

STERILITE # 127 SPRING STERLING SHEET/WIRE FABRICATION INSTRUCTIONS

Melt and cast temps: 1025°C, 1877°F

Clean after cast: Rod and plate should be scrubbed with medium abrasive pad (Scotchbrite or similar) before roll reduction.

Spring wire/sheet production: Standard sterling reduction per draw/roll. Do not anneal all the way down to finished size.

Annealing procedure: 625°C (1157°F) for 20 minutes and then water quench.

Heat Treating: Sterilite #127 may be aged hardened at 550°F (288°C) for 3-1/2 to 4 hours, then air cooled (DO NOT QUENCH).

Finishing: Treat as standard sterling – for final polish use Fabulustre or Musilin buff.