

## 2P14/PU



Classic Casting

**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	<input checked="" type="checkbox"/>	open systems	<input checked="" type="checkbox"/>	pre-set stones	<input checked="" type="checkbox"/>
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Density: 12,90 g/cm<sup>3</sup>  
 Hardness (as cast): 120 HV  
 Hardness (after annealing): 115 HV

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 890 °C

Casting temperature:

100 °C over its melting temperature to cast with centrifugal machines.

120 °C over its melting temperature to cast in vacuum machines with controlled atmosphere.

140 °C over its melting temperature to cast in outdoor cylinders with vacuum.

Cylinders temperature: from 550 °C to 650 °C depending on the machine and objects dimensions.

Cooling casted objects: in water after 10 minutes.

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

### HINTS

- ❖ Recommended Pandora Alloys yellow 14 kt solders: TG14 (soft), MG14 (medium), FG14 (hard)
- ❖ Recommended Pandora Alloys light yellow 14 kt alloy for mechanical works: 2P8/G

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.