

## **Tech specs: 902 Bronze**

<b>Alloy Name:</b>	<b>902 bronze</b>
<b>General Description:</b>	Fluid, bronze alloy for casting, harder than regular copper Casting, Gem-set is applicable.
<b>Color:</b>	Dark yellow.
<b>Melting point :</b>	945 °C
<b>Casting:</b>	Melting can be done in any atmosphere.
<b>Casting Temp:</b>	The casting temperature for heavy pieces should be <b>1000°C</b> and up to <b>1100°C</b> for lighter piece.
<b>Flask Temp:</b>	Depending on parts but a starting point would be <b>600°C</b> for heavy pieces to <b>700°C</b> for lighter pieces.
<b>Quench Time</b>	<b>15-20</b> minutes after casting.
<b>Pickling:</b>	ABI Investment Remover or equivalent should be used. Heating is not necessary and proper safety gloves and goggles should be worn.
<b>Reusability:</b>	A 70% fresh 30% recycle ratio is recommended, clean scraps thoroughly before reuse.
<b>technical questions:</b>	Please feel free to call at any time if you have questions or comments.