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## UNITED "PINK" ALLOY # NA-560

Thank you for using UNITED'S alloys.

UNITED'S # **NA-560** ALLOY may be used for **9K - 18K casting**, 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 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

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  
E-mail / [doc@unitedpmr.com](mailto:doc@unitedpmr.com) Web-Site / [www.unitedpmr.com](http://www.unitedpmr.com)

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