

SUPERWHITE



Classic Casting

18kt

GENERAL INFORMATION

Carats: 18kt, it is possible to improve quality by adding silver in accordance with the following proportions:
 750‰ Au + 30‰ Ag + 220‰ **SUPERWHITE**
 Suitable also for 14kt (if necessary usage of one alloy only);
 to get an optimal result add a small amount of silver:
 585‰ Au + 50‰ Ag + 365‰ **SUPERWHITE**

Colour: white – premium

Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 14,62 g/cm³
Hardness (as cast): 209 HV
Hardness (after silver addition): 190 HV
Hardness (after annealing): 200 HV
 Not age-hardenable

Nickel release UNI EN 1811:2011: Nickel release test on finished objects is required

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 950 °C
Melting temperature (after silver addition): 920 °C

Casting temperature:

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

Cooling casted objects: in water after 10 minutes
Cooling casted objects (with stones): in water after 30/40 minutes

Annealing: 680 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.), better if with alcohol

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.