



UNITED ALLOY # 600 SERIES

Thank you for using UNITED'S alloys.

UNITED 400 SERIES ALLOYS may be used for 10K & 14K yellow gold casting, which produces a rich yellow finished color.

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

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| MELTING | Melt Temperature for 14K Alloyed Grain | 970° - 980° C. 1778° - 1796° F. |
| | Melt Temperature for 10K Alloyed Grain | 980° - 990° C. 1796° - 1815° F. |
| | Melt Temperature for Alloying | 1030° - 1050° C. 1886° - 1922° F. |

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

FLASK TEMPERATURE Normal recommended 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 – 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 25% - 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.
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