

UNITED'S "ZING WHITE" - 18KWCGRM1

Thank you for using UNITED'S alloy.

UNITED'S # **18KWCGRM1** is designed for **18K White Gold casting**, which produces a **Super White finished color**.

18KWCGRM1 contains a small amount of Silicon as a deoxidizer.

You should obtain excellent results by following a few simple instructions.

MELTING

Cast Temperature

1010° - 1030°C

1850° - 1886°F

NOTES: Melt temperature may vary with type of unit.

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. (Quench Button first in water)

**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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