

EASY/ECO



High Performance Casting

14kt

GENERAL INFORMATION

Colour: white - standard

Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 12,75 g/cm³

Hardness (as cast): 170 HV

Nickel release UNI EN 1811:2011: In 14 kt the final objects have to be tested.

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 930 °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 5 minutes

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

HINTS

- ❖ Recommended Pandora Alloys 18kt 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.