

## 5P18/C



Classic Casting

18 kt

### GENERAL INFORMATION

Carats: 18 kt, suitable also for 9kt and 14kt (see specific tech data)  
Colour: Red  
Colour coordinates: L\*=84.0 a\*=11.0 b\*=18.2  
Advised use: Casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 14,60 g/cm<sup>3</sup>

Hardness (as cast): 160 HV

Hardness (after annealing): 170 HV

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 910 °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

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

### HINTS

❖ Recommended Pandora Alloys 18kt 5N red solders: TRJ18

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.