



Special investment for the precision casting after wax elimination

Especially suitable for use with alloys with liquid temperatures above 1200°C

Characteristics

| | |
|-------------------------------------|----------------------------|
| Appearance | powder |
| Mixing ratio powder : water | 3,3 - 4,5 kg : 1 l |
| Mixing time | 1 min |
| Working time | app. 6 min |
| Solidification point | app. 30 min |
| Hardening time before burnout: | at least 60 min |
| Rate of heating | 60 - 100° C/h |
| Final temperature | 400 – 750° C |
| Hold period at final temperature | app. 1 h/cm of the form |

Working instructions

Strew **GILVEST T** in the above mentioned ratio into the water, spatulate briefly and mix there after 1 minute with an electric mixer. Do not trap air! Pour the

mixed investment into the casting flask with the competently prepared wax model.

Useful hints

Use only clean mixing tools and container, do not mix with set material.

In order to prevent cracking observe the given rate of heating.

Packaging

Paperbag with foil liner 25 kg

Shelf life

At least 12 months in well closed, vapour proof packages.

Attention

This investment contains quartz and cristobalite, therefore avoid inhaling dust when handling the powder.

The above recommendations are given to the best of our knowledge. We grant the quality of our products according to our specification. Any further liability cannot be accepted since the proper application of our products is outside of our control.