



	18 KT alloys (ca. 15,3g/cm ³)	14 KT alloys (ca.13g/cm ³)	Silver alloys (ca. 10,5g/cm ³)
30mm sheet	110 Gramm	90 Gramm	75 Gramm
20mm sheet	80 Gramm	65 Gramm	55 Gramm
10mm sheet	40 Gramm	34 Gramm	28 Gramm
8mm round wire	42 Gramm	36 Gramm	29 Gramm
6mm round wire	23 Gramm	19 Gramm	15 Gramm

We recommend casting with additional material - at least 10 grams for gold alloys and 5 grams for silver alloys. Any impurities usually float on the melt and do not get into the required piece of sheet metal/wire during casting, but settle on the excess part of the material ("casting king/casting head"), also it compensate shrinkage and avoid cavitation. Coat the cylinder halves with silicone spray or bor-nidrid-spray to prevent sticking!