

Master Alloy: R020 (10K, 14K & 18K) - Red

Product No./產品型號: R020 (10K, 14K & 18K) – 紅色

| 合金特性 Alloy Characteristics | 10K | 14K | 18K |
|---|-------|-------|-------|
| Density 密度 (g/cm ³) | 11.47 | 13.10 | 15.32 |
| Hardness 硬度 As Cast (Hv) 熔鑄後 | <100 | 112 | 109 |
| Hardness 硬度 Cold worked, Reduced 60% (Hv), 冷加工減少 60% (Hv) | 210 | 225 | >228 |

| 建議鑄造參數 Recommended Investment Casting Parameters | 10K | 14K | 18K |
|---|----------------|----------------|----------------|
| Casting Temperature Range (°C) 澆鑄溫度範圍 | 1046-1121 | 1041-1121 | 1024-1121 |
| Flask Temperature Range (°C) 燒粉溫度範圍 | 538-732 | 538-732 | 538-732 |
| Quench Time (min.) 淬火時間 | 10-15 | 10-15 | 10-15 |
| Re-alloying Scrap Percentage(%) 合金翻新比例 | 75% (new 新) | 75% (new 新) | 75% (new 新) |

建議首飾樹的清潔及風乾步驟 Recommended Cast Tree Cleaning and Drying Procedure

After a preliminary removal of the investment powder during quenching, submerge trees in a hot (80-100°C) 50% phosphoric acid solution for 15-20 minutes. Rinse well with cool water to remove any remaining investment powder and base metal oxides. Dry with compressed air.

Do not dry trees in any type of furnace!

首先清潔首飾樹上的粉末，然後把首飾樹浸泡於攝氏 80 至 100 度，50% 磷酸約 15-20 分鐘。之後再用清水徹底清潔，最後用壓縮空氣吹乾。

切勿把首飾樹放進任何爐具烘乾!

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