

# Master Alloy: W220A (10K, 14K & 18K)

Product No./產品型號: W220A ; (with nickel, 含鎳)

合金特性 Alloy Characteristics	10K	14K	18K
Density 密度 (g/cm <sup>3</sup> )	11.10	12.65	14.80
Hardness 硬度 – As Cast (Hv) 未加工 (Hv)	151	170	180
Hardness 硬度 – Cold worked, Reduced 60% (Hv), 冷加工減少 60% (Hv)	220	298	278

建議鑄造參數 Recommended Investment Casting Parameters	10K	14K	18K
Casting Temperature Range (°C) 澆鑄溫度範圍	1140-1175	1130-1170	1063-1085
Flask Temperature Range (°C) 燒粉溫度範圍	532-735	532-735	532-735
Quench Time (min.) 淬火時間	10-15	10-15	10-15
Re-alloying Scrap Percentage(%) 合金翻新比例	<50	<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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