

emdin | instructions

CASTRITE - C B

MICRO-FINE HIGH-HEAT CROWN & BRIDGE CASTING INVESTMENT

Instructions for use

GENERAL MIXING DIRECTIONS

Hand Spatulate powder into liquid thoroughly, then mix under vacuum on low speed mixers (200 to 450 rpm) for 60 to 90 seconds. Always monitor the liquid and powder temperatures before mixing. Hold under vacuum for another 30 seconds before pouring into the casting ring.

If the material appears to be setting too fast reduce mixing time to as low as 30 to 45 seconds or cool the liquid to desired temperature as explained elsewhere.

BURN-OUT

Burn-out: After 20 to 30 minutes bench set place the mold directly in a cold oven. Raise temperature slowly at 7 to 10 degrees F per minute to casting temperature of 900 to 1200 degrees F; hold for about 30 minutes and cast.

ADJUSTING EXPANSION

To INCREASE expansion: Use more liquid and less water. Keep the total amount of mixing liquid the same as in the chart.

To DECREASE expansion: Use more water and less liquid. Do just the opposite of the technique for increasing expansion above.

FOR BEST RESULTS

The average of the temperatures of the LIQUID and the POWDER should be 72 Degrees F. If the POWDER temperature is TOO HIGH then the LIQUID temperature should be LOWERED so that the AVERAGE of the TWO is about 72 Degrees F.

WARNINGS:

DO NOT USE FAST BURN-OUT.

DO NOT USE RINGLESS PROCESS.

PHYSICAL PROPERTIES

Liquid to Powder Ratio: 27 to 100

Liquid Dilution: See directions

Working Time: 5 minutes min. at 72F

Setting Time: 8 to 12 min. at 72F

Setting Expansion: 1.7 to 2.4 %

Thermal Expansion: @700 C: 1.6-1.8%

LIQUID DILUTION

Non-precious Alloys		
Powder	Liquid, ml	Water, ml
60g	13.0	3.0
90g	19.5	5.0
100g	21.5	5.5
160g	34.5	8.5
High Noble Alloys (Gold over 60%)		
Powder	Liquid, ml	Water, ml
60g	10.0	6.0
90g	15.0	9.0
100g	16.0	11.0
160g	26.0	17.0
Semi-Precious alloy (Gold < 60%)		
Powder	Liquid, ml	Water, ml
60g	6.0	10.0
90g	9.0	15.0
100g	11.0	6.0
160g	17.0	26.0

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