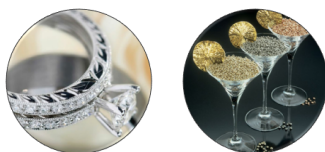


PD625L



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*=82.3 a*=3.8 b*=16.0
 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 – 6,25% in 18kt gold.
 Density: 15,25 g/cm³
 Hardness (as cast): 147 HV
 Hardness (after cold work 70%): 251 HV
 Hardness (after annealing): 145 HV
 Not age-hardenable

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

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 955 °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: 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: 720 °C for 30 minutes followed by a quick cooling in hot water (40 °C min.)

HINTS

- ❖ Recommended Pandora Alloys 18kt white Palladium solders: TBJPD (soft), MBJPD (medium), FBJPD (hard)
- ❖ 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.