

AMR/PLUS



High Performance Casting
 High Performance Mechanical

18 kt

GENERAL INFORMATION

Carats: 18 kt, suitable also for 14 kt (see specific tech data sheet)
 Colour: off white
 colour coordinates: L*=87.3 a*=3.4 b*=14.6
 Advised use: universal (both mechanical works and casting)

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

Density: 14,8 g/cm³
 Hardness (as cast): 180 HV
 Hardness (after cold work 70%): 275 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 920 °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 18 kt white solders: TB18 (soft), MB18 (medium), FB18 (hard)
- ❖ Suggested Pandora Alloys plating solutions: Rhodium P2 and Palladium PDSOL

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.