UNITED PRECIOUS METAL REFINING, INC.

UNITED ALLOY # 790

Thank you for using UNITED'S alloys.

UNITED'S 790 ALLOY is designed for 18K yellow gold casting, which produces a deep yellow color.

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

MELTING

Melt Temperature for 18K Alloyed Grain 1000° C / 1832° 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 / 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