

1PAG/NOG



High Performance Mechanical

925

GENERAL INFORMATION

Colour: white colour coordinates: L*=95.5 a*=-0.6 b*=5.1
 Advised use: mechanical works

MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■
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Density: 10,05 g/cm³
 Hardness (as cast): 75 HV
 Hardness (after cold work 70%): 180 HV
 Hardness (after age hardening): 135 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 900°C

Casting temperature:
 100°C over its melting temperature to cast into ingot-mould and continuous casting.
 80°C over its melting temperature for continuous casting with sinker thermocouple.

Ingot-mould temperature: 150°C

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

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

Age hardening: *Step 1: solubilization*
 700°C for 30 minutes. Cooling quickly in warm water (about 40°C), better if with alcohol.

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

HINTS

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

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.