

**UNITED “DARK PINK” ALLOY # 543**

UNITED’S # 543 ALLOY may be used for **9 K to 18 K casting**, which produces a **Dark Pink finished color**. This alloy has very less de-oxidizer and hence, the casted tree will have a fire-scale and finished pieces will have a darker pink 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.

<b>Step : 1</b>	Pre- Alloying (Fine gold + alloy) Temperature	<b>1040° - 1050° C</b> <b>1904° - 1922° F</b>
<b>Step : 2</b>	Casting Temperature for 9 K & 10 K Alloyed Grain	<b>990° - 1010° C</b> <b>1814° - 1850° F</b>
	Casting Temperature for 14 K & 18 K Alloyed Grain	<b>1000° - 1025° C</b> <b>1832° - 1877° F</b>

**NOTE: Melt temperature may vary with type of unit. This alloy is designed for casting or 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. Avoid flux in bottom pour automatic casting units and fluxing is highly recommended for pre-graining.

**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 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)

**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](mailto:sales@unitedpmr.com); Website: [www.unitedpmr.com](http://www.unitedpmr.com)**