



UNITED ALLOY # 780

Thank you for using UNITED'S alloys.

UNITED'S 780 ALLOY is designed for 18K yellow gold casting, which produces a light yellow color.

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

MELTING	Melt Temperature for 18K Alloyed Grain	1010° - 1020° C. 1850° - 1868° 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 Web-Site / http://www.unitedpmr.com/	

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