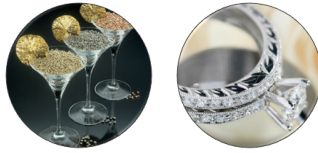


## AMR/PLUS



**High Performance Mechanical**  
**High Performance Casting**

**14kt**

### GENERAL INFORMATION

Carats: 14kt, suitable also for 18kt (see specific tech data sheet)  
 Colour: off white  
 Advised use: mechanical works

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

Density: 12,75 g/cm<sup>3</sup>  
 Hardness (as cast): 130 HV

Melting temperature: 940 °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 machine  
 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

Annealing: 650 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.), better if with alcohol

#### Age hardening:

**Step 1: solubilization**  
 720 °C for 30 minutes. Cooling quickly in lukewarm water (about 40 °C), better if with alcohol.  
**Step 2: hardening**  
 300 °C for 2 hours. Cooling at room temperature.

Nickel release UNI EN 1811:2011: Nickel release test on finished objects is required

#### HINTS

- ❖ Recommended Pandora Alloys 14kt white solders: TB14 (soft), MB14 (medium), FB14 (hard)
- ❖ Suggested Pandora Alloys plating solutions: Rhodium P2 and Palladium PDSOL/BE
- ❖

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.