UNITED CASTING ANTIQUE BRONZE ALLOY #341

Composition: 10% TIN, 90% COPPER

UNITED’S #341 Casting Antique bronze is a Reddish - Yellow antique bronze designed to cast jewelry samples, models, belt buckles, art objects, etc. It finishes to a Standard 14 K color and easily solders with silver or low gold formulas. #341 has a much better resistance to tarnish than brass alloys, as well as a harder surface. #341 also contains a silicon de-oxidizer for clean casting. Using 5% by weight of #99 replenisher with this alloy greatly improves the castability and tarnish resistance of this alloy. Specific Gravity of this alloy is 8.76.

MELTING

Casting Temperature

1020° C - 1030° C
1868° F - 1886° F

NOTES: Melt temperature may vary with type of unit. This alloy is designed for casting only. #341 Antique bronze should not be used for gold casting! #341 Antique bronze should not be cyanide gold plated, use acid gold plating unless nickel subplate is used. For #341 Antique bronze, we recommend an ultrasonic cleaning solution called BCR available from OKITE, phone # 1-800-526-4473 ext. 2411. Some kind of Anti-Tarnish coating on the jewelry is highly recommended since the tarnish resistance of this alloy is poor. Please visit: http://www.permalac.com/products.asp?gclid=CPqyxbT4obUCFUOK4AodUg1AEQ for more information on lacquering products.

FLASK TEMPERATURE

Normal recommended temperature in the range of 590° C to 700° C
593 TO 676° C / 1100 TO 1250° F – VACUUM CASTING
482 TO 537° C / 900 TO 1000° F - CENTRIFUGAL CASTING

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.

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. 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.

TECHNICAL ASSISTANCE

Always available… Call 1-800-999-3463 / 1-800-999-FINE
E-mail / doc@unitedpmr.com Web-Site / www.unitedpmr.com

2781 Townline Road, Alden, NY 14004, USA.
Phone : (800) 999-3463; International Phone : +1-(716)-683-8334
Fax : (800) 533-6657; International Fax : +1-(716)-683-5433
E-mail: sales@unitedpmr.com; Website: www.unitedpmr.com