

5P18L/EN



**High Performance Mechanical
Classic Casting**

14kt

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*=84.2 a*=10.8 b*=15.0
Advised use: universal (both mechanical works and casting)

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

Density: 12.90 g/cm³
Hardness (as cast): 125 HV
Hardness (after cold work 70%): 230 HV
Hardness (after annealing): 120 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 930 °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 550 °C to 650 °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: 660 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

HINTS

❖ Recommended Pandora Alloys 14kt 5N 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.