

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

Thank you for using UNITED'S alloys.

UNITED Low Karated Yellow 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 10K **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 **970° - 1020° C**  
**1778° - 1868° F**

**NOTES: Melt temperature may vary with type of unit. This alloy may be used for fabrication purposes also.**

	Specific Gravity Values				
	1K	2K	4K	6K	8K
Yellow	9.367	9.595	9.981	10.530	11.123

**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.**

**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, unless our # 99 Alloy Replenisher is used.

**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)

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