

## 5P2022



Classic Mechanical

**21kt**

### GENERAL INFORMATION

Carats: 21kt, suitable also for 22kt (see specific tech data sheet)  
Colour: pink gold  
colour coordinates: L\*=83.9 a\*=11.9 b\*=21.7  
Advised use: mechanical works  
Secondary use: casting (if necessary usage of one alloy only)

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

Density: 16,57 g/cm<sup>3</sup>  
Hardness (as cast): 124 HV  
Hardness (after cold work 70%): 226 HV  
Hardness (after annealing): 120 HV

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 910 °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.

140 °C over its melting temperature to cast in outdoor cylinders with vacuum.

120 °C over its melting temperature to cast in vacuum machines with controlled atmosphere.

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.

Annealing: 620 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

### HINTS

❖ Recommended Pandora Alloys 5N red solders: TR5NJ (soft), MR5NJ (medium), FR5NJ (hard)

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.