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## UNITED “LIGHT YELLOW” ALLOY # AURORA

Thank you for using UNITED’S alloys.

UNITED’S **PALLADIUM BASED “AURORA”** ALLOY may be used for low karat (**2k to 8k**) casting, which produces a **Light Yellow finished color**. It is formulated to **provide high resistance to tarnishing** and is often used for casting school rings. 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>1020° - 1030° C</b> <b>1868° - 1886° F</b>
<b>Step : 2</b>	Casting Temperature for 2 K – 8 K Alloyed Grain	<b>980° - 1000° C</b> <b>1796° - 1832° 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**

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**

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)

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