



Magnesia bound investment for titanium casting process suitable for casting technical products.

Characteristics

Appearance powder

Mixing ratio

Vacuum mixing 100 g powder : 18 ml distilled water

Conventional mixing 100 g powder : 20 ml distilled water

= Mixing volume 0,043 – 0,045 l

Density 2,74 – 2,67 kg/l

Mixing time app. 1 min

Working time app. 6 min

Solidification point app. 20 min

Hardening time before burnout: at least 120 min

Rate of heating 6° C/min

Final temperature 820 – 850 °C

Hold period at final temperature 1 h

Casting temperature 250 – 400 °C

Useful hints

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

