

INSTRUCTIONS FOR USE

CX-71

A 1700° F Investment

MICRO-FINE HIGH HEAT C&B CASTING INVESTMENT

PHYSICAL PROPERTIES:

Liquid to powder ratio: 24 – 25 ml to 100 g powder

Setting Time: 6 to 10 min. at 72F.

Setting Expansion: 2.0 to 2.4 % @ liquid dilution 2:1

Thermal Expansion @ 700 C: 1.2%

Liquid Dilution:

<u>Non-Precious Alloys: 80% Liquid, 20% water</u>	<u>Mix 20 to 30 Seconds at 400 rpm</u>
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<u>For Gold Alloys: 60% Liquid, 40% water</u>	<u>Mix 45 to 60 Seconds at 400 rpm</u>
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To INCREASE expansion: Use more liquid and less water. Keep the total amount of mixing liquid the same as in the chart. **OR Reduce mixing time in 15 seconds intervals. Do not reduce mixing time below 15 seconds.**

To DECREASE expansion: Use more water and less liquid. Do just the opposite of the technique for increasing expansion above. **OR increase mixing time in 15 seconds intervals. Do not mix more than 60 seconds.**

General Mixing Directions: Liquid and powder temperatures should be about 72 degrees F. Hand Spatulate powder into liquid 20 seconds. Mix under vacuum for 30 to 60 seconds. Use low speed mixers, about 400 rpm. Hold under vacuum for another 30 seconds. Pour into the casting ring.

Chill liquid and/or powder to increase working time when the lab temperature is above 75 degrees F.

Fast 1-hour Burn-out: Preheat oven to 1400 to 1600 F. After 20 minutes bench set place the mold in the oven. Hold for about 60 minutes and cast as usual.

Slow Burn-out: Bench set the mold for 20 to 30 minutes. Use 2-stage burnout. First stage: Raise temperature slowly at 10 to 15 degrees F per minute to 600 degrees F. hold for 15 minutes. Second stage: Raise temperature 15 to 20 degrees F to casting mold temperature. Hold for about 30 minutes and cast.

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