

Copper Drops

GENERAL INFORMATION

Colour:	rich red
Advised use:	universal (both mechanical works and casting)
Density:	18,45 g/cm ³

DIRECTIONS FOR SUGGESTED USE

Melting temperature in 22 kt: 940 °C

Casting temperature:

100 °C over its melting temperature to cast into ingot-mould and continuous casting.

100 °C over its melting temperature to cast with centrifugal machines.

120 °C over its melting temperature to cast in vacuum machines with controlled atmosphere.

140 °C over its melting temperature to cast in outdoor cylinders with vacuum.

Ingot-mould temperature: 150 °C

Cylinders temperature: from 600 °C to 700 °C depending on the machine and objects dimensions.

Cooling of ingots: quick in lukewarm water (about 40 °C)

Cooling casted objects: in water after 10 minutes.

Cooling casted objects (with stones): in water after 30/40 minutes.

Annealing: 670 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

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.