

TECHNICAL DATA SHEET

SPARK585

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	198	HV
Hardness hardened	n.d.	
Tensile strength	n.d.	
Yield strength	n.d.	
Elongation	n.d.	

TAB.2 - Physical data

Color	yellow
Colour Coordinates	L*: 85.68 a*: 1.20 b*: 14.34
Density	8.58 g/cm ³
Melting Range	Solidus: 850 °C Liquidus: 960 °C

TAB.3 - Heat treatments

Solution annealing	638 30	°C min
Recrystallization Annealing	638 30	°C min
Hardening	n.d.	

TAB.4 - Investment casting parameters

Premelting temperature		1030	
Casting Temperature	Min:	1010	°C
	Max:	1110	°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 in boiling water
Pickling	H2SO4:	20	%
	Temp:	50	°C
	Time:	50	min