

TECHNICAL DATA SHEET

SPARK575T

Alloy for the production of bronze 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	70	HV
Hardness hardened	n.d.	
Tensile strength	n.d.	
Yield strength	n.d.	
Elongation	n.d.	

TAB.2 - Physical data

Color	Deep yellow		
Colour Coordinates	L*:	85.04	
	a*:	1.73	
	b*:	20.09	
Density	8.45	g/cm ³	
Melting Range	Solidus:	965	°C
	Liquidus:	1008	°C

TAB.3 - Heat treatments

Solution annealing	700 30	°C min
Recrystallization Annealing	700 30	°C min
Hardening	n.d.	

TAB.4 - Investment casting parameters

Premelting temperature		1108	°C
Casting Temperature	Min: Max:	1058 1158	°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