
UNITED “PINK” ALLOY # 534

Thank you for using UNITED’S alloys.

UNITED’S # 534 ALLOY may be used for **9K - 18K casting, or hand-made (rolling)**, which produces a **Pink finished color**.

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

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 **1050° - 1060° C**
1922° - 1940° F

Step : 2 Casting Temperature for 9 K – 14 K Alloyed Grain **990° - 1010° C**
1814° - 1850° F

Casting Temperature for 18 K Alloyed Grain **1010° C / 1850° F**

NOTE: Melt temperature may vary with type of unit. This alloy is designed for casting and hand-made (rolling).

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

For 9 K – 14 K quench **15 minutes**.

For 18K quench the button (only) within 2 - 3 minutes after casting. Then proceed to quench the whole flask.

For hand-made (rolling), quench ingot immediately.

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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