

TECH SPECS: # 250-B STERILITE

FINENESS:	925 Sterling Silver
MELT:	Approx. 875 C (1610F)
PASTY RANGE:	850C to 874C (1562F to 1598F)
ALLOYING TEMP:	1050C
CASTING RANGE:	980C to 1010C
FLASK RANGE:	485C - 640C (900F to 1250F)
QUENCH:	15 TO 20 minutes normal, cold breakout can be done
HEAT TREAT:	Place pieces or trees in 650F(343C) oven for 1 to 1-1/2 hours. Turn off oven and let the oven cool to room temperature (about an hour more)
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).