

CASTING ALLOY DATA #700C

Alloy Name:	#700C Yellow
General Description:	18 K. Yellow alloy for casting.
Karating:	Pre Karating outside the machine is the preferred production procedure. Charge alloy, cover with gold and boric acid. Mechanically stir. Once metal reaches a temperature of 1066 C (1950 F), pour the shot.
Casting:	Melting should be done in an open atmosphere with flux. The casting temperature should be about 1070C for 18Kt.
Flask Temp:	Dependent on parts but a starting point would be 1100F (593C) for 3 dwt rings with detail, and 950F (510C) for heavy rings.
Quench Time:	20-25 minutes after casting.
Reusability:	A 60% fresh 40% recycle is acceptable, Regraining is not necessary.
Technical Questions:	Please feel free to call at any time if you have questions or comments.