

## T15/B

### GENERAL INFORMATION

Carats: 14 kt , suitable also for 18 kt (see specific tech data sheet)  
 Color: white  
 Advised use: mechanical works  
 Secondary use: casting (if necessary usage of one alloy only)

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

Density: 12,40 g/cm<sup>3</sup>

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

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 930° 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.  
 140° C over its melting temperature to cast in outdoor cylinders with vacuum.  
 120° C over its melting temperature to cast in vacuum machines with controlled atmosphere.

Ingot-mould temperature: 150° C

Cylinders temperature: from 550° C to 650° C depending on the machine and objects dimensions.

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

Cooling casted objects: in water after 10 minutes.

Annealing: 700° C for 20 minutes followed by a quick cooling in hot water (40° C min.)

### HINTS

- ❖ Recommended Pandora white 14kt solders: TB14 (soft), MB14 (medium), FB14 (hard)
- ❖ Suggested plating solutions Pandora rhodium P2 and Pandora 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.