



# HYDROCAST

## INVESTMENT POWDER

Hydro Cast is used for high quality of silver, bronze and brass casting in exacting circumstances and is ideal in situations where high quality is required at a more economical price.

- Blend easily to a very smooth creamy consistency.
- Enable easy air elimination thus eliminating nodules on the castings.
- Achieve fast, clean burn-outs.
- Form a strong, permeable mould suitable for either vacuum assisted or centrifugal casting.
- Give castings with smooth surfaces, sharp definition and dimensional accuracy.

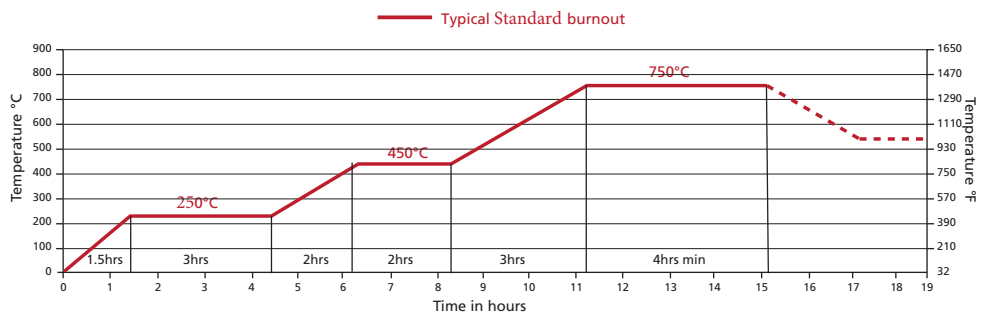
Hydro Cast is an economy investment powder for large scale commercial casters giving excellent value for money.



### TECHNICAL DATA

Powder / Water Ratio	<b>100/38</b>
Working Time @ 25°C Slurry Temp	<b>7.5 - 10 min.</b>
Gloss Off Time @ 25°C Slurry Temp	<b>13.5 - 14.5 min.</b>
Thermal Expansion At 750°C	<b>1.2%</b>

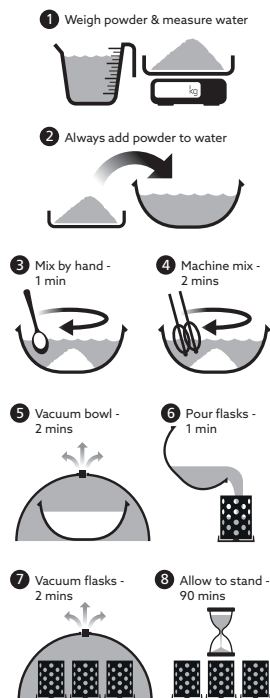
### BURNOUT CYCLE



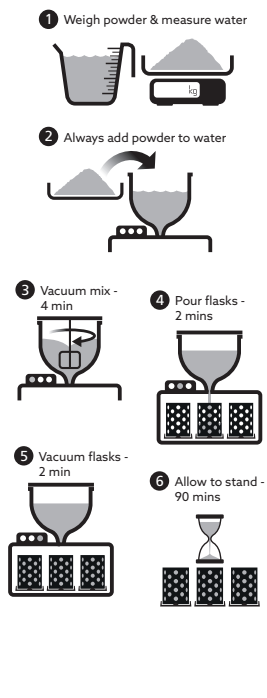
### MIXING INSTRUCTIONS



#### Conventional Mixing



#### Vacuum Mixing



**Water/Powder Ratio 38:100**

Conventional Mixing	Time (Mins)
Add Powder To Water	-
Hand Mix	1
Machine Mix	2
Vacuum Bowl	2
Pour Flasks	1
Vacuum Flasks	2
<b>Total Mixing Time</b>	<b>8</b>

**Water/Powder Ratio 38:100**

Vacuum Mixing	Time (Mins)
Add Powder To Water	-
Mix Under Vacuum	4
Pour Flasks	2
Hold Under Vacuum	2
<b>Total Mixing Time</b>	<b>8</b>