

TECH SPECS: # 250 M STERILITE

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| FINENESS: | 925 Sterling Silver |
| MELT: | Approx. 875 C (1610F) |
| PASTY RANGE: | 850C to 874C (1562F to 1598F) |
| ALLOYING TEMP: | 1020C (1868F) POUR AT: 980C (1796F) |
| CASTING RANGE: | OPEN SYSTEMS: 950C to 1010C (1742F to 1850F) CLOSED SYSTEMS: 980C to 1010C (1796F to 1850F) (Neutec, Indotherm) |
| 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). |