

TECHNICAL DATA SHEET

SPARK584 - Au1kt

Brass for the production of 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	128 HV
Hardness hardened	148 HV
Tensile strength	n.d.
Yield strength	n.d.
Elongation	n.d.

TAB.2 - Physical data

Color	Pale yellow
Colour Coordinates	L*: 85.84 a*: 1.21 b*: 14.69
Density	8.91 g/cm ³
Melting Range	Solidus: 839 °C Liquidus: 942 °C

TAB.3 - Heat treatments

Solution annealing	660 °C - 30 min
Recrystallization Annealing	n.d.
Hardening	n.d.

TAB.4 - Investment casting parameters

Premelting temperature	1042 °C
Casting Temperature	Min: 992 °C Max: 1092 °C
Water investment powder ratio	36 - 38 %
Flask temperature	Min: 450 °C Max: 700 °C
Quenching time without stones in place	Min: 5 min Max: 20 min
Quenching time with stones in place	15 min inboiling water
Pickling	H2SO4: 20 % Temp: 50 °C - 5 min