

UNITED “VANILLA WHITE” ALLOY # 380

Thank you for using UNITED’S alloys.

UNITED’S # 380 ALLOY is a **18 K – 22 K** Nickel & Palladium based white gold all purpose alloy which produces a **Vanilla White color**.

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	1130° - 1140° C 2066° - 2084° F
Step : 2	Casting Temperature for Alloyed Grain	1080° - 1100° C 1976° - 2012° F

FLASK TEMPERATURE

Platinum Investment highly recommended for this alloy.

For Vacuum casting **676° - 730° C**
1250° - 1350° F

For Centrifugal casting **537° - 565° C**
1000° - 1050° F

NOTE: Melt temperature may vary with type of unit.

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 50% rejuvenation for re-melting.

TECHNICAL ASSISTANCE

Always available... Call 1-800-999-3463 / 1-800-999-FINE
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