TECHNICAL SPECIFICATIONS

Heraeus

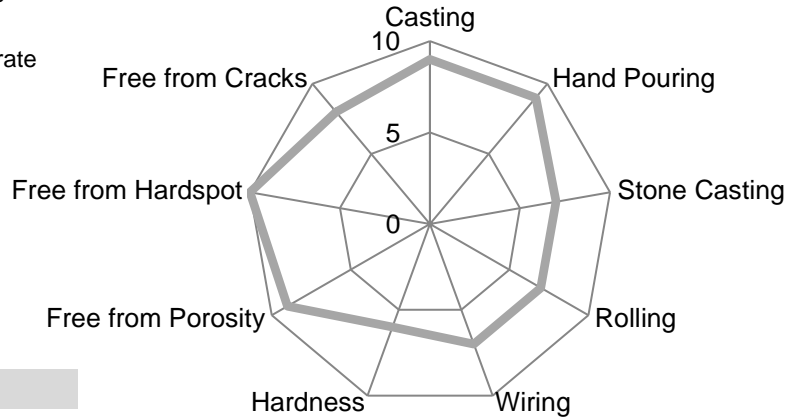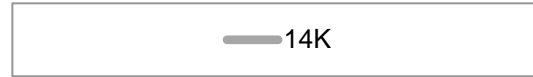| Alloy Code:	**H-752B**	Colour:	**Pink**

Suitable Karatage: 8/14K

Content : **Nickel:** 0.0%   **Palladium:** 0.0%
                Silver: 3.5%   **Platinum:** 0.0%

Applications: Suitable for loss wax casting, torch melting

Advantages: Shiny, not easily cracked, high re-casting rate

Melting Range (ºC):

8K	954 - 959
14K	885-887

Radar chart (14K): Casting, Hand Pouring, Stone Casting, Rolling, Wiring, Hardness, Free from Porosity, Free from Hardspot, Free from Cracks. Scale 0–10.

CIELAB Value :

Karat	YI:D1925	L*	a*	b*
8K	34.3	85.8	7.2	14.1
14K	32.9	83.4	7.3	12.9

Score(1--10)
1 means less likely to occur or not suitable
10 means most likely to occur or most suitable

Recommended Casting Parameters :   (Quenching Time: 5 - 10 Minutes)

Karat	Metal Casting Temperature (ºC)	Vacuum-assisted Casting Investment Temperature (ºC) Thickness of work piece (mm)		
		Thin (0.2~0.5)	Medium (0.5~1.1)	Thick (>1.1)
8K	1050-1070	660-700	560-640	480-560
14K	980-1000	660-700	560-640	440-560

Tensile Properties :

Karat	Annealed Hardness (HV)	As Casted Hardness (HV)	Max Strength (MPa)	Yield Strength (MPa)	Elongation (%)
8K	108	102	301	145	37
14K	120	120	303	180	36

Technical Advice:
1. To avoid oxidation, the alloys must be covered with inert gas or yellow flame during casting.
2. Not more than 50 % of old material should be used for recasting.
3. The old material must be tumbled to remove the investment powder residue and oxides.
   The material is then pickled in dilute sulfuric acid (15 %) for 15 - 20 minutes to remove the rest of oxides.
4. The sprue should be placed at the thickest position. Additional sprue must be applied if necessary.
   Fluted sprue is preferred to avoid any turbulence.

Remarks: The information is for your reference only. The parameters should be adjusted according to the particular casting conditions.
         If you have any technical questions, please do not hesitate to contact us.