

Master Alloy: W100 (10K, 14K & 18K)

Product No./產品型號: W100 ; (with nickel, 含鎳)

合金特性 Alloy Characteristics	10K	14K	18K
Density 密度 (g/cm ³)	11.55	12.86	14.60
Hardness 硬度 – As Cast (Hv) 未加工 (Hv)	107	110	139
Hardness 硬度 – Cold worked, Reduced 60% (Hv), 冷加工減少 60% (Hv)	231	>230	>230

建議鑄造參數 Recommended Investment Casting Parameters	10K	14K	18K
Casting Temperature Range (°C) 澆鑄溫度範圍	1065-1095	1031-1093	990-1017
Flask Temperature Range (°C) 燒粉溫度範圍	593-732	593-732	593-732
Quench Time (min.) 淬火時間	10-15	10-15	10-15
Re-alloying Scrap Percentage(%) 合金翻新比例	<75%	<75%	<75%

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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