



Gypsum bound investment for aluminium and its alloys

Gilcast ND TM offers

- Advantageous working consistency
- Specially developed for the tire industry
- Smooth casting surface with optimum definition of all details
- Use of low-pressure-casting possible
- Low setting expansion
- High compressive strength
- Constant quality

Characteristics

Mixing ratio powder : water	1 kg : 280-300 g
Working temperature	app. 20° C
Working time	app. 10 min.
Setting expansion	0,15 – 0,2 %

Hardening time before burnout 90 - 120 min.

Rate of heating	40 - 60 °C/h
depending on size of the mould	
Burnout temperature	app. 300 - 450° C
Burnout time	app. 4 h

Working method

Apply a release agent to the pattern and position it in a suitable moulding box.

Powder and water should have a temperature of 20 – 23°C before mixing. Water temperatures above 30°C shorten the setting time lower temperatures will prolong the setting time of the mixture.

Strew **Gilcast ND TM** in the given ratio into the water and mix thoroughly for 1 - 2 min., preferably with a vacuum mixer.

Pour the mixed investment into the moulding box taking care to avoid air bubbles, which would adhere to the pattern.

Demould the pattern after solidification and heat the **Gilcast**-mould after one hour to 300 - 450° C. After the hold period of approx. 4 hours the **Gilcast**-mould has to be cooled to 200° C if a hearth casting follows, respectively to a temperature below 70° C, if low pressure casting is applied.

Attention

- Do not mix **Gilcast ND TM** with other products.
- **Gilcast ND TM** contains quartz and cristobalite. Do not inhale 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.