

## 5N14/L



High Performance Casting

**9kt**

### GENERAL INFORMATION

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

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 11,20 g/cm<sup>3</sup>  
Hardness (as cast): 105 HV  
Hardness (after annealing): 100 HV  
Not age-hardenable

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 940 °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.

Cooling casted objects (with stones): in water after 30/40 minutes.

Annealing: 660 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

### HINTS

❖ Recommended Pandora Alloys 9kt red solders: TR9 (soft), MR9 (medium)

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)