



Aussiemet

AussieMaster



BM211

Technical Chart

BM211 is yellow metal designed for open casting system. Most suitable application as below:

- ◆ Can be used in stone in place casting
- ◆ Excellent Tarnish Resistance Properties
- ◆ High reusability
- ◆ Good hardness

Physical Characterization Data

| | |
|------------------------------|--------|
| COLOR | Yellow |
| DENSITY [G/CM ³] | 8.6 |
| MELTING TEMPERATURE | 980 °C |
| HARDNESS AS CAST | 78 HV |

Casting Parameter

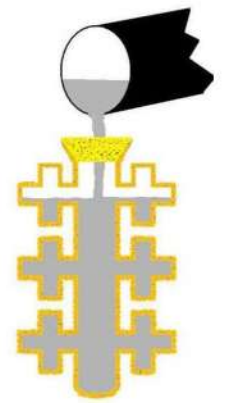
| | |
|---------------------------|-------------------|
| CASTING TEMPERATURE RANGE | 1030 °C – 1050 °C |
| FLASK TEMPERATURE RANGE | 600 °C – 650 °C |

Trees Without Stones:- Let the flask cool for 15-18 minutes then quench in water.

Trees With Stones:- Let the flask cool for 40-45 minutes then quench in water.

Investment Casting Instructions

The actual casting temperatures and flask temperatures shall be decided by the parameters like the section thickness of the items (thick, medium or thin), the overall size/bulk of the cast tree, the design intricacies etc. As a thumb rule, for thinner sections higher temperatures are selected and for thicker sections lower temperatures are preferred. At the same time, designs demanding higher form filling capabilities, higher than normal temperatures are an obvious choice.



Cleaning, Pickling and Cooling Instructions

After primary removal of the investment during quenching, submerge tree in a hot (80-100 °C) 50% phosphoric acid solution for 15-20 minutes. Rinse well with cool water to remove remaining investment powder and base metal oxides.



Reusing Scrap Instructions

Before reuse of scraps clean the scrap in best possible manner with the ultrasonic and magnetic polishing machine and remove all the dirt, oil, and greases from the metals. The scrap use percentage is not more than 50%.



Notes:-

The above directions are only indicative. Strong variations to the above data are possible, depending on personal experience. Please, do not hesitate to contact us for further information.



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Website: www.aussiemet.com.au,

Email: info@aussiemet.com.au, sales@aussiemet.com.au,

89 SOMERSBY CIRCUIT, ACACIA GARDENS, NSW 2763, AUSTRALIA