

1PAG/ML

GENERAL INFORMATION

Carats: 925‰, suitable also for 800‰ and 950‰
 Colour: white
 Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 10,25 g/cm³
 Hardness (as cast): 62 HV
 Hardness (after annealing): 60 HV
 Hardness (after age hardening): 130 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 880 °C

Casting temperature:

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.

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

Cooling casted objects: in water after 10 minutes.

Annealing: 650 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

Age hardening: *step 1: solubilization*
 720 °C for 30 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)
- ❖ Suggested Pandora Alloys 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.