

# ABI Precious Metals

## TECH SPECS: #185 STERILITE

<b>FINENESS:</b>	925 Sterling Silver
<b>MELT:</b>	Approx. 890° C (1634° F)
<b>PASTY RANGE:</b>	875° C to 890 °C (1607° F to 1634° F)
<b>ALLOYING TEMP:</b>	1020° C (1868° F) <b>POUR AT:</b> 1010° C (1850°F)
<b>CASTING RANGE:</b>	1000° C to 1030° C (1832° F to 1886° F) <b>Neutec and Indotherm machines cast better at the higher temperature range.</b>
<b>FLASK RANGE:</b>	535° C to 620° C (1000° F to 1150° F)
<b>QUENCH:</b>	15 TO 20 minutes
<b>HEAT TREAT:</b>	Place pieces or trees in 550°F - 675° F oven for 1 to 1-1/2 hours. Turn off oven and let the oven cool to room temperature, at least an hour more.
<b>METAL MIX:</b>	At least 50% new to 50% old.
<b>PICKLE:</b>	Sodium Bisulfate (SPAREX)
<b>FLUX:</b>	25% granular Boric Acid and 75% granular Borax mixed.
<b>MACHINE NOTES:</b>	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. <b>Neutec and Indotherm machines cast better at the higher temperature range.</b>

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