

UNITED “VERY WHITE” ALLOY # PD-9

Composition: 10% ZINC, 59.60% PALLADIUM, 30.4% COPPER

Thank you for using UNITED’S alloys.

UNITED’S # **PD-9** Palladium white alloy is a **nickel free white master alloy**. **PD-9** alloy is designed for **18 K castings** only. The color produced using this alloy will be **Very White**. Rhodium plating is recommended for optimum color. **PD-9** alloy **should be cast in a Phosphate bonded investment** (platinum casting investment) because of high metal temperatures involved using this alloy.

Note: Check the recommended temperature range on your casting equipment before using this alloy as the casting temperature may be above the limits of your equipment.

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	1240° - 1250° C 2264° - 2282° F
Step : 2	Casting Temperature for 18 K Alloyed Grain	1180° - 1190° C 2156° - 2174° 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

Not recommended.

QUENCH TIME

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 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
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