

LOW KARAT WHITE GRAIN (1K, 2K, 4K, 6K & 8K)

Thank you for using UNITED'S alloys.

UNITED Low Karated White comes in pre-mixed ready to cast grains. These grains are to be casted "as is" and there is no need to further add gold or any other metals.

According to the National Gold & Silver Stamping Act and FTC guides, any item made of Gold less than 10 K **CANNOT** be called Gold, even with proper karat designation.

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

MELTING

Casting Temperature for low karat Alloyed Grain **1050° - 1250° C**
1922° - 2282° F

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

	Specific Gravity Values				
	1K	2K	4K	6K	8K
White	9.167	9.395	9.771	10.326	10.924

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

Avoid flux in bottom pour automatic casting units. 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.

QUENCH TIME

20 – 25 minutes button first into the 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 35% - 50% fresh mix for re-melting.

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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