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## UNITED “STANDARD YELLOW” ALLOY # NA-84

Thank you for using UNITED’S alloys.

UNITED Alloy # **NA-84** is a **Standard Yellow** alloy that may be used for **9 K – 14 K casting**.

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

### MELTING

We do recommend pre-alloying all alloy and fine gold with aggressive stirring & fluxing to assure a uniform mixture.

<b>Step : 1</b>	Pre- Alloying (Fine gold + alloy) Temperature	<b>1010° - 1040° C</b> <b>1850° - 1910° F</b>
<b>Step : 2</b>	Casting Temperature for 9 K – 10 K Alloyed Grain	<b>970° - 990° C</b> <b>1780° - 1815° F</b>
	Casting Temperature for 14 K Alloyed Grain	<b>950° - 970° C</b> <b>1745° - 1780° F</b>

**NOTE: Melt temperature may vary with type of unit. This alloy is designed for casting only.**

### FLASK TEMPERATURE

Normal recommended temperature in the range of **580° C to 700° C / 1076° F – 1292° F** depending on size of flask, karat & type of jewelry.

### FLUXING

Avoid flux in bottom pour automatic casting units.

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.

### QUENCH TIME

**20 – 25 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. Use of aggressive acids causes stress corrosion and surface damage and is therefore not recommended.

**UNITED’S Brite-Cast™ Investment Remover works effectively in removing fire scale as well as preventing stress corrosion or surface damage of the cast piece.**

### REMELTING

We recommend a 35% - 50% fresh mix for re-melting, unless our # **99** Alloy Replenisher is used.

### NOTES

Melt temperature may vary with type of unit. These alloys are 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)

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