

C/S



Classic Casting

18 kt

GENERAL INFORMATION

Carats: 18 kt, suitable also for 14 kt (see specific tech data sheet)
 Colour: white – standard (Rhodium plating optional)
 Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 14,65 g/cm³
 Hardness (as cast): 180 HV

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

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 910°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

Annealing: 680°C for 20 minutes followed by a quick cooling in hot water (40°C min.)

HINTS

- ❖ Recommended Pandora white 18 kt 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.