



## Plaster-bound embedding compound for precision casting in accordance with the lost wax moulding principle

### GILCAST AM offers:

- Advantageous processing consistency
- Smooth cast surfaces with ideal detail reproduction
- Easy mould removal
- Particularly suitable for processing light metal and non-ferrous metal alloys
- Ideal for vacuum casting systems
- Consistent quality

### Characteristics

#### Mixing ratio:

Powder : water:	1kg : 0.28 – 0.30 l
= Mixing volume:	0.585 – 0.595 l
Density:	2.22 – 2.213 kg/l
Mixing time:	1 – 3 min
Processing time:	approx. 10 min
Curing time prior to lost wax process:	min.60 minutes
Heating rate:	60 – 100 °C/h
Preheating temperature:	min. 400 to max. 750 °C
Holding time at final temperature per cm layer thickness:	approx. 1 hour

### Processing

Sprinkle **GILCAST AM** into the prepared water, stir briefly and mix for 60 seconds using a vacuum stirrer if possible. The use of water with high degrees of hardness may extend the processing time a little. Warm water (30 – 35 °C) shortens the processing time.

Under slight vibration and, if possible, under vacuum, the prepared embedding compound is poured into the casting vessel with correctly prepared wax or plastic patterns. One hour after starting the mixing procedure, the wax in the casting vessels

can be completely dissipated by evaporation or by heating to 180 °C with a corresponding waiting time at this temperature. The temperature in the preheating furnace is then slowly increased as specified above and the final temperature maintained corresponding to the size of the casting vessel. For the casting of magnesium alloys, you have to flood the casting vessels with SF 6 – gas before the casting of the metal.

Depending on the type of alloy, the casting can be removed mechanically after cooling to room temperature or by placing in water after the glow colour of the alloy has disappeared.

### Caution:

**This embedding compound contains quartz and cristobalite. Therefore avoid inhaling dust!**

### Storage life

Minimum 12 months in well sealed, moisture-proof packing drums. Material that was stored at a temperature other than room temperature should be allowed to acclimatise for several hours at 20 – 23 °C prior to use.

Longer storage periods at temperatures in excess of 30 °C can impair the storage stability.

### Packing

Paper bags with a liner 25 kg

This information is provided to the best of our knowledge and is based on comprehensive testing. We guarantee the quality of our products in accordance with specifications, however, we can accept no liability for the results of further processing that are generally outside our sphere of influence.

