

TECH SPECS: # 407 STERILITE

FINENESS:	925 Sterling Silver
MELT:	Approx. 875°C (1610°F)
PASTY RANGE:	850°C to 874°C (1562°F to 1598°F)
CASTING RANGE:	980°C to 1010°C (1832°F to 1850°F)
FLASK RANGE:	485°C – 640°C (900°F to 1250°F)
QUENCH:	15 TO 20 minutes normal, cold breakout can be done
HEAT TREAT:	Place pieces or trees in 650°F 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.