

## 1P8/NF



**High Performance Mechanical**  
**High Performance Casting**

**14kt**

### GENERAL INFORMATION

Carats: 14kt, suitable also for 8, 9 and 10kt.  
 Colour: white - green  
 Advised use: universal (both mechanical works and casting)

MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■
CASTING	closed systems	■	open systems	■	pre-set stones		■	

Density: 12,24 g/cm<sup>3</sup>  
 Hardness (as cast): 100 HV

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 890 °C

Casting temperature:

100 °C over its melting temperature to cast into ingot-mould and continuous casting

100 °C over its melting temperature to cast with centrifugal machines

120 °C over its melting temperature to cast in vacuum machines with controlled atmosphere

140 °C over its melting temperature to cast in outdoor cylinders with vacuum

Ingot-mould temperature: 150 °C

Cylinders temperature: from 550 °C to 650 °C depending on the machine and objects dimensions

Cooling of ingots: quick in lukewarm water (about 40 °C)

Cooling casted objects: in water after 10 minutes

Cooling casted objects (with stones): in water after 30/40 minutes

Annealing: 620 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

Nickel release UNI EN 1811:2011: not required, nickel-free alloy

### HINTS

- ❖ Recommended Pandora Alloys white 9kt solders: TB9 (soft), MB9 (medium), FB9 (hard)
- ❖ Suggested Pandora Alloys plating solutions: Rhodium P2 and Palladium PDSOL/BE

The above directions are only indicative. Strong variations to the above data are possible, depending on personal experience. Please, do not hesitate to contact us for further information.

Tech Chart and Safety Data Sheet available on our website [www.pandoralloys.com](http://www.pandoralloys.com)