

TECH SPECS: #127 STERILITE

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| FINENESS: | 925 Sterling Silver |
| MELT: | Approximately 925°C (1700°F) |
| ALLOYING TEMP: | 1010°C (1850°F) POUR AT: 980°C (1796°F) |
| CASTING RANGE: | OPEN SYSTEMS: 950°C to 1010°C (1742°F to 1850°F) CLOSED SYSTEMS: 980°C to 1010°C (1796°F to 1850°F) (Neutec, Indotherm) |
| FLASK RANGE: | 540°C to 650°C (1000°C to 1200°F) |
| QUENCH: | Must be 15-20 minutes normal, cold breakout can be done FASTER QUENCH TIME WILL RESULT IN SIGNIFICANTLY LOWER HARDNESS |
| HEAT TREAT: | After casting quench in 15 to 20 minutes, divest and clean pieces. Oven heat pieces to 600°C to 650°C (1115°F - 1200°F) for 15 minutes, then quench while red hot in clean water. Clean/pickle pieces and pre-finish. Oven heat again at 286°C (550°F) for 3 to 4 hours, then remove and air cool slowly (do not quench). Thick pieces may heat treat better at 375°C (700°F). Clean pieces and finish as you normally do. Soldering can cause pieces to soften. |
| METAL MIX: | At least 50% new to 50% old, 60/40 or 70/30 preferred. |
| PICKLE: | Sodium Bisulfate (SPAREX) or 10% nitric 90% heated water. |
| 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 flasks well before casting temperature is reach, then cast when the temperature reaches set point. |
| PRE-GRAINING: | We recommend graining alloy and fine silver prior to casting If you do not pre-grain, fine silver and alloy should be blended together, added to the crucible and brought to the melting point of silver, approximately 950°C to 960°C. Stir the melt vigorously as the temperature is raised to the proper casting temperature (see above). |