



**Data Sheet**

**Crinkle**

**Reticulating Bi-Metal**

**RMS**  
Reactive Metals Studio Inc  
**RMS**

PO Box 890

Clarkdale, AZ 86324

928/634-3434 • 800/876-3434 • 928/634-6734F

[www.reactivemetals.com](http://www.reactivemetals.com) • [info@reactivemetals.com](mailto:info@reactivemetals.com)

# Crinkle • Bi-Metal

## COMPOSITION:

80/20 silver/copper reticulation alloy, fine silver back. 82% Fine silver, 18% 80-20 Reticulation silver

## DESCRIPTION:

The reticulation alloy is 1/6 of the total thickness. Shipped fully annealed.

**QUALITY MARK:** overall copper content is 3.33%, therefore it should be able to be quality maked with sterling, stg or .925

## USES:

Jewelry, flatware and other decorative metalwork. Some individuals may color or have a skin reaction with continuous contact with the reticulated side. Long term acidic food contact with the reticulated side is not recommended.

## CHARACTERISTICS:

Instant reticulation. No surface preparation is necessary. Crinkle may be precut and formed, it will not lose it's shape during reticulation. Very soft and easy to form.

## MELTING POINT:

Starts to melt at the silver/copper eutectic temperature, 1435°F/779°C

## ANNEALING:

Recommended annealing temperature is 1250°F/675°C. This material may be torch or kiln annealed. Soaking at the annealing temperature is not necessary. Do NOT protect from oxygen by coating with flux or using a reducing atmosphere unless soldering. Pickle only long enough to remove flux. Do not soak in the pickle as this may attack the pre-reticulated surface.

## WORKING THE MATERIAL:

**Hot working this bimetal is not recommended; doing so will void the warranty.**

This bimetal is easily formed by raising, cold forming, die striking and sawing. Anneal after a 40-50% reduction has been achieved. This metal is very soft in the annealed state. Use a solder that flows at a temperature lower than the melting point. Easy and medium silver solder are recommended. Soldering is best done after reticulation.

## RETICULATION:

Place the Crinkle on a charcoal or other suitable heat resistant block. Bring the piece slowly up to heat with a moving flame. When the metal reaches the proper temperature the surface will begin to form waves and then start to crawl as it crinkles up. Use the same torch techniques as with regular reticulation. A small oxidizing flame works best. Remove the heat, cool and pickle as usual.

Crinkle will work even if you lose track of which side is which (The dark side crinkles). The piece may be reheated if there are areas that you do not like. Overheating will cause the alloy to flow freely on the surface of the fine silver where it may be stirred with a soldering pick or metal brush for unusual effects. Granules, chips and other heat resistant bits can be dropped into the molten surface for even more special effects.

## FINISHING:

After reticulation the metals should be pickled or lightly etched and carefully brushed if a bright surface is desired. The sheet may be stiffened by hammering between a soft mallet and wooden stake after reticulating or soldering.

## PATINA:

Patina as you would sterling silver using either Antique Patina or liver of sulfur.

## NOTE:

Take proper safety precautions when using any chemicals or tools.  
This information represents the best knowledge and experience regarding the use of Shining Wave Metals products by their manufacturer, however it is not guaranteed to produce an expected result and is no substitute for experimentation by the user of these products.