



## UNITED ALLOY # 634

Be insured in quality, Be insured in service, Be insured in "United Alloys."

UNITED ALLOY is uniquely different from other available alloys. Combining the highest purity metals available, stringent quality control, special de-oxidizers and grain refiners, produce trouble-free, superior quality castings and fabrication or rolling (hand-made).

UNITED ALLOY # 634 is designed for 9K - 18K Pink Gold, which produces a Rose Pink Color. This alloy is making tremendous strides in the technical metal development of a cracking free pink gold alloy and contains grain refiner which make better solidification characteristics to eliminate the cracking problem and reduce the porosity which improve the quality of casting and provide high luster in finished color and can be used Regular Casting, Stone-In-Place Casting and can be used for hand-made.

We do recommend pre-graining all alloy and fine gold before casting to assure a uniform mixture.

- 1.) Melt Temperature for Alloying : 1,040 - 1,050 °C
- 2.) Melt Temperature for Casting : 1,030 - 1,050 °C
- 3.) Flask Temperature :

KARAT	WEIGHT	CENTRIFUGAL CAST	VACUUM CAST
9K - 18K	Light	530 - 550 °C	620 - 680 °C
	Medium	490 - 520 °C	550 - 590 °C
	Heavy	450 - 480 °C	480 - 540 °C

- 4.) Quench Time : For 9K-14K after casting, wait 15 minutes before quenching flask.

For 18K after casting, wait 5 minutes before quenching flask, quench the button first.

- 5.) Pickling : United's Brite-Cast™ (Ammonium Bi-fluoride), Sparex # 2 (sodium bisulfate), 10% - 20% Sulfuric Acid.

Rubber gloves and safety glasses are recommended when using acid pickle.

- 6.) Re-using : New alloy and fine gold 50%, Old gold 50%, Cleans Old gold well before re-melting.

- 7.) Specific Gravity : 9K - 11.22, 10K - 11.54, 14K - 13.05, 18K - 15.00

- 8.) Soldering : United Pink Solder Alloy # 11SA, # 12SA or already mixed gold solder sheet.

Laser welding is recommendation for matching red/pink color.

- 9.) Note : Melt temperature may vary with type of unit.

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