



Shenzhen Yongchanghe Technology Co., Ltd
www.jamghe.com



Tel:0755-61148991/61148992

Fax:0755-61148993

Website: www.jamghe.com

Adress:3F,Building 14,Longwangmiao Industrial Zone,
Fuyong Town, Baoan District, Shenzhen, China.



In order to understand investment casting very well, we make this operation brochure of the whole casting process, be free to reach us if you have any query.



Preparation

Put the jobs in isopropanol a few mins, and slightly shake the jobs to clean away the resin.

Post cure the clean jobs if they are not hard enough.

1. Wax tree

1.1 Remove unnecessary support before plant wax tree and rewash again.

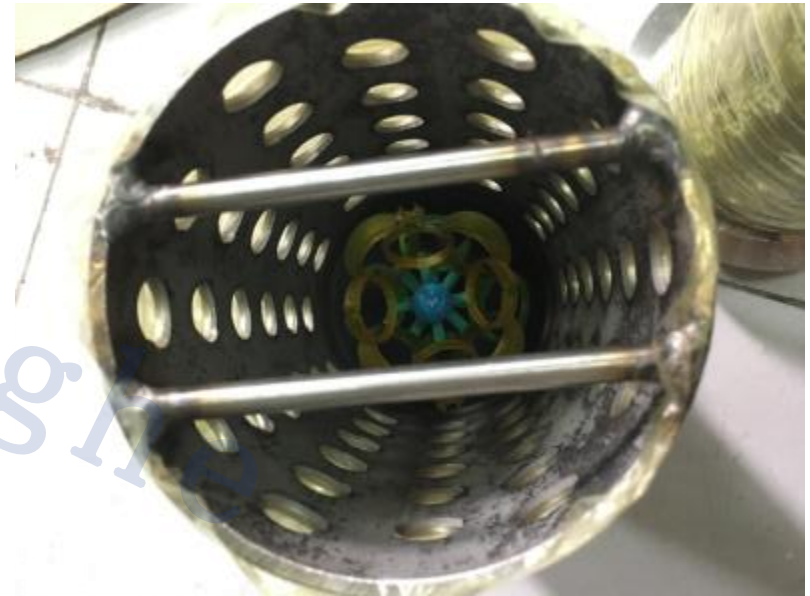
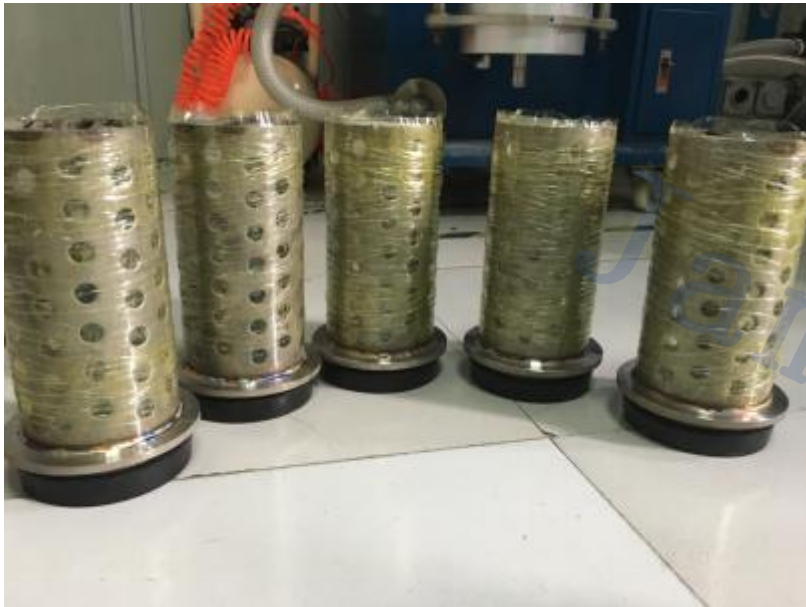
1.2 After cleaning, make sprue with each job and build into a tree.

Notice: simple jobs should be on top while complex job at downward.



2. Set up Flask

- 2.1 Wrap up the flask with packing tape, leave the top about 2-3mm longer than flask.
- 2.2 Put the wax tree into flask, keep the tree straight in the middle, the interspace between the flask and tree at least 5mm.



3. *Mixing gypsum*

3.1 Use ratio powder and water 1kg:350-400ml (20 °C to 28 °C pure water)

3.2 Firstly pour half of water into vacuum mixer, then pour gypsum powder, and the rest of the water, should be mixed completely at once.

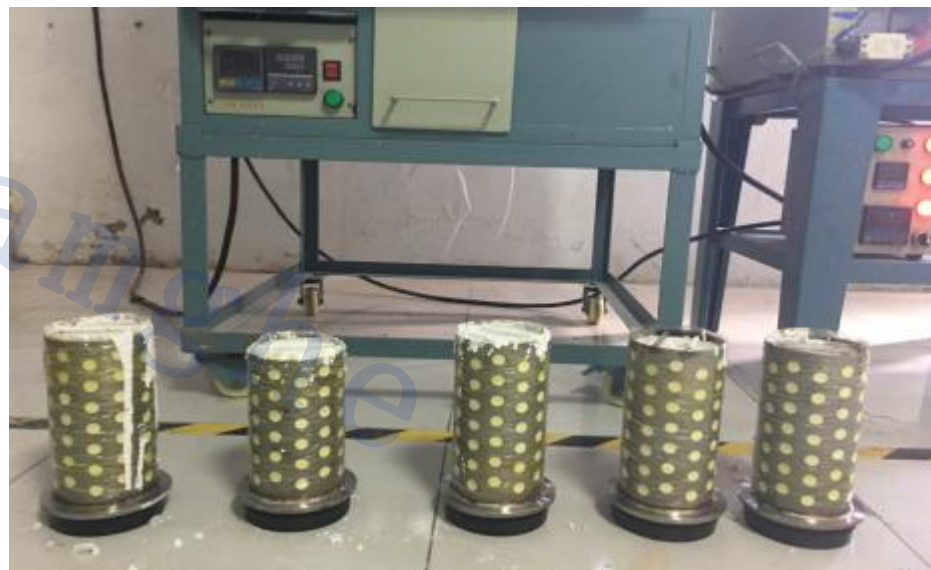
Notice: Recommend plasticast powder, or specially made for resin casting use purpose.



4. Fill flask

4.1 This should be strictly controlled within 9 minutes, fill flask by vacuum mixer, wait for no bubble about 20-30 mins.

4.2 Set flask at room temperature for 3 hours, take off the packing paper once it's dried.



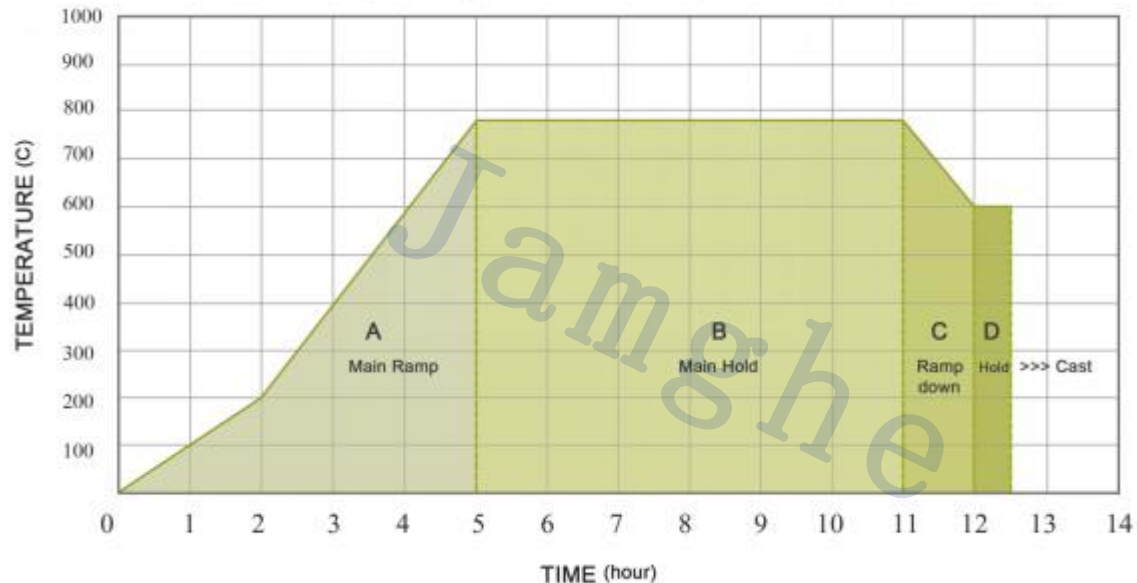
5. Burnout cycle 1

The First Method:

A: Wax model start fall off, set the temperature two hours from 0 °C to 200 °C, then three hours from 200 °C to 780°C, ramp up speed should be adjusted according to number and volume of flask and thickness of jobs.

B: Keep at 780 °C for 6 hours to be gasified completely, the holding time should be adjusted according to number and volume of flask and thickness of jobs.

Jewelry casting resin burnout cycle 1st method





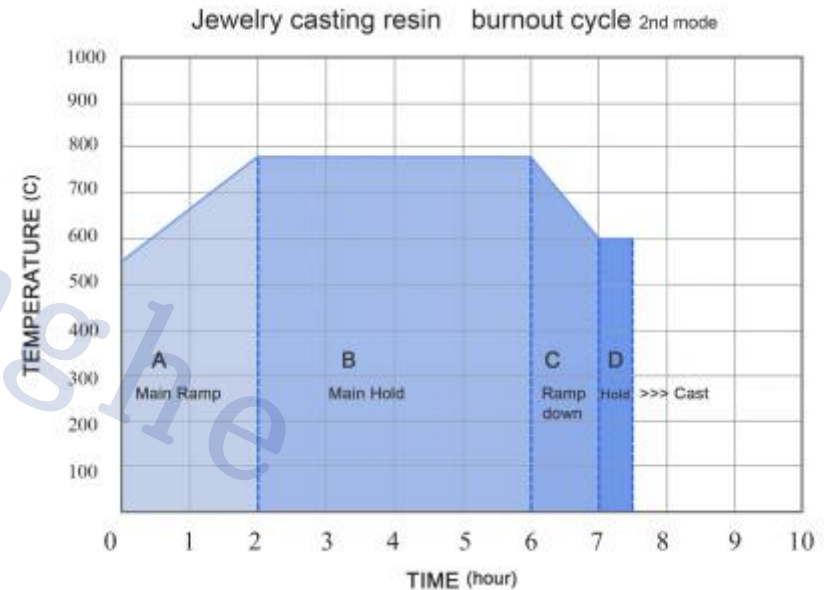
Burnout cycle 2

The Second Method:

A: Place flask in 500 °C, and set 2 hour for 780°C. Continuous casting brings high efficiency.

B: Hold for 4 hours at 780 °C, adjust the duration according to number and volume of flask and thickness of jobs.

Notice: gypsum must suitable for plasticast.



6. Casting

6.1 Ramp down to casting required temperature, and keep for half hour.

6.2 Use Casting machine to melt meta land then casting, natural cooling for 5 - 10mintures.



7. Cooling and cleaning

Water cooling flask , and clean with high press cleaning machine.



You are welcome to visit our casting house if you have any casting problem, we offer casting skill training.



Bellow are the Jewelry 3D resins, if you need other industrial photopolymer resin or customize resin, be free to reach us.

	DLP with mercury lamp	DLP with LED UV 405nm	LCD Printer 405nm	SLA Printer (FORM2)
Jewelry Casting Resin	UPIC-1000 (PIC100)	EPIC-1000 (Trans Yellow)	//	SPIC-1000 (Trans Yellow)
	UPIC-2000ST(EPIC green)	EPIC-2000ST (Green)	CPIC-2000 (Green)	SPIC-2000 (Green)
	UPIC-4000 (Yellow)	EPIC-4000 (Yellow)	CPIC-1000 (Yellow)	//
	UPIC-2008st (Filigree)	EPIC-2008st (Filigree)	CWIC-1000A (high wax)	//
	EWIC-1000a (High wax)	EWIC-1000A (High wax)	//	//
Jewelry Mold Resin	Rubber mold: HTU-29	Rubber mold: HTE-29	Rubber mold: HTC-29	//
	Liquid/silicon mould: PJHU series	Liquid/silicon mould: PJHE sereis	Liquid/silicon mould:YJC sereis	//