

BRASS

RECOMMENDED APPLICATIONS

WORKING: UNIVERSAL - CASTING

CHARACTERIZATION DATA

COLOR LIGHT YELLOW

PERCENT COPPER 67% - ZINC 33%

DENSITY [g/cm³] 8,4

MELTING TEMPERATURES °C 940

CASTING PROCESSING PARAMETERS

MELTING TEMPERATURES °C 1040

CASTING TEMPERATURES [°C]	METAL [°C]	FLASK [°C]
THIN (BELOW. 0,5MM)	1020-1040	620-700
MEDIUM (FROM 0,50 TO 1,2MM)	1010-1020	580-650
THICK (ABOVE 1,2MM)	1000-990	540-620

TREES WITHOUT STONES: LET THE FLASK COOL FOR 10-15 MINUTES, THEN QUENCH IN WATER.

PICKLING: DIP IN RADIAL SOLUTION 50g/l, 60°C FOR 5-10 MINUTES, OR IN SULPHURIC ACID

10% CONC, AT °C 50 FOR 10 MINUTES.



MECHANICAL WORKING PARAMETERS

MELTING TEMPERATURE[°C] 1020

CASTING TEMPERATURE [°C]	ANNEALING TEMPERATURE[°C]	TIME MINUTES ANNEALING
INGOT MAKING [°C] 1020-1060	> 5 MM 650	30
CONTINUOUS CASTING [°C] 1040-1110	< 5 MM 650	30
	< 1 MM 650	25

TECHNICAL CHARACTERISTICS

AS CAST HARDNESS HV AC 64

HARDNESS AFTER AGE-HARDENING HV AH ----