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# CASTING BEST PRACTICES

## FOR CASTABLE RESIN (CAST-LC200)

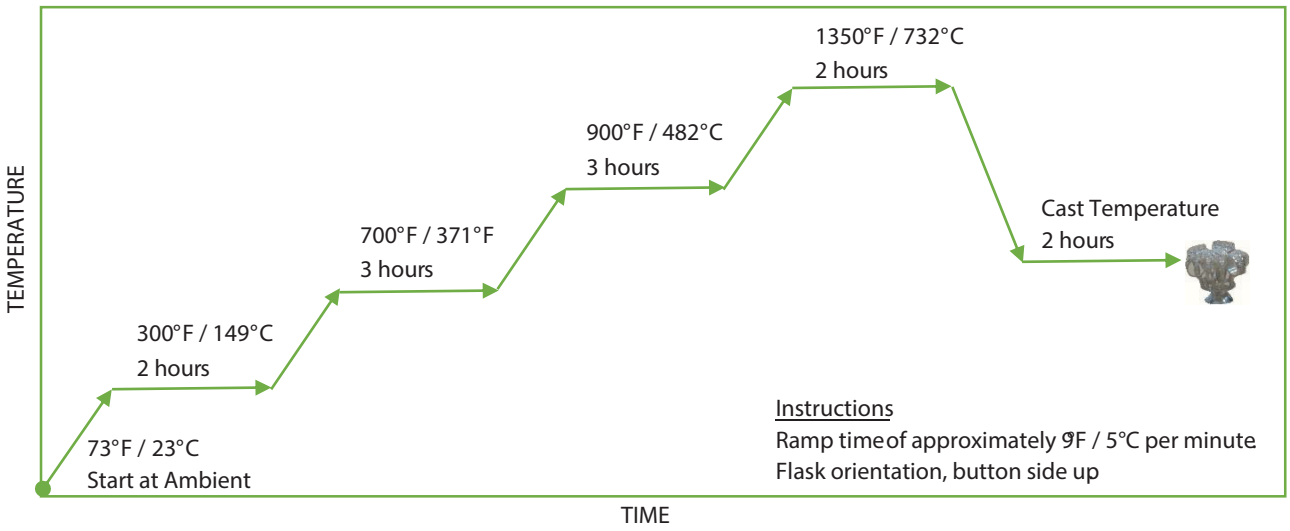
This extremely versatile material is predominantly used in lost wax casting. This resin is known to yield highest quality and crisp details along with standard burnout procedure. These properties are extremely useful when it comes to producing high quality parts for industries that deal with precise and intricate designs such as **Jewellery & Dental**.


Another prominent feature that provides Kevvox innovation an edge over other commercially available material is its sustainability. Castable material has low expansion rate and is able to retain its original form for an exceptionally long period of time. Its strength and stability makes it highly suitable for shipping without the risk of damage. You can safely use this for direct investment casting (lost wax casting).

| *Physical properties: | |
|---|---|
| Viscosity | 400 mPa*s at 25 degrees Celsius or lower |
| Hardness (Shore D) | 70 shore |
| Tensile Strength | 17.0 MPa |
| Available Colours | Light Green (Wax LC-200) |

### BURNOUT CYCLE

Models made using this material evaporate at moderate burn out temperatures with extremely low thermal expansion. The burn out process is ash free allowing for a casting that is free from porosity. This is a distinct advantage since most other polymer based material result in the ash residue when burning.




Note: Settings are to be used as a reference. It may require adjustment depending on casting conditions.

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## RECOMMENDATIONS

Our customer has successfully casted using the following investment power.

(a) Chang Kong Kee http://www.ckkgroup.com - Cobra Investment Power

(b) SRS http://www.srs-ltd.co.uk/ - StoneCast Investment Powder

(c) Kerr http://www.kerrcasting.com/ - Satin Cast 20 Investment Power

(d) Gold Star http://www.goldstarpowders.com/ - Gold Star Powder Omega Plus

For the flask type, it can be perforated or non-perforated (centrifugal casting machine).

## PROCEDURES

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1. Sprue printed models on a normal wax base.

2. Pour investment slurry into flask and let it set.

3. Place a metal tray inside the kiln on three ½" posts. Place the mold on a wire mesh screen on top of the tray. The mold's sprue holes should be down. The tray will catch melting wax as it drips from the sprue holes.

4. Keep the kiln's vent hole(s), if any, open during wax elimination. If the kiln has no vent hole, leave the door open ½". This allows fumes to escape from the kiln. Heat the kiln to 300°F/149°C and hold it at that temperature for at least one hour.

   Do NOT heat the wax above 300°F/149°C. Hold at 300°F/149°C for at least one hour. During this hour, the wax will melt from the mold and drip into the tray.

5. After one hour at 300°F/149°C, open the kiln. Remove the mold and wax tray. Pour the wax from the tray and leave the tray out of the kiln until your next wax elimination.

6. ***Flip the flask to have the spruce hole facing upwards, allowing fumes to have a clean escape.***

7. Heat the mold to the temperature recommended by your jewellers' supply house where you purchased the mold material. This is usually around 1350°F/732°C.

8. Lower the temperature to the casting temperature of the metal. Hold at that temperature until you are ready to begin casting. Remove the mold with tongs. Wear protective gloves and safety glasses.

Please contact our Support Team support@kevvox.com or access our Support Portal for more information.