

**UNITED “GREENISH-YELLOW  
(EUROPEAN 3N COLOR)”ALLOY # 263**

Thank you for using UNITED’s alloys.

UNITED # 263 alloy may be used for **14 K regular and stone-in-place castings**. This alloy provides a **Greenish-Yellow color (European 3N color)** casting and has **high re-usability and fluidity**.

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 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**

**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.

**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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