

WHIC



Classic Casting

14kt

GENERAL INFORMATION

Carats: 14kt, suitable also for 18kt (see specific tech data sheet)
 Colour: white – standard
 colour coordinates: L*=85.2 a*=1.3 b*=10.8
 Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 12,28 g/cm³
 Hardness (as cast): 156 HV
 Hardness (after annealing): 152 HV
 Not age-hardenable

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

DIRECTIONS FOR SUGGESTED USE

Melting range (Solidus – Liquidus): 883 - 950 °C

Casting temperature:
 100 °C over its Liquidus temperature to cast with centrifugal machines.
 120 °C over its Liquidus temperature to cast in vacuum machines with controlled atmosphere.
 140 °C over its Liquidus 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: 700 °C for 20 minutes followed by a quick cooling in hot water (40 °C min.), better if with alcohol

HINTS

- ❖ Recommended Pandora Alloys 14kt white solders: TB14 (soft), MB14 (medium), FB14 (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.