

ABI Precious Metals

TECH SPECS: # 330 STERILITE

FINENESS:	925 Sterling Silver
MELT:	Approx. 843°C (1550°F)
PASTY RANGE:	820°C to 839°C (1508°F to 1544°F)
ALLOYING TEMP:	1010°C (1850°F) POUR AT: 980°C (1796°F)
CASTING RANGE:	960°C to 1000°C (1760°F to 1830°F) Neutec and Indotherm machines cast better at the higher temperature range.
FLASK RANGE:	400°C to 620°C (750°F to 1100°F)
QUENCH:	20 to 30 minutes normal
HEAT TREAT:	Place pieces or trees in 600°F – 650° F oven for 2 hours. Turn off oven and let the cool to room temperature (about an hour more).
METAL MIX:	At least 50% new to 50% old
PICKLE:	Sodium Bisulfate (SPAREX) or 10% Nitric Acid and 90% water heated
FLUX:	A pinch of boric acid flux is recommended.
MACHINE NOTES:	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. Cast larger pieces at the lower end of the casting and flask temperatures. Neutec and Indotherm machines cast better at the higher temperature range.

10/11