



UNITED # STAGCG-PT4 (PLATINUM STERLING SILVER)

Sterling Silver “PT4” is a proprietary 1% of platinum based sterling silver designed to achieve maximum hardness and eliminate fire scale and porosity. Sterling Silver “PT4” has been developed to have a hardness exceeding 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 deoxidized gold casting alloys should have less trouble adjusting to the appearance of these silvers.

Casting Temperature : 980 - 1,000°C / 1,796 - 1832°F Please stir the metal aggressively and hold the metal at the casting temperature for about 1 minute. prior to pouring in flask. Hard spots may occur if proper mixing is not done.

Flask Temperature :

WEIGHT	CENTRIFUGAL CAST	VACUUM CAST
Light	524 – 538 °C (975 -1,000 °F)	621 – 677 °C(1,150 -1,250 °F)
Medium	482 – 510 °C (900 - 950 °F)	566 – 593 °C(1,050 -1,100 °F)
Heavy	455 - 482 °C (850 - 900 °F)	482 – 538 °C (900 –1,000 °F)

Quench Time : After casting, wait 20 - 25 minutes before quenching flask.

Reused : We recommend a 50% fresh – 50 scrap mix.

Fluxing : It will be 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.

Investment Removal : Most standard investment removers will successfully remove the investment powder. The best solutions are the sulfuric and hydrofluoric based products.

Heat Treatment : It can be hardened further by heat treatment at 300°C/ 575°F for 1 hr. and air cool.

Notes : Melt temperature may vary with type of unit.

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