

ABI Precious Metals

TECH SPECS: STERLING SILVER

FINENESS:	925 Sterling Silver
MELT:	Approx. 808°C (1485°F)
PASTY RANGE:	850°C to 874°C (1562°F to 1598°F)
ALLOYING TEMP:	1010°C (1850°F) POUR AT: 980°C (1796°F)
CASTING RANGE:	940°F to 1020°C (1724°F to 1870°F)
FLASK RANGE:	485°C to 640°C (900°F to 1250°F)
QUENCH:	15 to 20 minutes normal, cold breakout can be done.
HEAT TREAT:	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 more)
METAL MIX:	At least 50% new to 50% old, preferred 60/40-70/30.
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 when the temperature reaches set point. Cast larger pieces at the lower end of the casting and flask temperatures.

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