

2P14/C1

9 kt

GENERAL INFORMATION

Carats: 9 kt, 10kt suitable also for 14 kt (see specific tech data sheet)
 Colour: yellow
 Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 10,69 g/cm³

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 900° 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.

Ingot-mould temperature: 150° C

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 9kt solders: TG9 (soft), MG9 (medium), FG9 (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.

Tech Chart and Safety Data Sheet available on our website www.pandoralloys.com