GILCAST KM

Synthesegips Service

Compound for manufacturing cores
Also suitable for shell mould process (For non-ferrous metals)

Gilcast KM offers

- Advantageous processing consistency
- High dimensional accuracy
- Smooth surfaces
- Outstanding spreading properties
- Sufficiently high strength to withstand casting pressure and contraction of moulding
- Temperature resistance up to approx. 1000°C
- Insensitive to thermal shock
- Consistent quality

Physical data

Mixing ratio	
Powder : Water	1 kg : 0.28 kg
Mixing volume	1.28 kg = 0.63 l
Processing temperature	approx. 20 °C
Processing time	approx. 10 min.
End of solidification	approx. 25 min.

Processing

Sprinkle **Gilcast KM** at the specified mixing ratio into the prepared water and stir thoroughly for 1 – 2 minutes, preferably using a vacuum stirrer.
(The water used for mixing should have a temperature of 20 – 23 °C before the mixing process. Water temperatures above 30 °C to about 35 °C shorten the setting time, low temperatures lengthen the setting time.)

While taking care to avoid adhesion bubbles, the prepared core compound is carefully poured onto the separated pattern or into the core box or core mould.

Once the material has hardened, remove the core from the mould and leave standing at room temperature for at least 1 hour. The finished core can also be used in wax injection or casting moulds.

Attention

Do not mix **Gilcast KM** with other products.

Gilcast KM contains quartz and cristobalite. Avoid inhaling dust!

Packing

Paper bag with foil liner	25 kg

Shelf life

At least 12 months in well closed, vapour-proof packages.

The above recommendations are given to the best of our knowledge after careful control. We grant the quality of our products according to our specification. Any further liability cannot be accepted since the proper application of our products is outside of our control.

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