



UNITED ALLOY # 396

Thank you for using UNITED'S alloys.

UNITED'S 396 ALLOY is designed for 18K – 22K yellow gold casting, which produces a pink color in 18K, and a reddish yellow color in 20K – 22K.

MELTING

Melt Temperature for 18K Alloyed Grain	1010° - 1020° C. 1850° - 1868° F.
Melt Temperature for 20K-22K Alloyed Grain	1090° - 1120° C. 1994° - 2048° F.
Melt Temperature for Alloying 18K	1060° - 1070° C. 1940° - 1958° F.
Melt Temperature for Alloying 20K-22K	1080° - 1100° C. 1976° - 2012° F.

We do recommend pre-graining all alloy and fine gold before casting to assure a uniform mixture.

FLASK TEMPERATURE

For 18K, use normal recommended temperature.	
For 20K-22K Vacuum casting	676° - 730° C. 1250° - 1350° F.
For 20K-22K Centrifugal casting	537° - 565° C. 1000° - 1050° 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

For 20K-22K 15-20 minutes. For 18K quench 3-5 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. Our Brite-Cast Investment Remover also works very well.

REMELTING

We recommend 50% rejuvenation for remelting.

NOTES

Melt temperature may vary with type of unit. This alloy is designed for casting only.

TECHNICAL ASSISTANCE

Always available...
Call 1-800-999-3463 / 1-800-999-FINE.
E-mail / doc@unitedpmr.com
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