



UNITED ALLOY # 540

Thank you for using UNITED'S alloys.

UNITED'S 540 ALLOY may be used for 10K & 14K casting, which produces a pink / red finished color.

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

MELTING

Melt Temperature for 10 & 14K Alloyed Grain 990° - 1010° C.
1814° - 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

We recommended a slightly higher temperature.

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 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% 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
Web-Site / <http://www.unitedpmr.com/>

2781 Townline Road, Alden, NY 14004
Phone: 1 (800) 999-FINE (3463) Intl. Phone: + 1 (716) 683-8334
Fax: 1 (800) 533-6657 Intl. Fax: +1 (716) 683-5433
E mail: sales@unitedpmr.com Website: www.unitedpmr.com