



### UNITED ALLOY # 340

Thank you for using UNITED'S alloys.

UNITED'S 340 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.

<b>MELTING</b>	Melt Temperature for casting	1050° C - 1922° F.
<b>FLASK TEMPERATURE</b>	We suggest a higher flask temperature for light and medium weight pieces. 1200° - 1300° F.	
<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>NOTES</b>	Melt temperature may vary with type of unit. This alloy is designed for casting only. # 340 Brass should not be used for gold casting! # 340 Brass should not be cyanide gold plated, use acid gold plating unless nickel subplate is used. For # 340 Brass, we recommend an ultrasonic cleaning solution called BCR available from OKITE, phone # 1-800-526-4473 ext. 2411.	
<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/">http://www.unitedpmr.com/</a>	

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