



WORKING PROCESS FOR FLASKING

1. **INVESTING** : Mixing time within 7 minutes and allow flasks to set at least 1.30 – 2 hours

2. **STEAM DEWAXING** : Load flasks into a preheated steam dewaxer and dewax for 45 minutes to 1 hour.
Leaving flasks in steam dewaxer longer than 1 hour can result in water marks or investment breakdown.
Transfer flasks immediately to a preheated burn out oven set at 150 °C, do not allow flasks to cool down.

3. **BURNOUT CYCLE** :

90 °C	1 hours.
150 °C	1-2 hours.
300 °C	1-2 hours.
500 °C	1-2 hours.
730 - 750 °C	6-8 hours.
Casting temperature	1-2 hours.

4. Please see the instruction sheet of each alloy for graining temperature the fine gold/silver with alloy and Casting Temperature and Flask Temperature.

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