

EMV



High Performance Casting

18 kt

GENERAL INFORMATION

Colour: white - standard
 colour coordinates: L*=86.8 a*=2.6 b*=13.4
 Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 14,63 g/cm³
 Hardness (as cast): 181 HV
 Hardness (after annealing): 180 HV
 Hardness (after age hardening): 300 HV

Nickel release UNI EN 1811:2011: < 0,2 µg/cm²/week - **COMPLIANT** (max. 0.88 µg/cm²/week)

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 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.)

Age hardening: *Step 1: solubilization*
 720 °C for 30 minutes. Cooling quickly in lukewarm water (about 40 °C), better if with alcohol.
Step 2: hardening
 300 °C for 2 hours. Cooling at room temperature.

HINTS

- ❖ Recommended Pandora Alloys 18kt white solders: TB18 (soft), MB18 (medium), FB18 (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.