
UNITED “DARK YELLOW” ALLOY # 384

Thank you for using UNITED’S alloys.

UNITED’S # 384 ALLOY is designed for **20 K – 22 K** dark yellow gold **casting & fabrication**, which produces a **Dark Yellow 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 **1100° - 1130° C**
2012° - 2066° F

Step : 2 Casting Temperature for Alloyed Grain **1080° - 1100° C**
1976° - 2012° F

FLASK TEMPERATURE

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. This alloy is designed for Casting and Fabrication (Rolling , Wire, Tube, Sheet).

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.

HARDENING

90 MINUTES AT A TEMPERATURE OF 300 C.

**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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