

emdin | instructions

CASTRITE-220

A micro fine-grained casting investment for Platinum jewelry and Stainless Steel

Instructions for use

1. Line the flask with asbestos or ceramic liner. The liner is used to provide cushion to allow uniform expansion of the investment and also to protect the flask during devesting. The liner should be placed in the flask so that the inside of the flask is covered within 1/2 inch of top and bottom.

2. Place a collar made of flexible rubber or ordinary gummed tape around the top of the flask to extend about 2-1/2 inch above flask. A 3 inch wide collar will be adequate.

3. Place the flask on sprue base holding mounted wax patterns.

4. Mix the investment (water/powder ratio:: 38 parts water/100 parts powder.).

Add powder slowly into water and mix at low to medium speed. Mix until the slurry is creamy thin. It may take about 1/2 hour for the slurry to achieve a creamy consistency.

5. Vacuum the slurry in the bowl for 6~90 seconds at full vacuum. Then fill the flask up to the collar and repeat vacuum step. Add sufficient investment to fill the collar about 1-1/2 above the flask.

6. Let the invested flask stand, undisturbed, in dry warm room for 4 to 6 hours. Now pour off excess water. let flask stand overnight when the top of the flask would have become hard and dry. Now remove the collar, carefully trim excess investment flat and flush to the flask level.

7. Place the flask in cold furnace and raise the temperature slowly at a rate of about 200 degrees F (90 to 100 degree C)per hour to 1600 degrees F (870 C). Cast the flask either centrifugally or with vacuum assist at the desired flask temperature.

Allow the flask to cool to room temperature, until it can be safely handled with tongs or gloves. Do not plunge the flask into water, while it is hot. because this action may cause cracking of the castings.

Remove investment using standard devesting procedures.

Manufactured by:

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