



Gypsum bound investment for aluminium and its alloys

Gilcast ND offers

- Advantageous working consistency
- Smooth casting surface with optimum definition of all details
- Use of low-pressure-casting possible
- Constant quality

Characteristics

Mixing ratio powder : water	1 kg : 280-300 g
Working temperature	app. 20° C
Working time	app. 10 min.

Hardening time before burnout	60 min.
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Rate of heating depending on size of the mould	40 - 60 °C/h
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Burnout temperature	app. 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** 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 approximately 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** with other products.
- **Gilcast ND** contains quartz and cristobalite. Do not inhale dust!

Packing

Paper bag with foil liner	25 kg
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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.