

Main sprue and feeder sprues

Use a thicker feeder sprue than usual to accelerate a clean burnout of the resin in the flask. Additional feeder sprues are also recommended. This ensures that oxygen and heat reach the resin faster and it starts to ignite earlier.

Use a thicker main sprue than usual for the resin casting tree. Create small casting trees with a maximum of 10 models. Reduce the number for thick models, such as signet rings, as the burn-out process can take a long time. The more resin models there are on a tree, the longer the burnout process takes.

Investment powder

Kalman Hafner recommends "Prestige OPTIMA" from "CERTUS" as the investment material. Alternatively, "R + R Plasticast" can also be used. It is important to add 3% boric acid to the water.

To do this, boil the boric acid with distilled water and allow the boric acid-water mixture to cool to room temperature (21 - 24 ° C).

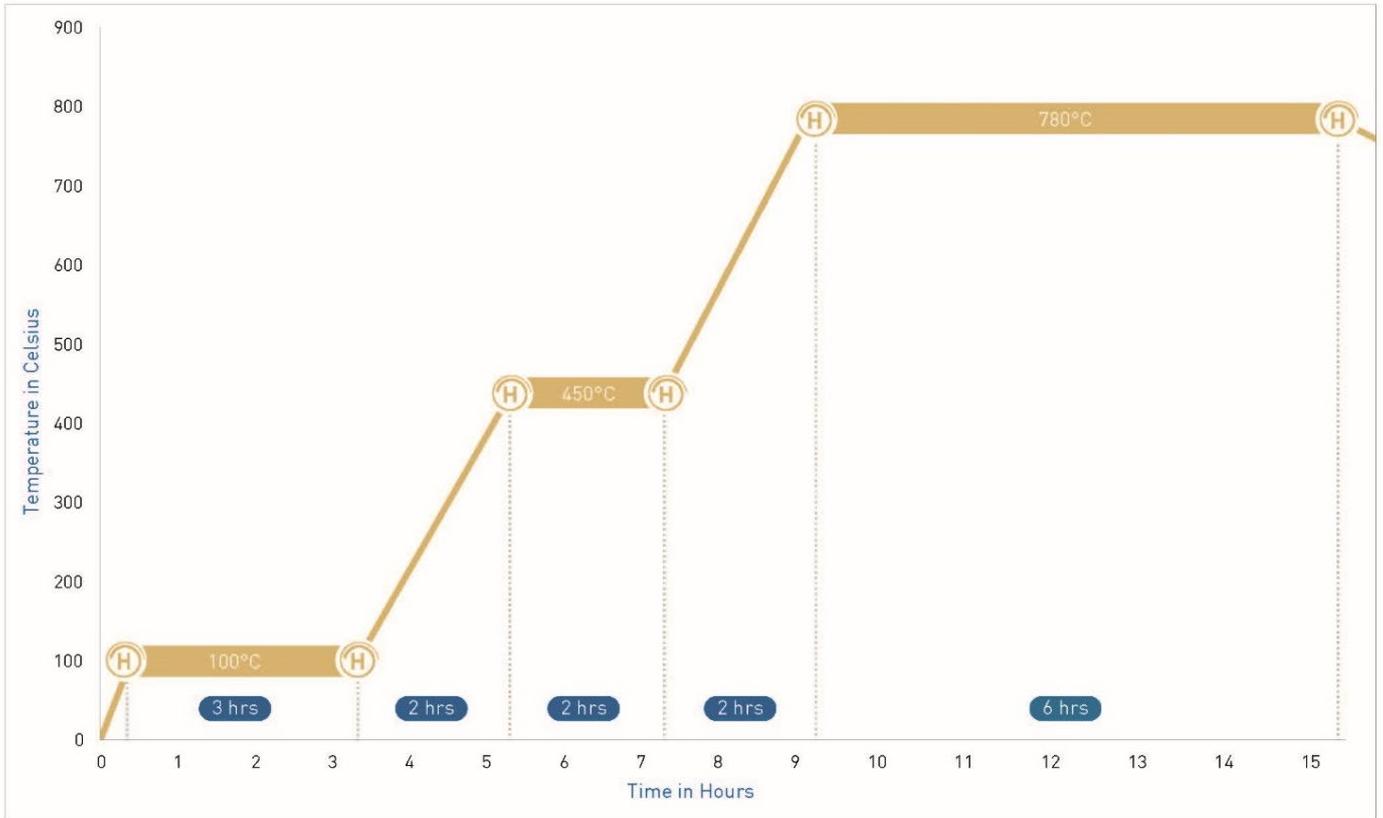
This increases the hardness of the investment and ensures a less spongy texture. The mixing ratio is as follows:

Water: Boric acid ratio 3%	Boric acid (g)	Water (g)
	30	1000
Investment material: Water ratio 38-40%	Powder (kg)	Water (g)
Automatic vacuum Mixer	1	380
Standard Mixer	1	400
Temperature °C	21 - 24	21 - 24

After investing under vacuum, the casting flasks should not be moved for at least 120 minutes.

Burnout

Place the flask in the oven with the opening facing down. Make sure that air can circulate at the opening. The resin burnout curve differs from conventional wax burnout. A higher maximum temperature of 780 ° C is used. This temperature should be maintained for at least six hours. If there are more models on the casting tree, it is recommended to extend the holding time at 780 ° C from six to eight hours.



CAST AWAY BURNOUT CURVE