

PD325ECO2



High Performance Casting
 High Performance Mechanical

14 kt

GENERAL INFORMATION

Carats: 14kt, suitable also for 18kt (see specific tech data sheet)
 Colour: white color coordinates: L*=84.4 a*=5.3 b*=14.6
 Advised use: universal (both casting and mechanical works)

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

Palladium content: 13% in 1kg of alloy – 5,40% in gold 14kt
 Density: 13,30 g/cm³
 Hardness (as cast): 180 HV
 Hardness (after cold work 70%): 282 HV

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

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 920 °C

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

Cylinders temperature: 700 °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: 650 °C for 30 minutes followed by a quick cooling in hot water (40 °C min.)

HINTS

- ❖ Recommended Pandora white palladium 14kt solders: TBJPD (soft), MBJPD (medium), FBJPD (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.