

C/S14



Classic Casting

14kt

GENERAL INFORMATION

Carats: 14kt, suitable also for 18kt (see specific tech data sheet)
Colour: white - standard
colour coordinates: L*=81.1 a*=2.8 b*=10.3
Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 12,30 g/cm³
Hardness (as cast): 152 HV
Hardness (after annealing): 140 HV
Not age-hardenable

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

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 940 °C

Casting temperature:

100 °C over its melting temperature to cast with centrifugal machines.

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.

Cylinders temperature: from 550 °C to 650 °C depending on the machine and objects dimensions

Cooling casted objects: in water after 10 minutes

Cooling casted objects (with stones): in water after 30/40 minutes

Annealing: 670 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

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.