

UNITED “ULTRA WHITE” ALLOY # 860

Thank you for using UNITED’S alloys.

UNITED’S # 860 ALLOY may be used for **14 K – 18 K** white gold **casting & fabrication**, which produces a **White finished color**. ALLOY # 860 contains small amounts of silicon and boron deoxidizer.

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 14 K – 18 K Alloyed Grain **1000° - 1020° C**
1832° - 1868° 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 suggest a slightly higher flask temperature for white gold.

FLUXING

Fluxing white gold is extremely important to pick-up oxides. Boric Acid is the recommended flux. 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

Wait at least 25 minutes prior to quenching. (Varies according to size of flask, styles, karat etc.)

**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 a 70% fresh - 30% scrap mix. White gold alloy has about 1/3 the reusability of yellow gold alloys.

**TECHNICAL
ASSISTANCE**

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