

TECHNICAL DATA SHEET

AP12

Alpacca for the production of white items, jewels and models obtained by investment casting. The elements contained in this product ensure a high deoxidation after casting and a high surface quality, making it suitable for castings with and without stones in place.

TAB.1 - Mechanical data

Hardness as cast	159	HV
Hardness hardened	n.d.	
Tensile strength	n.d.	
Yield strength	n.d.	
Elongation	n.d.	

TAB.2 - Physical data

Color	Standard white		
Colour Coordinates	L*:	85.2	
	a*:	-0.1	
	b*:	11.29	
Density	8.32	g/cm ³	
Melting Range	Solidus:	850	°C
	Liquidus:	950	°C

TAB.3 - Heat treatments

Solution annealing	800	°C
	30	min
Recrystallization Annealing	800	°C
	30	min
Hardening	n.d.	

TAB.4 - Investment casting parameters

Premelting temperature		1050	°C
Casting Temperature	Min: Max:	1000 1100	°C °C
Water investment powder ratio		36-38	%
Flask temperature	Min: Max:	450 700	°C °C
Quenching time without stones in place	Min: Max:	5 20	min min
Quenching time with stones in place		15	min in boiling water
Pickling	H2SO4: Temp: Time:	20 50 50	% °C min