

UNITED “LIGHT YELLOW” ALLOY # 386

Thank you for using UNITED’S alloys.

UNITED’S # 386 ALLOY is designed for **20 K – 22 K** light yellow gold **casting & fabrication**, which produces a **Light 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.

**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
E-mail / doc@unitedpmr.com Web-Site / www.unitedpmr.com

2781 Townline Road, Alden, NY 14004, USA.

Phone : (800) 999-3463; International Phone : +1-(716)-683-8334

Fax : (800) 533-6657; International Fax : +1-(716)-683-5433

E mail: sales@unitedpmr.com; Website: www.unitedpmr.com