

**C/M**

**18 kt**

**GENERAL INFORMATION**

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

MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■
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Density: 14,58 g/cm<sup>3</sup>

Hardness: 180 HV

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

**DIRECTIONS FOR SUGGESTED USE**

Melting temperature: 900° 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: 620° C for 20 minutes followed by a quick cooling in hot water (40° C min.)

Hardening treatment: 280° C for 2 hours

**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.