

UNITED “LIGHT YELLOW” ALLOY # 5KYCG

Thank you for using UNITED’S alloys.

UNITED’S # **5KYCG** is a **READY TO CAST GRAIN** & may be used for low karat casting, which produces a **Light Yellow finished color**. It is formulated to provide good resistance to tarnishing.

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

MELTING

Casting Temp for 5KYCG Grain **1010° - 1020° C**
1850° - 1868° F

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 % new + 50 % tumbled –clean scrap.

TECHNICAL ASSISTANCE

Always available... Call 1-800-999-3463 / 1-800-999-FINE
E-mail / doc@unitedpmr.com Web-Site / www.unitedpmr.com

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