



### UNITED ALLOY # 924

Thank you for using UNITED'S alloys.

UNITED'S 924 ALLOY is a high Nickel alloy and may only be used for 18K white gold casting. This alloy will produce an extremely white, Premium Grade-1 color of jewelry in 18 Karat. Alloy #924 contains small amounts of silicon as de-oxidizer.

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

**MELTING**

Melt Temperature for 18K Alloyed Grain	1040°-1060° C. 1904°-1940° F.
Melt Temperature for Alloying	1090°-1100° C. 1994°-2012° F.

We highly 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 usually in the range of 1200 F to 1300 F for regular non stone-in-place castings.

**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 or as soon as the red glow disappears from the button.

**INVESTMENT REMOVAL**

Most standard investment removers will successfully remove the investment powder. 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](mailto:doc@unitedpmr.com)  
Web-Site / [www.unitedpmr.com/](http://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](mailto:sales@unitedpmr.com) Website: [www.unitedpmr.com](http://www.unitedpmr.com)