

## 5P18L/EN



**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/cm<sup>3</sup>

**Hardness (as cast):** 105 HV

**Hardness (after cold work 70%):** 220 HV

**Hardness (after annealing):** 115 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.