

TECH SPECS: # 402-B STERILITE

FINENESS:	925 Sterling Silver
MELT:	Approx. 890°C (1634°F)
PASTY RANGE:	875°C to 890°C (1607°F to 1634°F)
ALLOYING TEMP:	1080°C to 1100°C (1976 °F to 2012°F)
POUR AT:	1080°C (1976°F)
CASTING RANGE:	960°C to 1000°C (1760°F to 1832°F)
FLASK RANGE:	455°C – 621°C (850°F to 1150°F)
QUENCH:	15 TO 20 minutes
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.
PICKLE:	Sodium Bisulfate (SPAREX)
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.
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, approx. 950°C – 960°C. Stir the melt vigorously as the temperature is raised to the proper casting temperature (see above)