

ALLOY YELLOW GOLD 18 KT **M10X17**

#### RECOMMENDED APPLICATIONS

**CASTING:** OPEN SYSTEMS – CLOSED SYSTEMS - WITHOUT STONES .

#### CHARACTERIZATION DATA

**COLOR** YELLOW/PINK

**PERCENT SILVER** 10%

**DENSITY [g/cm<sup>3</sup>]** 12,74

**MELTING TEMPERATURES °C** 875

#### CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES [°C] 1010

CASTING TEMPERATURES[°C]	METAL [°C]	FLASK [°C]
THIN (BELOW 0,5MM)	1000-1010	660-700
MEDIUM (FROM 0,50 TO 1,2MM)	990 -1000	600-640
THICK (ABOVE 1,2MM)	970 - 980	500-600

**TREES WITHOUT STONES:** LET THE FLASK COOL FOR 10-15 MINUTES, THEN QUENCH IN WATER.

**PICKLING:** DIP IN RADIAL SOLUTION 50g/l, °C60 FOR 2 MINUTES, OR IN SULPHURIC ACID 10% CONC, AT °C 50 FOR 5 MINUTES.

**HARDENING TREATMENT:** 280 °C FOR 180 MINUTES, COOL VERY SLOWLY

#### TECHNICAL CHARACTERISTICS

**AS CAST HARDNESS** HV AC 140

**HARDNESS AFTER AGE-HARDENING** HV AH 220