



# PRW20

## TECHNICAL DATA SHEET

Fineness	750 ‰	Density	14.64
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### Physical Data

Colour	White	Colour Coordinates	L*= 86.47 a*= 2.74 b*= 11.87
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Melting Range	Solidus: 898 °C	Casting Temperature	Min: 1020°C
	Liquidus: 924 °C		Max: 1070°C

### Mechanical Data

Hardness	As Cast	Hardened
	194 HV	-

## INVESTMENT CASTING

### CASTING INSTRUCTIONS

Metaltech suggests to make a premelting of the master alloy and fine gold to homogenize the alloy in the best way, before casting. In any case, if a premelting is not done, put first the master alloy in the crucible, and then the fine gold on top, reach a temperature between 1020 and 1070°C (according with the mass and the shape of the casted pieces) then pour the metal in the flask. Also the flask temperature must be set considering the mass and the shape of the pieces which have to be casted. In any case, it must be stabilized at a temperature between 450 and 700°C. After casting, quench the flask after a time between 10 and 20', always according with the kind of pieces you are producing and, moreover, with the mass of the entire tree. So, trees with higher masses request longer quenching times. In case of castings with stones in place, increase the quenching time considering the stones resistance features.



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**Do - It Impex Pvt.Ltd.**

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## **CLEANING AND PICKLING**

Clean the tree from investment residuals with a water jet and, to completely remove them, put the tree in a 5 - 10% solution of hydrofluoric acid at 40 - 60°C. The use of an ultrasonic tank will increase the removal power of the acid. After cleaning, make a pickling using a 10 - 15% solution of sulfuric acid at 40 - 60°C. A oftenrenewal of the acid solution is suggested to keep its features stable.

## **SCRAPS REUSE**

The scraps of the obtained alloy can be reused in a percentage not higher than 50%. The quantity of scraps to reuse depends on the level of impurities contamination of them during the production cycles and on the grade of protection of the bath during casting (which reduces oxides creation and related alloy contamination). To increase the scraps reuse capability, is also very important to remove as meticulously as possible the investment residuals from sprues.

## **HEAT TREATMENTS**

### **SOLUTION ANNEALING**

It can be done to make the material release the possible tensions accumulated during the tree casting and cooling, and make it more resistant to bending or other processes which require high mechanical resistance. To make the solution annealing, put the pieces in oven with protected atmosphere (if available) at a temperature of 670°C for 15 - 20' and then quench immediately. We specify that this treatment is needed only in case of brittleness problems due to particular casting conditions.

### **FURTHER INFORMATION**

For any further information or request, please contact our local agent.



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