

**UNITED “MEDIUM WHITE” ALLOY # NA-925**

Thank you for using UNITED’S alloys.

UNITED’S # **NA-925** ALLOY is the “New Age” version of our regular # **925** alloy. This alloy may be used for **9 K – 18 K white gold casting**, which produces a **Medium White finished color**. # **NA-925** is a **high fluidity** alloy that contains a 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.

<b>Step : 1</b>	Pre- Alloying (Fine gold + alloy) Temperature	<b>1050° - 1060° C</b> <b>1922° - 1940° F</b>
<b>Step : 2</b>	Casting Temperature for 9 K – 10 K Alloyed Grain	<b>1030° - 1040° C</b> <b>1886° - 1904° F</b>
	Casting Temperature for 14 K – 18 K Alloyed Grain	<b>1010° - 1030° C</b> <b>1850° - 1886° F</b>

**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**

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**

**10 – 12 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 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](mailto:doc@unitedpmr.com) Web-Site / [www.unitedpmr.com](http://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](mailto:sales@unitedpmr.com); Website: [www.unitedpmr.com](http://www.unitedpmr.com)**