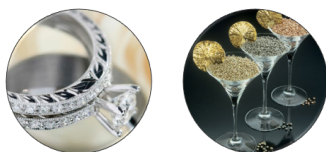


## PD325ECO2



High Performance Casting  
 High Performance Mechanical

**18kt**

### GENERAL INFORMATION

Carats: 18kt, suitable also for 14kt (see specific tech data sheet)  
 Colour: white  
 colour coordinates: L\*=82.5 a\*=6.5 b\*=16.5  
 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 – 3,25% in 18kt gold  
 Density: 15,07 g/cm<sup>3</sup>  
 Hardness (as cast): 167 HV  
 Hardness (after cold work 70%): 260 HV  
 Hardness (after annealing): 160 HV  
 Hardness (after age hardening): 251 HV

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

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 940 °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: from 600 °C to 700 °C depending on the machine and objects dimensions.

Ingot-mould temperature: 150 °C

Cooling casted objects: in water after 10 minutes.  
 Cooling casted objects (with stones): in water after 30/40 minutes.  
 Cooling of ingots: quick in lukewarm water (about 40 °C)

Annealing: 670 °C for 30 minutes followed by a quick cooling in hot water (40 °C min.)

Age hardening: *Step 1: solubilization*  
 720 °C for 30 minutes. Cooling quickly in lukewarm water (about 40 °C), better if with alcohol.

*Step 2: hardening*  
 300 °C for 2 hours. Cooling at room temperature.

### HINTS

- ❖ Recommended Pandora Alloys 18kt white Palladium solders: TBJPD (soft), MBJPD (medium), FBJPD (hard)
- ❖ Suggested Pandora Alloys plating solutions: Rhodium P2 and 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.