

## TECHNICAL SPECIFICATION

### Master Alloy: H-889H (Pd & Ni free)

<b>Suitable karatage</b> : 8/10K	<b>Colour</b> : White
<b>Nickel Content</b> : 0%	<b>Silver Content</b> : 83.5%
<b>Palladium Content</b> : 0%	<b>Platinum Content</b> : 0%
<b>Hardness</b> : 86HV (10K)	
<b>Applications</b> : Suitable for loss wax casting, stone casting, hand-making	
<b>Advantages</b> : No Palladium & Nickel, low melting point, higher hardness	

#### Recommended Casting Parameters :

Metal Casting Temperature : 8K / 1020°C, 10K / 1025°C  
Investment Flask Temperature : 480°C - 590°C (Vacuum-assisted Casting)  
: 430°C - 530°C (Centrifugal Casting)  
Quenching Time : 15 - 25 minutes

#### Technical Advice :

1. To avoid oxidation, the alloys must be covered with inert gas or yellow flame during casting.
2. Not more than 50 % of old material should be used for recasting.
3. The old material must be pickled in dilute sulfuric acid (10 %) for 15 - 20 minutes to remove the oxide, followed by tumbling to remove the investment powder residue.
4. The sprue should be placed at the thickest position. Additional sprue must be applied if necessary. Fluted sprue is preferred to avoid any turbulence.

**Remarks:** *The information is for your reference only. The parameters should be adjusted according to the particular casting conditions. If you have any technical questions, please do not hesitate to contact us.*

**Main Office:**  
**Heraeus Ltd.**  
Heraeus Technology Centre  
30 On Chuen Street, On Lok Tsuen  
Fanling, N.T., Hong Kong  
Tel : (852) 2675 1200  
Fax: (852) 2682 3220

**總公司:**  
**賀利氏有限公司**  
香港新界粉嶺安樂村  
安全街 30 號  
賀利氏科技中心  
電話 : (852) 2675 1200  
傳真 : (852) 2682 3200

**Hunghom Sales Office:**  
**Heraeus Ltd.**  
Rm. 2111-3, Peninsula Square  
18 Sung On Street, Hunghom  
Kowloon, Hong Kong  
Tel : (852) 2159 5960  
Fax: (852) 2773 1090

**紅磡營業部:**  
**賀利氏有限公司**  
香港九龍紅磡  
崇安街 18 號  
半島廣場 2111-3 室  
電話 : (852) 2159 5960  
傳真 : (852) 2773 1090