

- TECH SPECS:** **92.5% Sterling Silver / 3.5% Platinum (Patented)**
- FINENESS:** 92.5% Silver, 3.5% Platinum
- DENSITY:** 10.6g/ccm-VS. 10.4 g/ccm for regular sterling
- INVESTMENT:** Regular sterling investment acceptable - premium investment preferred
- MELT RANGE:** 954°C – 963°C

Please protect metal with inert gas during the melting process

- CASTING RANGE:** 1010°C – 1030°C **PASTY RANGE:** 907°C – 960°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 2nd flask 100°F (38°C) higher and a 3rd 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.