



UNITED ALLOY # 555

Thank you for using UNITED'S alloys.

UNITED'S 555 ALLOY has a very small amount of Iron and may be used for 10K - 18K 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 18K Alloyed Grain 1010° C / 1850° F.

Melt Temperature for Alloying 1050° - 1060° C.
1922° - 1940° 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

For 10K & 14K quench 15 minutes. For 18K quench A.S.A.P.
For hand-made (rolling), quench ingot immediately.

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.

TECHNICAL ASSISTANCE

Always available...
Call 1-800-999-3463 / 1-800-999-FINE.
E-mail / doc@unitedpmr.com
Web-Site / <http://www.unitedpmr.com/>

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