

1PAG/M

GENERAL INFORMATION

Carats: 925‰, suitable also for 800‰ and 950‰
Colour: white
colour coordinates: L*=93.3 a*=-0.5 b*=4.7
Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 10.22 g/cm³
Hardness (as cast): 60 HV
Hardness (after annealing): 65 HV
Hardness (after age hardening): 107 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 910 °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.
Cooling casted objects (with stones): in water after 30/40 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