

## EXTRA5N



High Performance Casting

18kt

### GENERAL INFORMATION

Colour: 5N red (**EN28654** Compliant)  
 colour coordinates: L\*=83.2 a\*=10.3 b\*=20.3

Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 14,92 g/cm<sup>3</sup>  
 Hardness (as cast): 192 HV  
 Hardness (after annealing): 190 HV  
 Hardness (after age hardening): 307 HV

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 890 °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: 650 °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 18kt 5N red solders: TR5NJ (soft), MR5NJ (medium), FR5NJ (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.