

E/C

GENERAL INFORMATION

Carats: 9 kt , suitable also for 14 kt (see specific tech data sheet) and for 18 kt (see specific tech data sheet)
 Colour: standard white
 Advised use: mechanical works

MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■
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Density: 11,00 g/cm³

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

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 920° C

Casting temperature:

100° C over its melting temperature to cast into ingot-mould and continuous casting.

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

140° C over its melting temperature to cast in outdoor cylinders with vacuum.

120° C over its melting temperature to cast in vacuum machines with controlled atmosphere.

Ingot-mould temperature: 150° C

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

Cooling of ingots: quick in lukewarm water (about 40° C)

Cooling casted objects: in water after 10 minutes.

Annealing:

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

HINTS

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