PRODUCT CODE	SY113
FINENESS	375 (9K)
COLOR	YELLOW



Brief descript	ion							
		gold 9, 10 and 1 3 is light yellow						
		en or closed syst	-				nis anoy gives	
Suitable appli	cations							
Plates&Sheets	Solid Chains	Hollow Chains	Soldered Tubes	CNC Works	Open Casting	Closed Casting	Wax Setting	
Proprieties								
Silver		10%			Amount of silver contained in the alloy			
Density		11.1			(g/cm <sup>3</sup> )			
Melting Rang	e	840-915			Solidus - Liquidus (°C)			
Hardness			100-/		Annealed - Ha	rdened (HV)		
Mould casting	8							
Put first the a	alloy in the cru	ucible and cove	r it with gold. H	leat the meta	l 50-100°C mor	e than Liquidu	s temperature,	
	-	g with a reduci	-					
		ig temperature	is reached, stir	the metal and	pour it in the i	mould; after cas	sting, open the	
mould and co	ol the metal in	nmediately.						
Continuous ca	asting							
-								
Mechanical w	vork							
-								
Annealing								
	-	e atmosphere at			ling on the qua	ntity), then qui	ckly cool it in a	
solution of 90	% water and 1	0% alcohol or in	warm water (≏	<sup>2</sup> 40°C).				
Hardening								
-								
Casting								
Flasks' tempe	rature should b	be between 500	-700°C, based o	n casted items	s' size and mode	els' intricacy. It i	s preferable to	
pre-melt the alloy with gold before casting. Casting temperature is 50-150°C higher than the liquidus temperature.								
After casting wait 15-20 min before cooling the metal in warm water ( $\simeq$ 40°C). In case of casting with stones, wait 30-					nes, wait 30-			
45 min.								
Pickling								
Sulfuric acid (	H <sub>2</sub> SO <sub>4</sub> ) at 15-30	0% concentratio	n and 50-60°C o	can be used to	remove surface	e oxide. Rinse w	ith attention	
the metal afte	er pickling.							
Scraps reuse								
Up to 50% scr	aps can be add	ded to the melti	ng, removal of s	prue button is	suggested. Alw	ays pay attentio	on to the	
cleanliness of the scraps, de-greasing and pickling before adding them to new metal is suggested.								

PRODUCT CODE	SY113
FINENESS	417 (10K)
COLOR	YELLOW



	Brief description								
Pre-Master alloy for yellow gold 9, 10 and 14K. The formulation of SY113 makes it suitable for casting applications. The									
colour obtained with SY113 is light yellow. The high amount of deoxidizing elements contained in this alloy gives									
shining casted objects in ope	en or closed syst	tems.							
Suitable applications           Plates&Sheets         Solid Chains				Open Casting	Closed Casting	Wax Satting			
	Hollow Chains	Soldered Tubes	CNC Works	Open Casting		Wax Setting			
Proprieties									
Silver	10%			Amount of silver contained in the alloy					
Density	11.3			(g/cm <sup>3</sup> )					
Melting Range		820-905		Solidus - Liquidus (°C)					
Hardness		100-/		Annealed - Ha	rdened (HV)				
Manufal an ether a	 								
Mould casting									
Put first the alloy in the cru		-							
while protecting the meltin	-	-		•					
200°C and, when the meltin		is reached, stir	the metal and	pour it in the r	nould; after cas	ting, open the			
mould and cool the metal in	imediately.								
Continuous casting	1								
	<u> </u>								
-									
Mechanical work									
-									
	 1								
Annealing					Annealing				
Heat the metal in protective atmosphere at 650°C for 10-30min (depending on the quantity), then quickly cool it in a									
Heat the metal in protective	e atmosphere a	t 650°C for 10-3	0min (depend	ling on the quai	ntity), then qui	ckly cool it in a			
solution of 90% water and 1	-			ling on the quai	ntity), then quid	ckly cool it in a			
solution of 90% water and 1	-			ling on the quai	ntity), then quio	ckly cool it in a			
	-			ling on the quai	ntity), then quid	ckly cool it in a			
solution of 90% water and 1	-			ling on the qua	ntity), then quid	ckly cool it in a			
solution of 90% water and 1	-			ling on the qua	ntity), then quio	ckly cool it in a			
solution of 90% water and 1 Hardening	-			ling on the quar	ntity), then quid	ckly cool it in a			
solution of 90% water and 1 Hardening - Casting	.0% alcohol or in	ı warm water (≃	240°C).						
solution of 90% water and 1 Hardening - Casting Flasks' temperature should	0% alcohol or in	ı warm water (≃ -700°C, based o	40°C).	' size and mode	ls' intricacy. It i	s preferable to			
solution of 90% water and 1 Hardening - Casting Flasks' temperature should I pre-melt the alloy with gold	0% alcohol or in	• warm water (≃ -700°C, based o Casting tempera	40°C).	5' size and mode	els' intricacy. It i the liquidus ten	s preferable to perature.			
solution of 90% water and 1 Hardening - Casting Flasks' temperature should I pre-melt the alloy with gold After casting wait 15-20 min	0% alcohol or in	• warm water (≃ -700°C, based o Casting tempera	40°C).	5' size and mode	els' intricacy. It i the liquidus ten	s preferable to perature.			
solution of 90% water and 1 Hardening - Casting Flasks' temperature should I pre-melt the alloy with gold	0% alcohol or in	• warm water (≃ -700°C, based o Casting tempera	40°C).	5' size and mode	els' intricacy. It i the liquidus ten	s preferable to perature.			
solution of 90% water and 1 Hardening - Casting Flasks' temperature should I pre-melt the alloy with gold After casting wait 15-20 min	0% alcohol or in	• warm water (≃ -700°C, based o Casting tempera	40°C).	5' size and mode	els' intricacy. It i the liquidus ten	s preferable to perature.			
solution of 90% water and 1 Hardening - Casting Flasks' temperature should I pre-melt the alloy with gold After casting wait 15-20 min 45 min. Pickling	0% alcohol or in be between 500 before casting. before cooling	i warm water (≃ -700°C, based o Casting tempera the metal in wa	40°C). on casted items ature is 50-150 rm water (≃40	s' size and mode I°C higher than I°C). In case of c	els' intricacy. It i the liquidus ten asting with stor	s preferable to pperature. nes, wait 30-			
solution of 90% water and 1 Hardening - Casting Flasks' temperature should I pre-melt the alloy with gold After casting wait 15-20 min 45 min. Pickling Sulfuric acid (H <sub>2</sub> SO <sub>4</sub> ) at 15-3	0% alcohol or in be between 500 before casting. before cooling	i warm water (≃ -700°C, based o Casting tempera the metal in wa	40°C). on casted items ature is 50-150 rm water (≃40	s' size and mode I°C higher than I°C). In case of c	els' intricacy. It i the liquidus ten asting with stor	s preferable to pperature. nes, wait 30-			
solution of 90% water and 1 Hardening - Casting Flasks' temperature should I pre-melt the alloy with gold After casting wait 15-20 min 45 min. Pickling	0% alcohol or in be between 500 before casting. before cooling	i warm water (≃ -700°C, based o Casting tempera the metal in wa	40°C). on casted items ature is 50-150 rm water (≃40	s' size and mode I°C higher than I°C). In case of c	els' intricacy. It i the liquidus ten asting with stor	s preferable to pperature. nes, wait 30-			
solution of 90% water and 1 Hardening - Casting Flasks' temperature should I pre-melt the alloy with gold After casting wait 15-20 min 45 min. Pickling Sulfuric acid (H <sub>2</sub> SO <sub>4</sub> ) at 15-3	0% alcohol or in be between 500 before casting. before cooling	i warm water (≃ -700°C, based o Casting tempera the metal in wa	40°C). on casted items ature is 50-150 rm water (≃40	s' size and mode I°C higher than I°C). In case of c	els' intricacy. It i the liquidus ten asting with stor	s preferable to pperature. nes, wait 30-			
solution of 90% water and 1 Hardening - Casting Flasks' temperature should I pre-melt the alloy with gold After casting wait 15-20 min 45 min. Pickling Sulfuric acid (H <sub>2</sub> SO <sub>4</sub> ) at 15-3 the metal after pickling.	0% alcohol or in be between 500 before casting. before cooling 0% concentratic	a warm water (≃ -700°C, based o Casting tempera the metal in wa	40°C). In casted items ature is 50-150 rm water (≃40 can be used to	s' size and mode 1°C higher than t 1°C). In case of c remove surface	els' intricacy. It i the liquidus ten asting with stor e oxide. Rinse w	s preferable to pperature. nes, wait 30- ith attention			

PRODUCT CODE	SY113
FINENESS	585 (14K)
COLOR	YELLOW



Brief descript	ion							
colour obtain	ed with SY113	gold 9, 10 and 14 3 is light yellow en or closed syst	. The high amo					
	actions.							
Suitable appli Plates&Sheets	Solid Chains	Hollow Chains	Soldered Tubes	CNC Works	Open Casting	Closed Casting	Wax Setting	
					-			
Proprieties								
Silver			10%		Amount of silver contained in the alloy			
Density		12.8			(g/cm <sup>3</sup> )			
Melting Rang	e	845-890			Solidus - Liquidus (°C)			
Hardness			120-/		Annealed - Ha	rdened (HV)		
Mould casting		ucible and cove						
while protect 200°C and, w	ing the meltin	g with a reducing temperature	ng flame or kee	eping it in pro	tective atmosp	here. Heat the	mould at 180-	
Continuous ca	asting							
-								
Mechanical w	vork							
-								
Annealing								
		e atmosphere at 0% alcohol or in		• •	ing on the qua	ntity), then qui	ckly cool it in a	
Hardening		l						
-								
Casting								
pre-melt the a	alloy with gold	be between 500 before casting. before cooling	Casting tempera	ature is 50-150	°C higher than	the liquidus ten	nperature.	
Pickling								
Sulfuric acid ( the metal afte	•	0% concentratio	n and 50-60°C (	can be used to	remove surface	e oxide. Rinse w	ith attention	
Scraps reuse								
-		ded to the meltin -greasing and pi	-				on to the	