

## **TECH SPECS: #250 STERILITE**

<b>FINENESS:</b>	925 Sterling Silver
<b>MELT:</b>	Approx- 875°C (1610°F)
<b>PASTY RANGE:</b>	850°C To 874°C (1562°F To 1598°F)
<b>ALLOYING TEMP:</b>	1010°C (1850°F)
<b>POUR AT:</b>	980°C (1796°F)
<b>CASTING RANGE:</b>	955°C To 1025°C (1750°F To 1875°F)
<b>FLASK RANGE:</b>	485°C To 600°C (900°F To 1100°F)
<b>QUENCH:</b>	15 To 20 minutes
<b>HEAT TREAT:</b>	Place pieces or trees in 650°F oven for 1 to 1 ½ hours. Turn off oven and let the oven cool to room temperature. (about an hour more)
<b>METAL MIX:</b>	At least 50% new to 50% old
<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 temperature is reached, then cast it when the temperature reaches the set point. Cast larger pieces at the lower end of the casting and flask temperatures.