

## EM



Classic Casting

**18 kt**

### GENERAL INFORMATION

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

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 14,50 g/cm<sup>3</sup>  
 Hardness: 180 Hv

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

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 880° 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 18kt 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.