
UNITED CASTING BRASS ALLOY # 650

Thank you for using UNITED'S alloys.

UNITED'S **# 650 Casting Brass** is a **Standard Yellow bronze** designed to cast jewelry samples, models, belt buckles, art objects, etc. It finishes to a Standard **14 K** color and **easily solders with silver or low gold formulas**. **# 650** has a **much better resistance to tarnish than brass alloys**, as well as a **harder surface**. **# 650** also contains a **silicon de-oxidizer for clean casting**. Using 5 % by weight of **# 99** replenisher with this alloy **greatly improves the castability and tarnish resistance of this alloy**.

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

MELTING

Casting Temperature **1048° C - 1055° C**
1920° F - 1930° F

NOTES: Melt temperature may vary with type of unit. This alloy is designed for casting only. # 650 Brass should not be used for gold casting! # 650 Brass should not be cyanide gold plated, use acid gold plating unless nickel subplate is used. For # 650 Brass, we recommend an ultrasonic cleaning solution called BCR available from OKITE, phone # 1-800-526-4473 ext. 2411. Some kind of Anti - Tarnish coating on the jewelry is highly recommended since the tarnish resistance of this alloy is poor.

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

15 – 20 minutes.

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.

TECHNICAL ASSISTANCE

Always available... Call 1-800-999-3463 / 1-800-999-FINE
E-mail / doc@unitedpmr.com Web-Site / www.unitedpmr.com

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