

Instructions for
ALL CAST

Item# 265-4995, 265-4996, 265-4998, 265-4999

MADE IN USA

A Micro-Fine Grain, “Carbon-Free” Investment for Producing Ultra-Smooth Castings

All Cast is a super-fine phosphate-bound, cristobalite investment ideal for use with precious, semi-precious and non-precious alloys. Meticulously formulated compound provides the caster with a wide range of burnout temperatures... **ready in just 20 minutes!**

Smooth... Accurate... Strong... Reliable... that’s ALL CAST Investment.

Specifications

Working Time:	7-8 Minutes
P to L Consistency:	100gm: 25cc
Setting Expansion:	0.6%
Thermal Expansion:	1.4%
Burnout Range:	1300° – 1800°F 704° – 982°C

**Allows 1500° – 1700°F (816° – 927°C)
furnace entry ready for burnout in just 20
minutes and yields ultra-smooth castings!**

Directions

1. Attach sprue to wax pattern and mount on sprue former base.
2. Apply Debubbler to pattern and shake off excess.
3. Line casting flask with a strip of asbestos-free liner. Dip lined casting flask in water and shake out excess. Position flask in sprue former base.
4. Recommended liquid dilution for castings:

	Special Liquid	Water Distilled
Base Ceramic Alloys:	50-80%	20-50%
Semi-Precious Alloys:	60-80%	20-40%
Gold Alloys:	50-75%	25-50%
Recommended:	70%	30%

***Not recommended for titanium or titanium alloys**

5. Recommended powder to liquid ratio:
100 Grams Powder: 25.0cc Liquid
6. Wet the bowl and shake out excess water. Pour liquid into mixing bowl. Add All Cast powder to liquid. Hand spatulate 10 seconds until the investment is wet. Vacuum mix for 45-60 seconds, and then invest.
7. Invest by pouring a thin stream of investment directly into the flask, pausing only to see if a bubble-free film of investment has covered the entire pattern surface. If not, either blow on the surface to break the bubble or use a soft artist’s brush, then continue to pour. **Avoid vibration.**
8. Allow All Cast Investment mold to set on bench for 1 hour.

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Directions (cont.)

- Place flask in a burnout furnace at room temperature. **Burnout according to alloy manufacturer's recommendations.** Raise the temperature to the desired "final" temperature at a rate of **15°-20°F (5°-10°C)** per minute. Heat-soak at the final temperature for 1 hour. A ramp burnout is also possible.
- If rapid burnout is required,** use wax sprues only. Place the All Cast flask in a 1500°-1700°F (816°-927°C) furnace after 20 minutes of bench set. Increase or decrease the furnace temperature **slowly** to **alloy manufacturer's recommended temperature.** Hold for 30 minutes at maximum temperature, then cast.

Note: If solid plastic sprues are used, proceed as described in step #9.

- After casting, allow flask to cool. Submerge flask in water for a few minutes (protects you from breathing undesirable dust). Use a pair of plaster tongs to remove the casting and then blast with aluminum oxide.

Description	Shipping Weight	Item#	Each
All Cast Investment	25lbs.	265-4995	\$80.00
All Cast Investment	50lbs.	265-4996	155.00
All Cast Liquid Binder	96oz.	265-4997	35.00
All Cast 25# Investment & Binder Kit	25lbs.	265-4998	115.00
All Cast 50# Investment & Binder Kit	50lbs.	265-4999	225.00

Prices subject to change without notice.

WARNING
This product contains free silica

Inhalation of dust may be harmful to your health and excessive inhalation will increase the risk of serious respiratory disease (silicosis). Take appropriate protective measures to avoid breathing dust. Immediate clean up of spills is highly recommended.