



## Plaster-bound embedding compound for precision casting in accordance with the lost wax moulding principle

### GILCAST AL SP2 offers

- Advantageous processing consistency
- Smooth cast surfaces with ideal detail reproduction
- especially easy mould removal
- Particularly suitable for processing light metal and non-ferrous metal alloys
- Ideal for vacuum casting systems
- Consistent quality
- Very suitable for the casting of big flasks

### Characteristics

Mixing ratio:	
Powder : water:	1kg : 0.27 – 0.29 l
= Mixing volume:	0.595 – 0.605 l
Density of mixture	2.15 – 2.14 kg/l
Mixing time:	1 – 4 min
Processing time:	approx. 10 minutes
Curing time prior to lost wax process:	min 90 min, better 120 min
Heating rate:	60 – 100 °C/h
Preheating temperature:	min 400 °C to max 750 °C
Holding time at final temperature:	approx. 4 hours
per cm layer thickness:	approx. 1 hour longer

### Processing

Sprinkle **GILCAST AL SP2** into the prepared water, stir briefly and mix for 60 until 300 seconds using a vacuum stirrer if possible. The use of water with high degrees of hardness may extend the processing time a little.

Warm water (30 – 35 °C) shortens the processing time.

Under slight vibration and, if possible, under vacuum, the prepared embedding compound is poured into the casting vessel with correctly prepared wax or plastic patterns. One hour after starting the mixing procedure, the wax in the casting vessels can be completely dissipated (by evaporation with steam wait 2 hours) by heating to 200 °C with a corresponding waiting time at this temperature. The temperature in the preheating furnace is then slowly increased as specified above and the final temperature maintained corresponding to the size of the casting vessel.

Depending on the type of alloy, the casting can be removed mechanically after cooling to room temperature or by placing in water after the glow colour of the alloy has disappeared.

### Caution

**This embedding compound contains quartz and cristobalite. Therefore avoid inhaling dust!**



## GILCAST AL SP2

### Storage / Shelf life

Minimum 12 months in well-sealed, moisture-proof packing.

Material that was stored at a temperature other than room temperature should be allowed to acclimatise for several hours at 20 – 23 °C prior to use.

Longer storage periods at temperatures in excess of 30 °C can impair the storage stability.

This information is provided to the best of our knowledge and is based on comprehensive testing. We guarantee the quality of our products in accordance with specifications, however, we can accept no liability for the results of further processing that are generally outside our sphere of influence.

### Packing

Paper bags with a liner

25 kg

