

## UNITED HARD BRASS ALLOY # 340

Thank you for using UNITED'S alloys.

UNITED'S # 340 Casting Hard Brass is a **Standard 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. # 340 Brass should not be used for gold casting! # 340 Brass should not be cyanide gold plated, use acid gold plating unless nickel subplate is used. For # 340 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.

### 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](mailto:doc@unitedpmr.com) Web-Site / [www.unitedpmr.com](http://www.unitedpmr.com)

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