

## UNITED # 200 SERIES

Thank you for using UNITED'S alloys.

UNITED # 200 SERIES ALLOYS may be used for **9 K – 14 K casting** with the **exceptions # 200 & # 240 for 14 K only.**

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

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. Avoid flux in bottom pour automatic casting units.

### QUENCH TIME

**15 – 20 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.

### 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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