



GILCAST HS Soft

Gypsum-bonded, quick-heatable jewellery embedding compound for precious-metal

Gilcast HS Soft offers:

- advantageous processing consistency
- smooth casting surfaces with optimum reproduction of details
- easy removal
- quick heat-up possible

Key data

Mixing ratio:	
powder : water	100 : 36 - 40
Processing time	approx. 9 minutes
Waiting time before heat-up	60 minutes

Processing

- Strew **Gilcast HS Soft** into the given water amount, mix briefly and mix for 60 seconds if possible with a vacuum mixer. When using water with higher degrees of hardness, the processing time may be slightly longer.

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

One hour after the start of mixing, the cuvettes can be placed directly in the oven preheated to 750 °C..

Casting cuvettes, for example, of 10 cm can be casted after 90 minutes of firing. Alternatively, they can also be fired with the usual heat-up cycle:

up to 300 °C at 60 °C per hour
up to 750 °C at 100 °C per hour.

Depending on the type of alloy, the divesting may be carried out mechanically after cooling to room temperature or already after the disappearance of the glow colour of the alloy by introducing it into water.

For surface cleaning, a commercially available pickling agent can be used.

Please note

Do **not** mix **Gilcast HS Soft** with other products

Shelf-life

in well-sealed, moisture-proof containers approx. 12 months.

Packaging

Paperbags with lining	25 kg
Big Bag	1000 kg

The particulars above have been given to the best of our knowledge, and after careful checking. We warrant the faultless quality of our products, but accept no liability for processing results, which will usually be outside the sphere of our influence.