



UNITED ALLOY # 909

Thank you for using UNITED'S alloys.

UNITED'S 909 ALLOY may be used for 14 or 18K white gold castings and will produce a white finished color. #909 contains a boron deoxidizer.

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

MELTING	Melt Temperature for 14-18K Alloyed Grain	1040°-1050° C. 1904°-1922° F.
	Melt Temperature for Alloying	1090°-1100° C. 1994°-2012° F.
	We do recommend pre-graining all alloy and fine gold before casting to assure a uniform mixture.	
FLASK TEMPERATURE	We suggest a slightly higher flask temperature for white gold.	
FLUXING	Fluxing white gold is extremely important to pick-up oxides. Boric Acid is the recommended flux. 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	10 – 15 minutes.	
INVESTMENT REMOVAL	Most standard investment removers will successfully remove the investment powder. UNITED'S Brite-Cast Investment Remover also works very well.	
RE MELTING	We recommend a 70% fresh - 30% scrap mix. White gold alloy has about 1/3 the reusability of yellow gold alloys.	
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	

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