

## PD625L



**High Performance Casting**  
**High Performance Mechanical**

**14 kt**

### GENERAL INFORMATION

Carats: 14kt, suitable also for 18kt (see specific tech data sheet) and 9kt (see specific tech data sheet)  
 Colour: white - standard  
 Advised use: universal (both casting and mechanical works)

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

Palladium content: 25% in 1kg of alloy – 10% in gold 14kt  
 Density: 13,40 g/cm<sup>3</sup>  
 Hardness (as cast): 150 HV  
 Hardness (after cold work 70%): 255 HV  
 Hardness (after annealing): 148 HV

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

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 1100 °C

#### Casting temperature:

100 °C over its melting temperature to cast into ingot-mould and continuous casting  
 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: ~ 700 °C depending on the machine and objects dimensions.  
 Ingot-mould temperature: 150-200 °C

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

Annealing: 760 °C for 30 minutes followed by a quick cooling in hot water (40 °C min.)

### HINTS

❖ Recommended 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.