



UNITED ALLOY # 520

Thank you for using UNITED'S alloys.

UNITED'S 520 ALLOY may be used for 10K - 18K casting, which produces a Russian red, or reddish yellow finished color.

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

MELTING

Melt Temperature for 10 & 14K Alloyed Grain 970° - 980° C.
1778° - 1796° F.
Melt Temperature for 18K Alloyed Grain 1000° - 1010° C.
1832° - 1850° F.
Melt Temperature for Alloying 1040° - 1050° C.
1904° - 1922° F.

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

FLASK TEMPERATURE

Normal recommended temperature. Use slightly higher for 18K.

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 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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