



Gypsum bound investment for aluminium and its alloys

- Advantageous working consistency
- Smooth casting surface with optimum definition of all details
- Use of low-pressure-casting possible
- Constant quality

Characteristics

Mixing ratio powder : water	1 kg : 280-300 g
Working temperature	app. 20° C
Working time	app. 10 min.

Hardening time before burnout	60 min.
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Rate of heating depending on size of the mould	60 - 100 °C/h
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Burnout temperature	app. 450° C
Burnout time	app. 4 h

Working method

Apply a release agent to the pattern and position it in a suitable moulding box.

Strew GILCAST ND in the given ratio into the water and mix thoroughly for 1 - 2 min., preferably with a vacuum mixer.

Pour the mixed investment into the moulding box taking care to avoid air bubbles, which would adhere to the pattern. Demould the pattern after solidification and heat the GILCAST-mould after one hour to approximately 450° C. After the hold period of approx. 4 hours the GILCAST-mould has to be cooled to 200° C if a hearth casting follows, respectively to a temperature beneath 70° C, if low pressure casting is applied.

Packing

Plastic pail	20 kg
Paper bag with foil liner	25 kg

Attention

- Do not mix GILCAST ND with other products.
- GILCAST ND contains quartz and cristobalite.
- Do not inhale dust!

Shelf life

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

The above recommendations are given to the best of our knowledge after careful control. 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.