

PD130C



High Performance Casting

18 kt

GENERAL INFORMATION

Colour: premium white
 Advised use: casting
 Secondary use: mechanical works (if necessary usage of one alloy only)

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

Density: 15.85 g/cm³
 Hardness (as cast) : 185 HV

Nickel release UNI EN 1811:2011: not required, palladium alloy nickel-free

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 1025° C

Casting temperature:
 100° C over its melting temperature to cast with every kind of machine.
 150° C over its melting temperature to cast into ingot-mould and continuous casting.

Cylinders temperature: 720° C depending on the machine and objects dimensions.

Ingot-mould temperature: 150° C

Cooling casted objects: in water after 10 minutes.
 Cooling of ingots: quick in lukewarm water (about 40° C)

Annealing: 700° C for 30 minutes followed by a quick cooling in hot water (40° C min.)

Hardening treatment: 350° C for 60 minutes

HINTS

❖ Recommended Pandora white palladium 18kt solders: TBJPD (soft), MBJPD (medium), FBJPD (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.