

TECH SPECS: # 127 – B2 STERILITE

FINENESS:	925 Sterling Silver
APPLICATION	alloy for casting
MELT:	Approx. 925°C (1700°F)
ALLOYING TEMP:	1040°C (1904°F) POUR AT: 1000°C (1832°F)
CASTING RANGE:	OPEN SYSTEMS: 980°C to 1040°C (1796°F to 1904°F) CLOSE SYSTEMS: 1000°C to 1050°C (1832°F to 1922°F) (Neutec,Indotherm)
FLASK RANGE:	540°C – 650°C (1000°F to 1200°F)
QUENCH:	Must be 15-20 minutes normal, cold breakout can be done FASTER QUENCH TIME WILL RESULT IN SIGNIFICANTLY LOWER HARDNESS
HEAT TREAT:	1) De-invest, cut sprue, clean the trees 2) Place the pieces in the preheat oven at 650C for 20-30 mins, once the time reaches, quench the pieces immediately in room temperature water, pickle clean and cry. 3) Heat the pieces in 2) in an oven once again at 286C for 2-4 hours depending on designs. Once the time has reached, turn off the oven, let the pieces cool down slowly, do not quench, process completes.
METAL MIX:	At least 50% new to 50% old, 60/40 or 70/30 preferred.
PICKLE:	Sodium Bisulfate (SPAREX) or 10% nitric 90% heated water
FLUX:	25% granular Boric Acid and 75% granular Borax mixed.
MACHINE NOTES:	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 when the temperature reaches set point.
PRE-GRAINING:	We recommend graining alloy and fine silver prior to casting. If you do not pre-grain, fine silver and alloy should be blended together, added to the crucible and brought to the melting point of silver, approx. 950°C – 960°C. Stir the melt vigorously as the temperature is raised to the proper casting temperature (see above).