

5P18/L



High Performance Mechanical
Classic Casting

9kt

GENERAL INFORMATION

Carats: 14kt, suitable also for 18kt (see specific tech data sheet) and 8, 9, 10kt (see specific tech data sheet)

Colour: intense red
 colour coordinates: L*=85.4 a*=10.6 b*=14.6

Advised use: universal (both mechanical works and casting)

MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■
CASTING	closed systems	■	open systems	■	pre-set stones			■

Density: 11.10 g/cm³

Hardness (as cast): 110 HV

Hardness (after cold work 70%): 225 HV

Hardness (after annealing): 101 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 960 °C

Casting temperature:

100 °C over its melting temperature to cast into ingot-mould and continuous casting

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

Ingot-mould temperature: 150 °C

Cylinders temperature: from 600 °C to 700 °C depending on the machine and objects dimensions

Cooling of ingots: quick in lukewarm water (about 40 °C)

Cooling casted objects: in water after 15 minutes

Annealing:

680 °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.