

1PAG/CA1

Classic Mechanical

925

GENERAL INFORMATION

Colour: white
colour coordinates: L*=97.6 a*=-0.6 b*=4.7

Advised use: mechanical works

MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■
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Density: 10,5 g/cm³
Hardness (as cast): 70 HV
Hardness (after cold work 70%): 165 HV
Hardness (after annealing): 80 HV
Hardness (after age hardening): 120 HV

DIRECTIONS FOR SUGGESTED USE

Melting range: Liquidus 895 °C - Solidus 810 °C

Casting temperature:
100 °C over its melting temperature for continuous casting with sinker thermocouple.
120 °C over its melting temperature to cast into ingot-mould and continuous casting.

Ingot-mould temperature: 150 °C

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

Annealing: 600 °C for 20 minutes followed by a quick cooling in warm water (40 °C)

Age hardening: *step 1: solubilization*
730 °C for 40 minutes followed by quick cooling in hot water (min. 40 °C), better if with alcohol.

step 2: hardening
300 °C for 2 hours. Cooling at room temperature.

HINTS

- ❖ Recommended Pandora Alloys silver solders: TA (soft), MA (medium), FA (hard)
- ❖ Recommended Pandora Alloys silver alloy for High Performance Casting: 1PAG/L

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