

EM



Classic Casting

14 kt

GENERAL INFORMATION

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

| | | | | | | |
|---------|----------------|---|--------------|---|----------------|---|
| CASTING | closed systems | ■ | open systems | ■ | pre-set stones | ■ |
|---------|----------------|---|--------------|---|----------------|---|

Density: 12,60 g/cm³
 Hardness: 165 Hv

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

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 900° C

Casting temperature:

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.

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

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 white 14kt solders: TB14 (soft), MB14 (medium), FB14 (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.