

# ABI Precious Metals

## TECH SPECS: # 219-B STERILITE

<b>FINENESS:</b>	925 Sterling Silver
<b>MELT:</b>	Approx. 843° C (1551° F)
<b>PASTY RANGE:</b>	820° C to 839° C (1508° F to 1544° F)
<b>ALLOYING TEMP:</b>	1010° C (1850° F) <b>POUR AT:</b> 980° C (1796° F)
<b>CASTING RANGE:</b>	955° C to 975° C (1750° F to 1780° F) <b>Neutec and Indotherm machines cast better at the higher temperature range.</b>
<b>FLASK RANGE:</b>	455° C to 594° C (850° F to 1100° F)
<b>QUENCH:</b>	15 to 20 minutes normal, cold breakout can be done
<b>HEAT TREAT:</b>	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)
<b>METAL MIX:</b>	At least 50% new to 50% old/preferred 60/40-70/30.
<b>PICKLE:</b>	Sodium Bisulfate (SPAREX) or 10% Nitric Acid and 90% water heated
<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 temperatures is reached, then cast it when the temp reaches set point. Cast larger pieces at the lower end of the casting and flask temperatures. <b>Neutec and Indotherm machines cast better at the higher temperature range.</b>

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