

T13/C



High Performance Casting

9kt

GENERAL INFORMATION

Carats: 9kt , suitable also for 14kt (see specific tech data sheet)
 Colour: white – standard
 Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
---------	----------------	---	--------------	---	----------------	---

Density: 11,30 g/cm³
 Hardness (as cast): 158 HV
 Hardness (after annealing): 150 HV
 Hardness (after age hardening): 261 HV

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

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 960 °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.)

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 9kt white solders: TB9 (soft), MB9 (medium), FB9 (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.