



UNITED ALLOY # 920

Thank you for using UNITED'S alloys.

UNITED'S 920 ALLOY may be used for 10K & 14K white gold casting, which produces a white finished color. #920 is a high fluidity alloy that contains a silicon deoxidizer.

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

MELTING	Melt Temperature for 10K Alloyed Grain	1030° - 1040° C. 1886° - 1904° F.
	Melt Temperature for 14K Alloyed Grain	1000° - 1010° C. 1832° - 1850° F.
	Melt Temperature for Alloying	1050° - 1060° C. 1922° - 1940° 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 – 12 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 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

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