

ABI Precious Metals

TECH SPECS: ALLURA-WHITE # 1000

COMPOSTION:	Silver, palladium, platinum
MELT:	Solidus 1551°F (844°C) Liquidus 1767°F (964°C)
PASTY RANGE:	N/A
CASTING RANGE:	1925°F -2000°F (1052°C -1094°C) Best results usually occur when casting at the high end of the range (large pieces)
FLASK RANGE:	Lady's rings 1050°F - 1100°F (565°C - 593°C) Men's rings 950°F - 975°F (510°C - 524°C)
QUENCH:	12 to 20 minutes
HARDNESS:	As cast - 110 – 125 Hv (81 Rockwell 15-T)
HEAT TREAT:	N/A
METAL MIX:	We recommend 60% new to 40% old . It is important to thoroughly clean the old (used) metal prior to re-using. It is imperative to re-grain the buttons and sprues if you plan to re-use them to eliminate sulfur dioxide and other contaminates from previous melts.
PICKLE:	Sodium Bisulfate (SPAREX) or 10% Nitric Acid and 90% water (heated)
FLUX:	25% granular Boric Acid and 75% granular Borax mixed
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 it when the temp reaches set point. Leave in machine for 2 minutes after pour. (DO NOT MOVE THE FLASK)

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