



### UNITED ALLOY # 713

Thank you for using UNITED'S alloys.

UNITED'S 713 ALLOY is designed for 18K yellow gold casting, which produces a light, greenish yellow color.

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

#### **MELTING**

Melt Temperature for 18K Alloyed Grain      1016° - 1027° C.  
1860° - 1880° F.

Melt Temperature for Alloying                      1050° - 1070° C.  
1922° - 1958° F.

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

#### **FLASK TEMPERATURE**

We recommend a slightly higher flask temperature 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](mailto:doc@unitedpmr.com)  
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