
UNITED “REDDISH YELLOW BRASS” ALLOY # 335

Thank you for using UNITED’S alloys.

UNITED’S # 335 Casting Brass is a Reddish Yellow brass designed to cast jewelry samples, models, belt buckles, art objects, etc. It finishes to a bright 14 K color and easily solders with silver or low gold formulas.

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

MELTING

Casting Temperature **1050° C - 1922° F**

NOTES: Melt temperature may vary with type of unit. This alloy is designed for casting only. # 335 Brass should not be used for gold casting! # 335 Brass should not be cyanide gold plated, use acid gold plating unless nickel subplate is used. For # 335 Brass, we recommend an ultrasonic cleaning solution called BCR available from OKITE, phone # 1-800-526-4473 ext. 2411.

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.

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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.

**TECHNICAL
ASSISTANCE**

Always available... Call 1-800-999-3463 / 1-800-999-FINE
E-mail / doc@unitedpmr.com Web-Site / www.unitedpmr.com

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