

OTT.82/18MICROP

GENERAL INFORMATION

Carats: NONE - to be used without gold
 Colour: yellow
 colour coordinates: L*=86.5 a*=2.2 b*=18.1
 Advised use: casting

CASTING	closed systems <input checked="" type="checkbox"/>	open systems <input checked="" type="checkbox"/>	pre-set stones <input checked="" type="checkbox"/>
---------	----------------------------------------------------	--------------------------------------------------	----------------------------------------------------

Density: 8,34 g/cm³
 Hardness (as cast): 153 HV
 Hardness (after annealing): 150 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature (Solidus – Liquidus): 832 - 930 °C

Casting temperature:
 100 °C over its Liquidus temperature to cast with centrifugal machines and vacuum machines with controlled atmosphere.
 140 °C over its Liquidus 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: 660 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.)

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.
 Tech Chart and Safety Data Sheet available on our website www.pandoralloys.com.