

TECHNICAL DATASHEET AND GUIDELINE

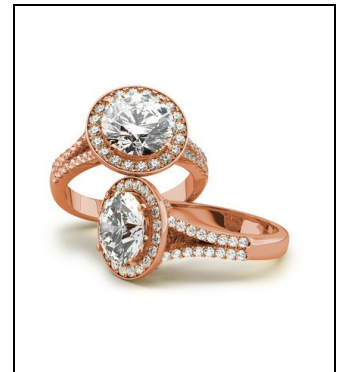
**C185N**  
Title 14 Kt

Master alloy for casting of 375-585-750‰ (9-14-18 Kt) red gold

GENERAL INFORMATION

Typology	Master alloy for gold
Production process	Casting
Color	Red
Color shade	Red
Density [g/cm <sup>3</sup> ]	12.8
Melting temperatures	
Solidus [°C]	900
Liquidus [°C]	935

Commercial composition	
Ag (%)	6
Cu (%)	91
Zn (%)	3



FULL CHARACTERIZATION DATA

Color coordinates	
L*	85
a*	9.4
b*	15.3
c*	N/A

Mechanical characteristics	
As cast hardness [HV 0.2]	124
Hardness after 70% area red. [HV 0.2]	246
Hardness after annealing [HV 0.2]	140

PRODUCT APPLICATIONS

Casting in open systems
Casting in closed systems
Casting without stones
Stone-in-place casting

RELATED PRODUCTS

OR134	All-purpose formulation, deeper red color
OR134C	Lower level of deoxidizers
LSR490	Medium solder for 750‰ red gold
LSR500	Medium solder for 585‰ red gold

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**CASTING PROCESSING PARAMETERS**

Casting temperatures	Metal - from [°C]	Metal - to [°C]	Flask - from [°C]	Flask - to [°C]
Thin (below 0.5 mm)	1035	1065	660	720
Medium (from 0.5 to 1.2 mm)	1015	1035	580	650
Thick (above 1.2 mm)	995	1015	460	600

**Stone-in-place casting trees**

Remove the flask immediately from the machine. Dip only the bottom part of the tree in cold water and keep under ventilation for 15 minutes. Quench in water.

**Trees without stones**

Remove the flask within 1 minute after pouring, then quench immediately in water.

**Pickling**

Dip in RADIAL solution (50 g/l conc. at 60°C for 2 min.), or in sulphuric acid (10% conc. at 50°C for 5 min.)