

UNITED “GREENISH YELLOW” ALLOY # 765

Thank you for using UNITED’S alloys.

UNITED’S # 765 ALLOY is designed for **18 K yellow gold casting & fabrication**, which produces a **Greenish Yellow** 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° - 1070° C 1922° - 1958° F
Step : 2	Casting Temperature for 18 K Alloyed Grain	1030° - 1040° C 1886° - 1904° F

NOTE: Melt temperature may vary with type of unit. This alloy is designed for Casting and Fabrication (Rolling, Wire, Tube, Sheet).

FLASK TEMPERATURE

We recommend a slightly higher flask temperature for 18 K.

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

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.

REMELTING

We recommend 50% rejuvenation for re-melting.

TECHNICAL ASSISTANCE

Always available... Call 1-800-999-3463 / 1-800-999-FINE
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