

Master Alloy: Pd150 (10K, 14K & 18K)

Product No./產品型號: Pd150 ; (without nickel, 不含鎳)

Complies with EN 1811:2011 Standards

合金特性 Alloy Characteristics	10K	14K	18K
Density 密度 (g/cm ³)	11.30	13.09	14.30
Hardness 硬度 – As Cast (Hv) 未加工 (Hv)	199	126	<100
Hardness 硬度 – Cold worked, Reduced 60% (Hv), 冷加工減少 60% (Hv)	>250	241	169

建議鑄造參數 Recommended Investment Casting Parameters	10K	14K	18K
Casting Temperature Range (°C) 澆鑄溫度範圍	1191-1235	1177-1232	1066-1110
Flask Temperature Range (°C) 燒粉溫度範圍	425-735	425-735	425-735
Quench Time (min.) 淬火時間	20	20	20
Re-alloying Scrap Percentage(%) 合金翻新比例	<75	<75	<75

建議首飾樹的清潔及風乾步驟 Recommended Cast Tree Cleaning and Drying Procedure

After a preliminary removal of the investment powder during quenching, submerge trees in a hot (80-100°C) 50% phosphoric acid solution for 15-20 minutes. Rinse well with cool water to remove any remaining investment powder and base metal oxides. Dry with compressed air.

Do not dry trees in any type of furnace!

首先清潔首飾樹上的粉末，然後把首飾樹浸泡於攝氏 80 至 100 度，50% 磷酸約 15-20 分鐘。之後再用清水徹底清潔，最後用壓縮空氣吹乾。

切勿把首飾樹放進任何爐具烘乾!

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