

## UNITED “CHAMPAGNE PINK” 10K & 18K # 535 CASTING GRAIN

UNITED'S # 535 comes are a pre-mixed **READY-TO-CAST** Grain for **10 K to 18 K casting**, which produces a **Champagne- Pink finished color**. This grain is formulated with Palladium and hence, the casted tree will be fire-scale resistant. Finished pieces will have a grayish pink color with a purple hue.

### MELTING

We do recommend aggressive stirring & fluxing while melting this casting grain.

Casting Temperature for 10 K Alloyed Grain	<b>1010° - 1020° C</b> <b>1850° - 1868° F</b>
Casting Temperature for 14 K Alloyed Grain	<b>1020° - 1030° C</b> <b>1868° - 1886° F</b>
Casting Temperature for 18 K Alloyed Grain	<b>1000° - 1010° C</b> <b>1832° - 1850° F</b>

**NOTE: Melt temperature may vary with type of unit. This casting grain is designed for casting only.**

### 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. Avoid flux in bottom pour automatic casting units and fluxing is highly recommended while melting this pre-karated grain.

### QUENCH TIME

For 10 K – 14 K quench in **15 – 20 minutes**.  
**For 18K quench the button (only) within 2 - 3 minutes after casting. Then proceed to quench the whole flask.**

### 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 a 50% rejuvenation for re-melting.

### 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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