

## UNITED “ RED BRASS” ALLOY # 552

Thank you for using UNITED’S alloys.

UNITED’S # 552 Red Brass ALLOY may be used for direct **casting** which produces a **Copperish - Red 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** Direct Alloy Casting Temperature **1060° - 1070° C**  
**1940° - 1960° F**

**NOTE: Melt temperature may vary with type of unit. This alloy 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. 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

Quench **15 – 25 minutes**.

**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  
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)**