



# SYNERGY

## INVESTMENT POWDER

A Premium Investment Powder for Resin/CAD casting, which has been tested and approved worldwide.

Synergy was developed by G3D in the United Kingdom - tried and tested by jewellery manufacturers worldwide. It is designed Primarily for investing, burnout and DIRECT CASTING of your resin/wax patterns.

Highest Quality raw materials sourced and graded for Resin/CAD direct casting  
Formulated with a greater green strength enabling it to withstand the high Resin/CAD expansion  
Can be used with any Resin/CAD manufacturer  
Clean cut surface finish, sharp edges, without inclusions  
Easy removal after casting, like your regular GRS investment powders

### PRODUCT PACKAGING

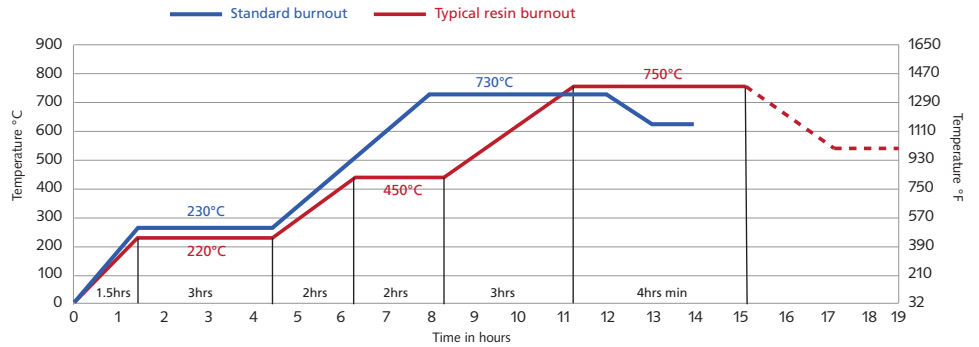
SACK : 22.5 kg. (50 lb.) Drum : 22.7 kg.



### 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>12-14 min.</b>
Thermal Expansion At 750°C	<b>1.2%</b>

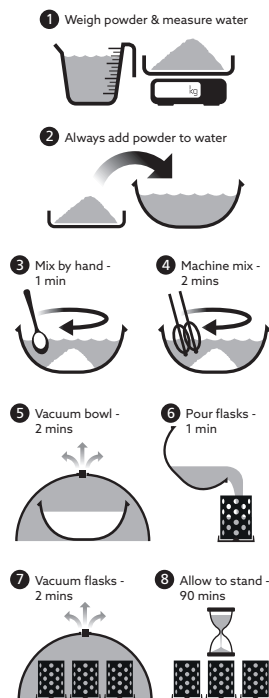
### BURNOUT CYCLE



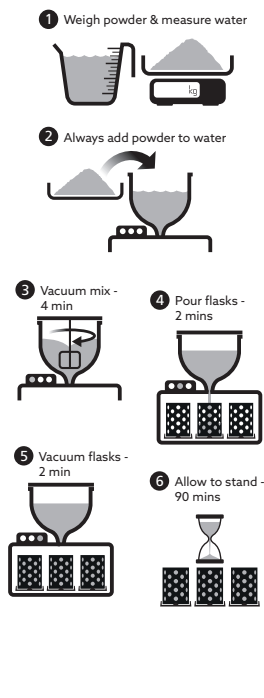
### MIXING INSTRUCTIONS



#### 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>