

## TECH SPECS: Allura 48

<b>COMPOSTION:</b>	Silver, gold, palladium
<b>MELT:</b>	1724°F -1760°F (940°C - 960°C)
<b>PASTY RANGE:</b>	1544°F -1598°F (840°C - 870°C)
<b>CASTING RANGE:</b>	1785°F -1875°F (974°C -1024°C)
<b>FLASK RANGE:</b>	Men's rings 950°F - 1100°F (510°C - 593°C) Very large Men's rings 800°F - 950°F (427°C - 510°C) Ladies rings 1150°F – 1200°F (620°C - 650°C)
<b>QUENCH:</b>	15 to 20 minutes
<b>HARDNESS:</b>	As cast - 160 Vickers scale
<b>HEAT TREAT:</b>	N/A
<b>METAL MIX:</b>	70% new to 30% old works best
<b>PICKLE:</b>	Sodium Bisulfate (SPAREX) or 10% Nitric Acid and 90% water (heated)
<b>FLUX:</b>	25% granular Boric Acid and 75% granular Borax mixed
<b>MACHINE NOTES:</b>	If casting with a frequency machine, always cast “on the upswing” of the metal heating cycle. Always retrieve flask well before casting temperature is reached, then cast it when the temp reaches set point. Leave in machine for 2 minutes after pour. <b>(DO NOT MOVE THE FLASK)</b>