



UNITED MEDIUM PINK SILVER GRAIN # SP-2

THANK YOU FOR USING UNITED'S ALLOYS.

UNITED MASTER ALLOY # SP-2 has been formulated to be used in the manufacture of silver jewelry. Please note, this alloy is **NOT** recommended for making **STERLING SILVER JEWELRY**. This alloy has 35% fine silver and is to be **directly** used for casting or for pouring into ingot for further sheet and wire making.

CASTING TEMPERATURE : 950°C - 980°C / 1742°C - 1796°F

Do not overheat the metal. Boric acid flux may be used to keep the metal clean during the melting process. The metal should be mixed well with a stirring rod before pouring to assure a good mix.

FLASK TEMPERATURE : 650°C to 675°C depending on size of flask and type of jewelry.

QUENCHING TIME FOR FLASKS : 20 to 30 minutes.

POURING INGOT : Metal should be poured into a preheated, vertical, lightly lubricated, 2 piece, L shaped mold with a 1/8 inch opening. A steady even pouring motion should be used slowing at the end of the pour to prevent shrinkage in the top of the ingot.

INGOT QUENCHING : The metal ingot should be removed from the mold and quenched immediately in pickle solution or water.

FABRICATION : The metal ingot should be cleaned of all adhering oxide or fluxes before rolling. The ingot should be rolled to a 10%-15% reduction in thickness each time. Anneal the sheet after 50% reduction. Clean the ingot after each annealing. Keep rolls, dies and metal clean to prevent defects in the finished stock.

ANNEALING : Annealing temperature 250°C - 400°C/ 500°F- 750°F for 20 minutes. Be careful handling the silver ingots when hot, as they can be fragile. Air-cool the ingots for a few minutes before quenching in water.

Representative Office :

UNITED PM (THAILAND) CO., LTD. 427/15-16 Krungthonburi Rd., Klongtonsai, Klongsan, Bangkok. 10600, Thailand.

Tel : (662) 4400643, 4400673 Fax : (662) 8622344 Mobile 081- 6948866, 081-7517384 E-mail : sales@unitedpmthailand.com