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## UNITED “GREENISH-YELLOW” ALLOY # 263 S

UNITED # 263 S ALLOY is a “spring-hard” version of our regular # 263 alloy. This alloy may be used for **14 K regular and stone-in-place castings**. This alloy provides a **Greenish-Yellow color** casting and will provide **improved hardness and spring action on the castings**.

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.

- Step : 1** Pre- Alloying (Fine gold + alloy) Temperature **1010° - 1040° C**  
**1850° - 1910° F**
- Step : 2** Casting Temperature for 14 K Alloyed Grain **950° - 970° C**  
**1745° - 1780° F**

**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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