



### UNITED ALLOY # 400 SERIES

Thank you for using UNITED'S alloys.

UNITED 400 SERIES ALLOYS may be used for 10K & 14K casting with the exceptions # 450 for 14K only.

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

<b>MELTING</b>	Melt Temperature for 14K Alloyed Grain	970° - 990° C. 1780° - 1815° F.
	Melt Temperature for 10K Alloyed Grain	990° - 1020° C. 1815° - 1870° F.
	Melt Temperature for Alloying	1030° - 1065° C. 1900° - 1950° F.

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

**FLASK TEMPERATURE** Increase normal temperature 50° 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.

**REMELTING** We recommend a 50% fresh mix for remelting, unless our # 99 Alloy Replenisher is used.

**NOTES** Melt temperature may vary with type of unit. These alloys are designed for casting only.

**TECHNICAL ASSISTANCE** Always available...  
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