

## WHIC



Classic Casting

**18kt**

### GENERAL INFORMATION

Carats: 18kt, suitable also for 14kt (see specific tech data sheet)  
 Colour: white – standard  
 Advised use: casting

CASTING	closed systems	■	open systems	■	pre-set stones	■
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Density: 14,75 g/cm<sup>3</sup>  
 Hardness (as cast): 178 HV  
 Hardness (after annealing): 175 HV  
 Not age-hardenable

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

### DIRECTIONS FOR SUGGESTED USE

Melting temperature: 900 °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 550 °C to 650 °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: 650 °C for 30 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.