

UNITED “RICH YELLOW” ALLOY # NA-720

Thank you for using UNITED’S alloys.

UNITED’S # **NA-720** ALLOY is designed for **18 K yellow gold casting**, which produces a **Rich 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.

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|-----------------|---|--|
| Step : 1 | Pre- Alloying (Fine gold + alloy) Temperature | 1050° - 1070° C
1922° - 1958° F |
| Step : 2 | Casting Temperature for 18 K Alloyed Grain | 1000° - 1010° C
1832° - 1850° F |

NOTES: 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

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.

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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