

ESL

GENERAL INFORMATION

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

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: n.a.
 Hardness: n.a.

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

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 910° C

Casting temperature:
 100° C over its melting temperature to cast with centrifugal machine.
 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.