

TECHNICAL DATASHEET AND GUIDELINE

OTT67/33M
Title

Brass for casting

GENERAL INFORMATION

Typology	Brass
Production process	Casting
Color	Yellow
Color shade	Light yellow
Density (g/cm ³)	8.4
Melting temperatures	
Solidus (°C)	825
Liquidus (°C)	900

Commercial composition	
Cu (%)	67
Zn (%)	33



FULL CHARACTERIZATION DATA

General characteristics	
Fluidity (grid filling test) [%]	83
Color coordinates	
L*	87
a*	-0.2
b*	21.6
c*	21.6

Mechanical characteristics	
Tensile strength (Rm) [MPa]	277
Yield strength (Rp0.2) [MPa]	70
Elongation at rupture (A) [%]	41
As cast hardness [HV 0.2]	78
Hardness after 70% area red. [HV 0.2]	241
Hardness after annealing [HV 0.2]	83
Single step age-hardening hardness [HV 0.2]	93

PRODUCT APPLICATIONS

Casting in open systems
Casting in closed systems
Casting without stones

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Casting temperatures	Metal - from (°C)	Metal - to (°C)	Flask - from (°C)	Flask - to (°C)
Thin (below 0.5 mm)	1000	1030	660	720
Medium (from 0.5 to 1.2 mm)	980	1000	580	650
Thick (above 1.2 mm)	960	980	460	600

Trees without stones

Let the flask cool down for 5 minutes, then quench in water.

Stone-in-place casting trees

Let the flask cool down for 30-45 minutes, then quench in water.

Pickling

Use water jet or sand blasting; see notes for further details