

TECHNICAL DATA SHEET

STAR606P + Pd52% - 750 ‰

Universal master alloy for the production of white palladium based 750 ‰ gold jewellery obtained by investment casting and mechanical working. The elements contained in this product ensure a high surface quality in investment casting, while in mechanical working a high deformation capability thanks the small grain structure, making it suitable for the production of hand and machine made hollow and solid chains, deep drawn items and tube. The use is suggested with the addition of 30 - 52 % of pure palladium to the master alloy.

TAB.1 - Mechanical data

Hardness as cast	101	HV
Hardness hardened	n.d.	
Tensile strength	355	MPa
Yield strength	170	MPa
Elongation	31	%

TAB.2 - Physical data

Color	Premium white		
Colour Coordinates	L*:	80.31	
	a*:	2.09	
	b*:	9.04	
Density	16.12	g/cm ³	
Melting Range	Solidus:	925	°C
	Liquidus:	1124	°C

TAB.3 - Heat treatments

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

TAB.4 - Investment casting parameters

Premelting temperature		1224	°C
Casting Temperature	Min:	1174	°C
	Max:	1274	°C
Water investment powder ratio		36-38	%
Flask temperature	Min:	600	°C
	Max:	720	°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

TAB.5 - Mechanical working parameters

Premelting temperature		1224	°C
Casting Temperature	Min:	1174	°C
	Max:	1274	°C
First thickness reduction	Lamination:	50	%
	Drawing:	25	%
Following thickness reductions	Lamination:	75	%
	Drawing:	50	%
Pickling after annealing	H2SO4:	20	%
	Temp:	50	°C
	Time:	5	min