

2P8/AR



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	■	open systems	■	pre-set stones	■
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Density: 12,65 g/cm³
 Hardness (as cast): 110 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 860 °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 500 °C to 600 °C depending on the machine and objects dimensions.

Cooling casted objects: in water after 15 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 Alloys 14 kt yellow 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.
 Tech Chart and Safety Data Sheet available on our website www.pandoralloys.com