JPL
JEWELRY PLASTER

SILK CAST (Diamond)

INVESTMENT POWDER

SILK CAST DIAMOND LABEL

Our new product is the high end Investment powder formulated for casting white goldpalladium and white gold-nickel jewelry. It can withstand high temperature and gives a very fine surface finish.

Product Packaging :

DRUM : 45.4 kg. (100 lb.)
PP SACK : 22.7 kg. (50 lb.)

MIXING INSTRUCTIONS

CONVENTIONAL MIXING

Add powder to water and mix				Vacuum Mixing Bowl	Pour into Flask	Vacuum Flask		Setting time			Gloss off			
1	2	3	4	5	6	7	8	9	10	11	12	13	14	minutes
Add powder to water and mix				Fill into Flasks		Vacuum Flask		Setting time			Gloss off			

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TECHNICAL DATA

POWDER / WATER RATIO	100/38
WORKING TIME @ 25°C SLURRY TEMP.	7-8 min.
GLOSS OFF TIME @ 25°C SLURRU TEMP.	12-14 min.
THERMAL EXPANSION AT 750°C	0.69%
SETTING EXPANSION AFTER 2 HOURS	0.49%
VOLUME YIELD PER KG. OF POWDER	755 ml.

DEWAX CYCLE

SILK CAST can be both dry and steam dewaxed with excellent results. As a general rule the larger the flask the longer the dewax time. Dry dewax in a furnace should take place at about 230°C. For a 6"x4" jewelry mold, 3 hours will be sufficient to remove the bulk of the wax and 2 hours should be sufficient for steam dewax.

CASTING

After completion of burnout, the flask should be cooled to proper casting temperature. The flask can then be cast by either centrifugal or vacuum casting methods. Temperature of the last 1-2 hours of burnout must be adjusted at correct temperature for casting. If held for less than 1 hour, the core of the flasks will be at a much higher temperature, and may result in metal mould reaction.

CASTING CONDITIONS

The casting temperature varies considerable depending on the size of wax piece and type of metal to be cast. Please contact us for our recommendations.

BURNOUT CYCLE

Burnout cycles will depend very much on the size of the flask. The larger the flask or the waxes therein the longer and more gradual the burnout must be. For 6"x4" mould will only need 7 hours. In addition the furnace must have a good supply of air in order to achieve a clean burnout. Carbon deposits from the wax must combine with oxygen to form CO_2 and thus excape through the pores of the investment. If after Burnout your mould is a gray colour you need to get more air into the furnace-do not increase the temperature, this will only sufficient for steam dewax. damage the investment.

Note

NEVER INCREASE THE FURNACE TEMPERATURE ABOVE 750°C