
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=CPqvxbT4obUCFUOK4AodUgIAEQ> for more information on lacquering products.

FLASK TEMPERATURE

Normal recommended temperature in the range of **590° C to 700° C**
593 TO 676C / 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