

6. Preheating(Burn-out)

	Press investment
Setting time	min. 30 min., max. 45 min.
Preheating furnace temperature	850°C (1562°F) ; Switch on the preheating furnace in time
Position of the investment ring in the preheating furnace	Towards the rear wall, tipped with the opening facing down
Final temperature upon preheating the investment ring	850°C / 1562°F
Holding time of the investment ring at the temperature	100g investment ring - min. 45 min. 200g investment ring - min. 60 min.
Ingots	no preheating
Plunger	no preheating