

## BR88-12-S

### GENERAL INFORMATION

Carats: NONE - to be used without gold  
 Colour: yellow  
 colour coordinates: L\*=87.5 a\*=5.0 b\*=17.8  
 Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 8,83 g/cm<sup>3</sup>  
 Hardness (as cast): 138 HV  
 Hardness (after annealing): 130 HV  
 Not age-hardenable

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 970 °C

Casting temperature:  
 100 °C over its melting temperature to cast with centrifugal machines.  
 120 °C over its melting temperature to cast in vacuum machines with controlled atmosphere.  
 140 °C over its melting temperature to cast in outdoor cylinders with vacuum.

Cylinders temperature: from 550 °C to 650 °C depending on the machine and objects dimensions.

Cooling casted objects: in water after 10 minutes.  
 Cooling casted objects (with stones): in water after 30/40 minutes.

Annealing: 680 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

The above directions are only indicative. Strong variations to the above data are possible, depending on personal experience. Please, do not hesitate to contact us for further information.