

OTT.96/4J

GENERAL INFORMATION

Carats: NONE - to be used without gold
 Colour: deep yellow
 colour coordinates: L*=87.2 a*=4.6 b*=16.7
 Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 8,49 g/cm³
 Hardness (as cast): 125 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 1000 °C

Casting temperature:
 100 °C over its melting temperature to cast into ingot-mould and continuous casting.
 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.

Ingot-mould temperature: 150 °C
 Cylinders temperature: from 550 °C to 650 °C depending on the machine and objects dimensions.

Cooling of ingots: quick in lukewarm water (about 40 °C)
 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.