



### UNITED # 200 SERIES

Thank you for using UNITED'S alloys.

UNITED 200 SERIES ALLOYS may be used for 10K & 14K casting with the exceptions # 200 & # 240 for 14K only.

You should obtain excellent results by following a few simple instructions.

<b>MELTING</b>	Melt Temperature for 14K Alloyed Grain	950° - 970° C. 1745° - 1780° F.
	Melt Temperature for 10K Alloyed Grain	970° - 990° C. 1780° - 1815° F.
	Melt Temperature for Alloying	1010° - 1040° C. 1850° - 1910° F.
	We do recommend pre-graining all alloy and fine gold before casting to assure a uniform mixture.	
<b>FLASK TEMPERATURE</b>	Normal recommended temperature.	
<b>FLUXING</b>	Boric Acid is the recommended flux. Use as little flux as possible. Do not use carbon fluxes or any fluxes designed for refining; i.e., soda ash, saltpeter, etc. Avoid flux in bottom pour automatic casting units.	
<b>QUENCH TIME</b>	15 – 20 minutes.	
<b>INVESTMENT REMOVAL</b>	Most standard investment removers will successfully remove the investment powder. Fluoric-based investment removers are the best for removing the silicon oxide invisible coating. UNITED'S Brite-Cast Investment Remover also works very well.	
<b>RE MELTING</b>	We recommend a 35% - 50% fresh mix for remelting, unless our # 99 Alloy Replenisher is used.	
<b>NOTES</b>	Melt temperature may vary with type of unit. These alloys are designed for casting only.	
<b>TECHNICAL ASSISTANCE</b>	Always available... Call 1-800-999-3463 / 1-800-999-FINE. E-mail / <a href="mailto:doc@unitedpmr.com">doc@unitedpmr.com</a> Web-Site / <a href="http://www.unitedpmr.com/">www.unitedpmr.com/</a>	

2781 Townline Road, Alden, NY 14004

Phone: 1 (800) 999-FINE (3463) Intl. Phone: + 1 (716) 683-8334

Fax: 1 (800) 533-6657 Intl. Fax: +1 (716) 683-5433

E mail: [sales@unitedpmr.com](mailto:sales@unitedpmr.com) Website: [www.unitedpmr.com](http://www.unitedpmr.com)