

5P18/3



High Performance Mechanical
High Performance Casting

14 kt

GENERAL INFORMATION

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

Colour: intense red
colour coordinates: L*=85.0 a*=10.7 b*=15.0

Advised use: universal (both mechanical works and casting)
Special alloy for extra light items

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

Density: 12,85 g/cm³

Hardness (as cast): 141 HV

Hardness (after cold work 70%): 266 HV

Hardness (after annealing): 140 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 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 14 kt 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.