

## YM530

## Technical Chart 9KT

YM530 is mechanical working master alloy for 9-14kt yellow gold. Most suitable applications as below:

- ◆ Can be used in continuous casting
- ◆ Can be used in Wire Production
- ◆ Can be used in Sheet Production
- ◆ Can be used in CNC and Lathe Production
- ◆ Suitable for mechanical working application like stamped items, solid and hollow chains, earrings, bracelets and tube rings

### Physical Characterization Data

COLOR	Natural Yellow
DENSITY [G/CM <sup>3</sup> ]	11.12
MELTING TEMPERATURE	915 °C
HARDNESS AS CAST	110 HV
HARDNESS (AFTER COLD WORK 70%)	220 HV
HARDNESS (AFTER ANNEALING)	109 HV
HARDNESS (AFTER AGE HARDNING)	185 HV

### Mechanical Working Parameters

PRE-MIXING TEMPERATURE [°C]	980-1030
PICKLING	Sulphuric Acid (%10)

Casting Temperature	Metal - from [°C]	Metal - to [°C]
INGOT MAKING	980	1030
CONTINUOUS CASTING	1000	1080

### Recommended Reductions

SHEET - AREA OR THICKNESS [%]	70
WIRE - DIAMETER [%]	45

Mechanical working recommended annealing	Temperature [°C]	Time [min]
> 5 mm	630 - 670	40
1 - 5 mm	630 - 670	30
< 1 mm	630 - 670	20

### 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%.



### Hardening Treatment

275°C for 100 minutes cool very slowly possibly inside the furnace with a protection of hydrogen. To obtain further hardening increase the time in the furnace.

#### 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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