

UNITED "ULTRA WHITE" ALLOY # 862

Thank you for using UNITED'S alloys.

UNITED'S # 862 ALLOY may be used for **9 K – 18 K white gold casting**, which produces a **Ultra White finished color**. ALLOY # 862 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 9 K -10 K Alloyed Grain	1030° - 1040° C 1886° - 1904° F
	Casting Temperature for 14 K -18 K Alloyed Grain	1000° - 1020° C 1832° - 1868° F

NOTES: Melt temperature may vary with type of unit. This alloy is designed for casting only.

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
E-mail / doc@unitedpmr.com Web-Site / www.unitedpmr.com

2781 Townline Road, Alden, NY 14004, USA.

Phone : (800) 999-3463; International Phone : +1-(716)-683-8334

Fax : (800) 533-6657; International Fax : +1-(716)-683-5433

E mail: sales@unitedpmr.com; Website: www.unitedpmr.com