

99900067 - BRONZE EN GRENAILLES BR10S POUR LA FONTE

BR10S

Technical chart

BRONZE FOR CASTING

mod. 1 - rev. 022, 11/07/2005

Last revision

03/05/2012

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Colour **Pink**

[L: 85,8 a: 6,2 b: 17,8 c: 18,8]

Product description

BR10S is an antioxidant pink bronze for lost-wax casting of costume jewellery. It guarantees excellent mechanical resistance and low shrinkage porosity. No residues in the crucible.

Recommended applications

BR10S is indicated for all types of lost-wax casting. It is also suitable for productions where enamelling operations are required.

Physical-chemical properties

Precious metal of reference

Cu 100,0

Temperatures (°C)

Solidus	935
Liquidus	1000
Range	65

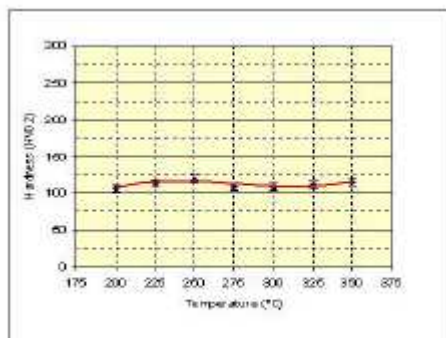
Density (g/cm³) 8,7

General characteristics

Fluidity (grid filling test) [%]	86
STSR (Sulfur tarnish sensitivity)	3

Mechanical characteristics

Tensile strength (Rm) [N/mm²]	455
Yield strength (Rp0.2) [N/mm²]	206
Elongation (A) [%]	45
"As cast" hardness [HV 0.2]	109
Hardness after 70% red. [HV 0.2]	278
Hardness after annealing [HV 0.2]	122
Hardness after age-hardening [HV 0.2]	119
L1	249
L2	6
L3	55



Age-hardening temperature profile (90 minutes)

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Instructions for use

Casting

Casting temperatures

Size of objects	Metal casting (°C)	Flask (°C)
thin from 0,2 to 0,5 mm.	1130-1100	660-720
medium from 0,5 to 1,2 mm	1100-1080	580-650
thick > 1,2 mm.	1080-1060	460-600

Flasks quenching

Leave flask to air cool for 5 minutes, then quench in water

Pickling

Dip items in RADIAL (50g/l) cleaning solution, 60°C for 2 minutes