



UNITED ALLOY # 952

Thank you for using UNITED'S alloys.

UNITED'S 952 ALLOY may be used for 10K & 14K white gold casting, which produces a white finished color. #952 contains silicon, and boron deoxidizers. This alloy has been proven to perform very well for Stone-In-Place castings.

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

MELTING

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| Melt Temperature for 10K Alloyed Grain | 1010° - 1020° C. 1850° - 1868° 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 in the range of 1050°F to 1250°F depending on the size of flask and type of jewelry styles.

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

15 to 20 minutes after pouring.

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 50% fresh - 50% scrap mix.

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
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