

1PAG/R1

GENERAL INFORMATION

Carats: 925‰,
 Colour: shining white **TARNISH-RESISTANT SURFACE**
 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): 130 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.
 Cooling casted objects (with stones): in water after 30/40 minutes.

Annealing: 620 °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 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.
 Tech Chart and Safety Data Sheet available on our website www.pandoralloys.com