

A/O



Classic Mechanical

9kt

GENERAL INFORMATION

Colour: white – standard
 colour coordinates: L*=88.1 a*=1,93 b*=10,5

Advised use: mechanical works

MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■
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Density: 11,60 g/cm³
 Hardness (as cast): 150 HV
 Hardness (after cold work 70%): 281 HV
 Hardness (after annealing): 155 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 980 °C

Casting temperature:
 80 °C over its melting temperature for continuous casting with sinker thermocouple.
 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: 700 °C for 30 minutes followed by a quick cooling in hot water (40 °C min.), better if with alcohol

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

HINTS

- ❖ Recommended Pandora Alloys 9kt white solders: TB9 (soft), MB9 (medium), FB9 (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.