
UNITED “VANILLA WHITE” ALLOY # PD2

Composition: 8% ZINC, 29.3% PALLADIUM, 53.4% AG, 9.3% COPPER

Thank you for using UNITED’S alloys.

UNITED’S # **PD2** Palladium white alloy is a **NICKEL FREE** white gold master alloys. PD2 is designed **14K - 18K casting**. The color produced will be a **Vanilla White**, which should be Rhodium plated for optimum color. **PD 2 alloy can be used in regular investment and regular gold & silver casting machines** but will perform better if Platinum investment and Pt casting machine is used for 18 karat casting.

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.

Step : 1	Pre- Alloying (Fine gold + alloy) Temperature	1130° - 1140° C 2066° - 2084° F
Step : 2	Casting Temperature for 14 K – 18 K Alloyed Grain	1120° - 1130° C 2048° - 2066° F

NOTES: Melt temperature may vary with type of unit. This alloy is designed for casting but may be used for hand-made.

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. (Quenching below 15 min will cause brittleness).

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. Reuse will be limited to a few melts.

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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