



UNITED # STAGCG-86 (STERLING SILVER CASTING GRAIN)

UNITED # STAGCG-86 is a De-oxidized Sterling Silver Grain designed to achieve high tarnish resistance, high lustre, improving hardness, eliminate fire scale and porosity. Sterling # STAGCG-86 has been developed to have hardness approximately equal to standard sterling silver, while still retaining the advantageous characteristics of our other sterling silver grains.

Melting : Traditional methods of melting regular sterling silver I.E. (as cool as possible) will cause a variety of problems. Most failures with these sterling products are caused by too low of a melt temperature. Customers familiar with silicon deoxidized gold casting alloys should have less trouble adjusting to the appearance of these silvers.

Casting Temperature	: 990 - 1,020°C / 1,814-1870°F
Flask Temperature	: Use your regular flask temperatures in the range of 1100 F to 1250 F depending on the size of flask and type of jewelry being cast.
Quench Time	: 15 - 20 minutes.
Specific Gravity	: 10.27
Remelting	: We recommend a 50% fresh mix.
Investment Removal	: Most standard investment removers will successfully remove the investment powder. The best solutions are the sulfuric and hydrofluoric based products.
Fluxing	: It maybe necessary to flux these silver melts. We recommend Boric acid. Do not use Carbon Containing Fluxes or Charcoal. Skim any surface oxides off the surface before stirring.
Hardness and	: This silver as cast will have a hardness similar to traditional sterling silver.
Heat Treatment	: It can be hardened further by heat treatment at 300°C/ 575°F for 2 hr., and air cool.
Soldering	: Over-heating while soldering is to be avoided. United # SSA is a silver solder alloy or ready to use Easy-Medium-Hard silver solder.
Notes	: Melt temperature may vary with type of unit. U.S. Patent # 4,973,446, # 5,039,479 or International Publication # 's WO 95/14112, & WO 96/22400

Representative Office :

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

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