

## Products for art and investment casting (i.e. the lost wax moulding process)



### Investment products

425

#### 1) Type 'H.D.' Item No. 425.001 in drums of 45 kg

synthetic gypsum bonded, for Al-alloys

**Instruction:** Add the measured powder to the water and mix thoroughly by hand or mechanically for 1 min. Avoid air-inclusions. Pour the material quickly into the cavity. Respect the time of heating to avoid cracking.

#### 2) Type 910 X Investment (R&R) Item No. 425.101 in bags of 25 kg

Calcium sulfate bonded pourable material for the investment-casting of Al- and CU-alloys.

May be used as moulding as well as core material. May be combined as core with ceramic shell. Excellent surface quality.

**Instruction:** Add the measured powder to the water and mix thoroughly by hand or mechanically for 1 min. Avoid air-inclusions. Pour the material quickly into the cavity.

Dewaxing may start after about 2 hours.



### Pattern and sculpture waxes for art castings

426

#### 1) CARA-CM 6 Item No. 426.006

dark-brown, ideal quality for fine and easy work. It has a low sticking effect to the fingers; having a slight settlement if melted, it should be continuously stirred.

Melting point 72,5°C, softening point 40 – 45°C, shrinkage 0,8 %.

#### 2) CARA-CUC 17 Item No. 426.017

dark-brown opak, clean burnout, for fine detail work. Can be poured or injected into moulds. Selective blending of raw materials has produced a wax with the proper hardness and plasticity for working with hand tools even after long storage. Melting point 71,1°C.

Other waxes on request!



### Silicon rubber, condensation-curing

427

#### 1) CARA-506 with catalyst T 46

**reasonable**, pale grey, multi-purpose, pourable, good flow, hardness Shore A 25, linear shrinkage 0,5 %, outstanding resistance to casting resins, particularly to polyesters, especially suitable for reproducing models with extensive undercuts in casting resins. Other materials, such as wax and plaster, can be processed also without any problem. If the rubber is to be applied to vertical surfaces, it can be rendered non-sag by adding 1 – 2 % w/w of **Thixotropic Add. M** to the catalysed mass (rubber base plus catalyst).

#### 2) Elastosil M 1470 with catalyst T 40

kneadable, especially for making moulds from low structured surfaces, hardness Shore A 55, low shrinkage (0,2 %), therefore excellent moulding accuracy, high mechanical strength. Add 5 % catalyst, working time 20 min., demoulding may start after about 2 hrs., pink colour.

#### 3) Elastosil M 4470 with catalyst T 40

pourable, high heat resistance and thermal conductivity, for low melting point metals and alloys (tin), hardness Shore A 60, shrinkage 0,8 %, excellent flow, working time 20 – 40 min., demoulding may start after 2 or 4 hours (depending on the added quantity of catalyst, which should be between 2 and 3 % w/w), red-brown.

#### 4) Elastosil M 4440 with catalyst T

pourable, flexible, light grey, of medium hardness (Shore A 45), shrinkage 0,4 %, working time 20 – 40 min. (depending on the added quantity of catalyst which should be between 2 and 4 % w/w), demoulding may start after 2 or 4 hours.

#### 5) Elastosil M 2471 with catalyst T40

brushable, no flowing on vertical surfaces, light-grey, hardness Shore A 55, shrinkage 0,4 %, working time 20 – 50 min. (depending on the added quantity of catalyst which should be between 2 and 3 % w/w), demoulding may start after 2 or 4 hours.

| Rubber type | Cont./Item No. |         |
|-------------|----------------|---------|
|             | 1 kg           | 5 kg    |
| CARA-506    | 427.201        | 427.202 |
| M 1470      | 427.001        | 427.002 |
| M 4470      | 427.101        | 427.102 |
| M 4440      | 427.401        | 427.402 |
| M 2471      | 427.301        | 427.302 |

| Catalyst-type | Cont./Item No. |         |         |         |
|---------------|----------------|---------|---------|---------|
|               | 40 gr.         | 50 gr.  | 200 gr. | 250 gr. |
| T 46          | –              | 427.211 | –       | 427.212 |
| T 40          | 427.011        | –       | 427.012 | –       |
| T             | 427.411        | –       | 427.412 | –       |
| Thix. Add. M  | 20 gr.         |         | 40 gr.  |         |
| Item No.      | 427.221        |         | 427.222 |         |

