

ROLLY_C

GENERAL INFORMATION

Colour: standard white
 colour coordinates: $L^*=85.5$ $a^*=2.5$ $b^*=13.5$
 Advised use: mechanical works

MECHANICAL WORKS	stamping	■	chains	■	tube	■	spring	■
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Density: 14,56 g/cm³
 Hardness (as cast): 175 HV
 Hardness (after cold work 70%): 310 HV
 Tensile strength (Rm): 510 [Mpa]

DIRECTIONS FOR SUGGESTED

USE Melting temperature: 920 °C

Casting temperature:

80 °C over its melting temperature for continuous casting with sinker thermocouple.
 100 °C over its melting temperature to cast into ingot-mould and continuous casting

Ingot-mould temperature: 150 °C

Cooling of ingots: quick in lukewarm water (about 40 °C)

Annealing: 660 °C for 25 minutes followed by a quick cooling in hot water (40 °C min.), better if with alcohol

Nickel release UNI EN 1811:2011 0,14 µg/cm²/week (max. 0,88 µg/cm²/week)
 Compliant results in internal tests.
 Tests on finished objects are compulsory as per the European Rule

HINTS

- ❖ Recommended Pandora Alloys 18kt white solders: TB18 (soft), MB18 (medium), FB18 (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.