



UNITED ALLOY # 342

Thank you for using UNITED'S alloys.

UNITED'S 342 Casting Bronze is a bright yellow bronze 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. # 342 has a much better resistance to tarnish than brass alloys, as well as a harder surface. # 342 also contains a silicon de-oxidizer for clean casting. Using 5 % by weight of # 99 replenisher with this alloy greatly improves the castability and tarnish resistance of this alloy.

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 high 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. # 342 Bronze should not be used for gold casting! # 342 Bronze should not be cyanide gold plated, use acid gold plating unless nickel subplate is used. For # 342 Bronze, 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.
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