

1PAG/L

GENERAL INFORMATION

Carats: 925‰, suitable also for 800‰ and 950‰
 Colour: white colour coordinates: L*=95.3 a*=-0.5 b*=5.0
 Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 10,30 g/cm³
 Hardness: 62 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 880° C

Casting temperature:

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

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

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

Cylinders temperature:

from 550° C to 650° C depending on the machine and objects dimensions.

Cooling casted objects:

in water after 10 minutes.

Annealing:

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

HINTS

- ❖ Recommended Pandora silver solders: TA (soft), MA (medium), FA (hard)
- ❖ Suggested Pandora silver alloy for High Performance Mechanical works: 1PAG/CA

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.