

EXTRA3N

Universal Alloy

18kt

GENERAL INFORMATION

Colour: 3N yellow (**EN28654** Compliant)
 colour coordinates: L*=84.7 a*=7.6 b*=29.9

Advised use: Universal (both mechanical works and casting)

MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■
CASTING	closed systems	■	open systems	■	pre-set stones			■

Density: 15,10 g/cm³
 Hardness (as cast): 146 HV
 Hardness (after annealing): 140 HV
 Hardness (after age hardening): 251 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 880 °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
 120° C over its melting temperature to cast with 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 5 minutes
 Cooling casted objects (with stones): in water after 30/40 minutes

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

Age hardening: *Step 1: solubilization*
 680 °C for 30 minutes. Cooling quickly in warm water (about 40 °C).
Step 2: hardening
 300 °C for 2 hours. Cooling at room temperature

HINTS

- ❖ Recommended Pandora Alloys 3N yellow 18kt solders: T3NJ (soft), M3NJ (medium), F3NJ (hard)

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.