



UNITED ALLOY # 330

Thank you for using UNITED'S alloys.

UNITED'S 330 Casting Brass is a bright yellow brass designed to cast jewelry samples, models, belt buckles, art objects, etc. It finishes to a bright 14K color and easily solders with silver or low gold formulas.

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

MELTING	Melt Temperature for casting	1050° C - 1922° F.
FLASK TEMPERATURE	We suggest a higher flask temperature for light and medium weight pieces. 1200° - 1300° F.	
FLUXING	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.	
QUENCH TIME	15 – 20 minutes.	
INVESTMENT REMOVAL	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.	
NOTES	Melt temperature may vary with type of unit. This alloy is designed for casting only. # 330 Brass should not be used for gold casting! # 330 Brass should not be cyanide gold plated, use acid gold plating unless nickel subplate is used. For # 330 Brass, we recommend an ultrasonic cleaning solution called BCR available from OKITE, phone # 1-800-526-4473 ext. 2411.	
TECHNICAL ASSISTANCE	Always available... Call 1-800-999-3463 / 1-800-999-FINE. E-mail / doc@unitedpmr.com Web-Site / http://www.unitedpmr.com/	

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