



ASSYST sprl / A.S.O.W. sprl
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SRS ARTCAST

DESCRIPTION:

ARTCAST™ is one of the original products designed by SRS. It is a plaster-based investment powder for brass/bronze castings using the lost wax process.

ARTCAST™ is designed for small to medium-sized brass / bronze / small industrial castings up to 60 kg.

SCOPE:

ARTCAST™ offers the following advantages to art foundries:

- ✓ It is specially designed for artificial castings in brass, bronze or silver.
- ✓ It has extra strength to withstand larger mould dimensions.
- ✓ it is easy to mix and vacuum larger quantities.
- ✓ it already contains wetting and defoaming agents - no need to add any.
- ✓ It gives a smooth surface finish with perfect reproduction of wax patterns.
- ✓ it is easy to break out after casting.
- ✓ It is also available with water-soluble fibres for extra firmness.

TECHNICAL PROPERTIES:

ARTCAST™ contains fine particles and is mixed in a powder-to-water ratio of 38%.

- ✓ - Powder / water ratio: 38%.
- ✓ - Working time @ 22°C: 8-9 minutes
- ✓ - Initial set time: 10-12 minutes
- ✓ - Set extension @ 2 hours: 0.45%
- ✓ - Thermal expansion @ 750°C: 0.75%.

PREPARATION:

Mixing instructions - Mixing under vacuum (time in minutes)

- ✓ - Weigh water and powder: 0
- ✓ - Add powder to water: 0
- ✓ - Mix under vacuum: 4
- ✓ - Pour into flasks : 1
- ✓ - Vacuum pumps: 1
- ✓ - Total time required : 6

Mixing instructions: Mixing without vacuum (time in minutes)

- ✓ - Weigh water and powder: 0
- ✓ - Add powder to water: 0
- ✓ - Mix: 2
- ✓ - Vacuum freeze: 1
- ✓ - Pour into flasks: 1
- ✓ - Vacuum pumps: 2
- ✓ - Total time required: 6

MIXING INSTRUCTIONS

Add the powder to the water in the recommended proportions in a mechanical mixer and mix for 4 minutes. Ideally, the resulting slurry should be vacuumed for 1.1/2 minutes before pouring around the cartridge, followed by a further vacuum of 1.1/2 minutes after covering the cartridge. After vacuuming, fill the cartridge upwards. If there is insufficient time for both vacuum cycles, skip the first cycle. Gentle vibration also helps to remove air bubbles.



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DRYING CYCLE:

After mixing, the moulds should stand for at least 2 hours. The moulds can be dewaxed dry by heating them to 200°C and maintaining this temperature for 3 to 4 hours (depending on the size).

Increase the oven temperature by 70-90°C per hour up to 725°C. The burnout is completed 4 - 6 hours after reaching the final temperature. After burnout, let the moulds cool down to the casting temperature at the natural cooling rate of the oven.

STORAGE:

Store the product in a dry place, protected from moisture. Bags should be stored without direct contact to the ground and protected from dripping water.