

AM/R



High Performance Mechanical

18 kt

GENERAL INFORMATION

Colour: white - standard
 Advised use: mechanical works; wire diameter 0,5 mm

MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■
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Density: 14,88 g/cm³
 Hardness: 195 HV
 Hardness (after cold work 70%): 291 HV
 Hardness (after age hardening): 249 HV

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

DIRECTIONS FOR SUGGESTED USE

Melting temperature in 18 kt: 920°C

Casting temperature:
 100°C over its melting temperature to cast into ingot-mould and continuous casting

Ingot-mould temperature: 150°C

Cooling of ingots: quick in lukewarm water (about 40°C)

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

Age hardening: 250°C for 3 hours, cooling at room temperature

HINTS

- ❖ Recommended Pandora white 18kt solders: TB18 (soft), MB18 (medium), FB18 (hard)
- ❖ Suggested plating solutions Pandora rhodium P2 and Pandora 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.