

Master Alloy: Pd250 (10K, 14K & 18K)

Product No./產品型號: Pd250 ; (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)	13.10	14.55	15.93
Hardness 硬度 Cold worked, Reduced 60% (Hv), 冷加工減少 60% (Hv)	228	195	168
Hardness 硬度 Reduced 60%, Annealed 15 mins at 680C, Water quenched 水冷卻, 於 680 度退火 15 分鐘, 減少 60% (Hv)	144	<100	<100
Hardness 硬度 Reduced 60%, Annealed 15 mins at 680C, Air cooled 空氣冷卻, 於 680 度退火 15 分鐘, 減少 60% (Hv)	195	<100	<100

建議鑄造參數

Recommended Investment Casting Parameters	10K	14K	18K
Casting Temperature Range (°C) 澆鑄溫度範圍	1160	1175	1195
Quench Time (min.) 淬火時間	15	15	15

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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