

**TECH SPECS:**      **92.5% Sterling Silver / 1% Platinum (Patented)**

**FINENESS:**            92.5% Silver, 1% Platinum

**DENSITY:**            10.4g/ccm, same as regular sterling

**INVESTMENT:**        Regular sterling investment acceptable - premium investment preferred

**MELT RANGE:**        893°C – 910°C

*Please protect metal with inert gas during the melting process*

**CASTING RANGE:**    968°C – 982°C    **PASTY RANGE:** 882°C – 902°C

**FLASK RANGE:**        Depends on part(s), weight or type. In general, we believe this alloy should be **cast at flask temperature 100°F to 200°F higher** than you currently use for traditional sterling castings. It is important to hold flask at intended temperature or at least 1 hour prior to casting. We suggest test casting with 1 flask at the same temperature as you normally do for traditional sterling, a 2<sup>nd</sup> flask 100°F (38°C) higher and a 3<sup>rd</sup> 200°F (93°C) higher to establish the optimum temperatures for your oven and specific parts.

**QUENCH:**            15 to 20 minutes (quicker = softer castings, longer= harder)

**HEAT TREAT:**        Place pieces on trees in 650°F (343°C) oven for 2 hour. Turn off oven and let the oven cool to room temperature (about one hour more)

**PICKLE:**            Pickling with SPAREX (Granular Sodium Bisulfate) is recommended. After pickling the sprues and trees to be re-cast should be tumbled & thoroughly rinsed and cleaned prior to casting.

**METAL MIX:**        At least 60% new to 40% old. It is important to thoroughly clean the old (used) metal prior to re-using. It is imperative to “regrain” the buttons & sprues if you plan to re-use them to eliminate the sulfur dioxide from previous melts.

**FLUX:**            Not necessary with this metal. If desired, use 25% granular Boric Acid and 75% granular borax mixed on the button.

**MACHINE NOTES:**    If casting with a frequency machine, always cast “on the upswing” of the metal heat cycle. Always retrieve flask well before casting temperature is reached, then cast when temperature reaches set point.