

## 5N14/L



High Performance Casting

**14kt**

### GENERAL INFORMATION

Carats: 14kt, suitable also for 8, 9, 10kt (see specific tech data sheet)  
 Colour: Russian red  
 colour coordinates: L\*=85.4 a\*=8.4 b\*=17.8  
 Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 12,57 g/cm<sup>3</sup>  
 Hardness (as cast): 130 HV  
 Hardness (after annealing): 125 HV  
 Not age-hardenable

### DIRECTIONS FOR SUGGESTED USE

Melting range (Solidus – Liquidus): 857 - 908 °C

Casting temperature:  
 100 °C over its Liquidus temperature to cast with centrifugal machines.  
 120 °C over its Liquidus temperature to cast in vacuum machines with controlled atmosphere.  
 140 °C over its Liquidus 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.  
 Cooling casted objects (with stones): in water after 30/40 minutes.

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

### HINTS

- ❖ Recommended Pandora Alloys 14kt red solders: TRJ14

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](http://www.pandoralloys.com)