



SIAM CASTING POWDERS LTD.

# Smooth

## INVESTMENT POWDER

**SCP SMOOTH Investment Powder, designed for casting brass, silver and all precious metals including all karat yellow and white gold, including palladium white gold.**

SCP Smooth premium quality investment powder is designed to meet high quality standards that are demanded by all casters. Super smooth surfaces and fine detail design are key and prerequisite in casting high karat gold and have been taken into consideration when SCP Smooth was formulated.

SCP Smooth is suitable for direct casting from 3D printed resins or wax pieces & patterns. It is also suitable for all traditional wax injection techniques.

Flexible and easy to remove after casting, SMOOTH investment powder is the perfect solution to casting a variety of different applications, alloys and achieving precision castings with super Smooth surfaces.

**PRODUCT PACKAGING**  
SACK :  
22.5 kg. (50 lb.)



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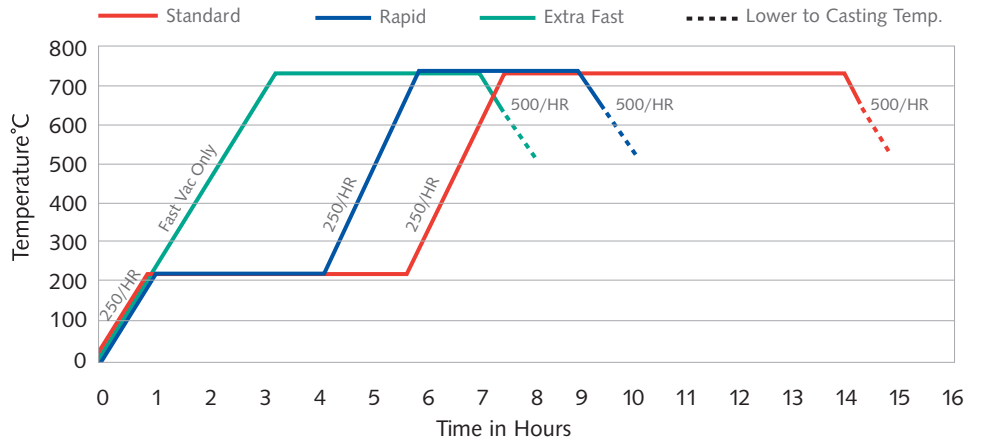
## INVESTMENT POWDER

### TECHNICAL DATA



Powder / Water Ratio	<b>100/38</b>
Working Time @ 25°C Slurry Temp	<b>8-9 min.</b>
Gloss Off Time @ 25°C Slurry Temp	<b>11 - 13 min.</b>
Thermal Expansion At 750°C	<b>1.2%</b>

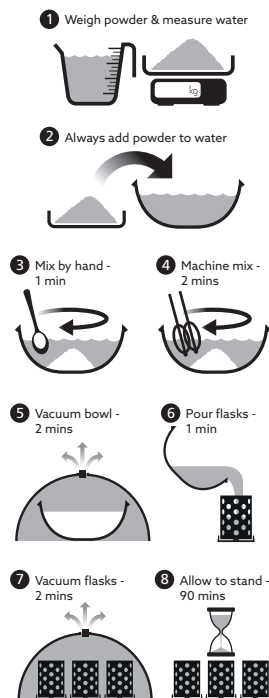
### BURNOUT CYCLE



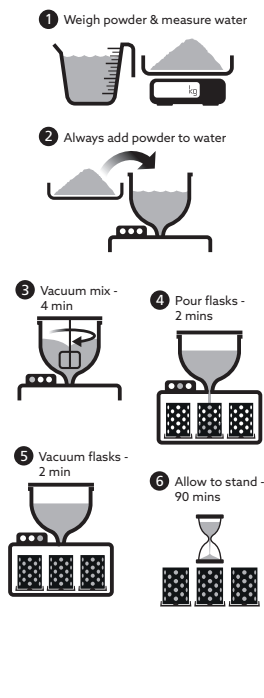
### MIXING INSTRUCTIONS



#### Conventional Mixing



#### Vacuum Mixing



Water/Powder Ratio 40:100

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

Water/Powder Ratio 38:100

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



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