

T15/M

18 kt

GENERAL INFORMATION

Carats: 18 kt, suitable also for 14 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: 14,00 g/cm³
 Hardness: 200 HV

DIRECTIONS FOR SUGGESTED USE

Melting temperature: 920° 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: 620° C for 20 minutes followed by a quick cooling in hot water (40° C min.)

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

HINTS

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