

Mixing Instructions

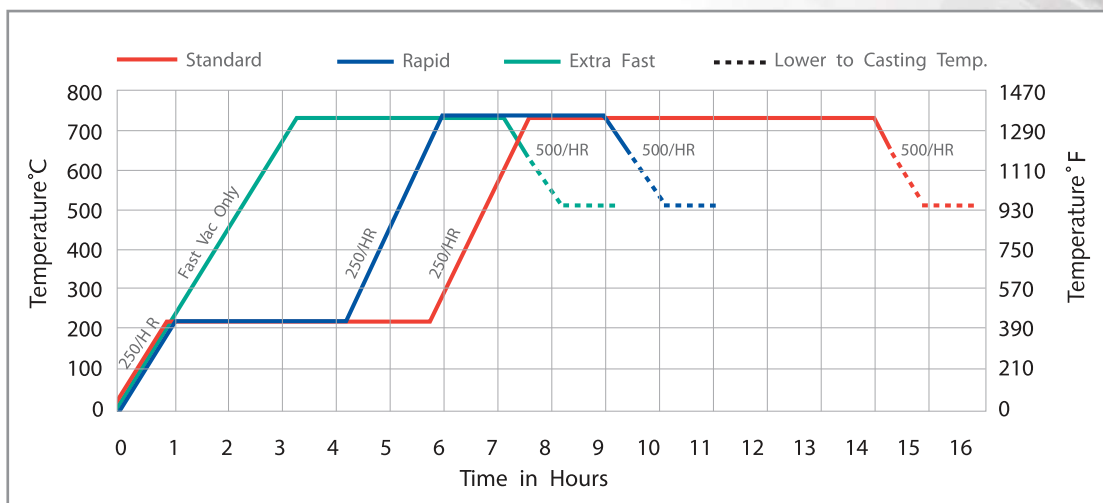
Water : Powder Ratio	Vacuum Mixing	Conventional Mixing
	38 : 100	40 : 100

Machine Vacuum Mixing	Min.
Weigh out water & powder	-
Add powder to water	-
Mix under vacuum	5
Pour flasks	2
Hold flasks under vacuum	1
Total time taken	8

Conventional Mixing	Min.
Weigh out water & powder	-
Add powder to water and mix	4
Vacuum the bowl	1
Pour flasks and vacuum the flasks	3
Total time taken	8

- Leave for 90 minutes to stand before burnout.

Recommended Burnout Cycles



Note: Do not remove flasks from furnace to cast until they have been held at casting temperature for a minimum of 1 hour. If held for less than 1 hour, the core of the flasks will be at a much higher temperature than the digital temperature display states, and may result in metal mould reaction.