

## 2P14/C1

**14 kt**

### GENERAL INFORMATION

Carats: 14 kt, suitable also for 9 kt (see specific tech data sheet)  
 Colour: yellow  
 Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 12,57 g/cm<sup>3</sup>

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 860° 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.)

### HINTS

❖ Recommended Pandora yellow 14kt solders: TG14 (soft), MG14 (medium), FG14 (hard)

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.