

**GENERAL INFORMATION**
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Color	Yellow
Color shade	Light yellow
Production process	Casting
Typology	Brass

**Melting temperatures**

Liquidus [°C]	940.0
Solidus [°C]	835.0
Melting range [°C]	105.0

**Commercial composition**

Silicon (%)	3,00
Copper (%)	84,00
Zinc (%)	13,00



FASHION line

**FULL CHARACTERIZATION DATA**
**Color coordinates**

L*	85.7
a*	1.2
b*	14.3
c*	14.4

**Physical characteristics**

Density [g/cm <sup>3</sup> ]	8.5
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**General characteristics**

As cast grain size [μm]	1200.0
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**Product applications**

Casting in closed systems
Casting in open systems
Casting without stones

**Mechanical characteristics**

As cast hardness [HV 0.2]	130.0
Single step age-hardening hardness [HV 0.2]	150.0
Tensile strength (Rm) [Mpa]	404.0
Yield strength (Rp0.2) [MPa]	328.0
Elongation at rupture (A) [%]	16.0

**CASTING PROCESSING PARAMETERS**

CASTING TEMPERATURES	Flask from [°C]	Flask to [°C]	Metal from [°C]	Metal to [°C]
< 0.5 mm	660.0	720.0	1040.0	1070.0
0.5 - 1.2 mm	580.0	650.0	1020.0	1040.0
> 1.2 mm	460.0	600.0	1000.0	1020.0

**Trees without stones**

Let the flask cool down for 5 minutes, then quench in water.

**Stone-in-place casting trees**

Let the flask cool down for 30-45 minutes, then quench 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.)

**AGE HARDENING PROCESSING PARAMETERS**

SINGLE STEP AGE-HARDENING TREATMENT	Temperature [°C]	Time [min]	Quenching
Age-hardening	350.0	90.0	Air or in furnace