

# DIVINE CAST

## Investment Powder



AIICP DIVINE CAST is an exceptionally competitive, plaster-bonded investment powder, specifically formulated by optimizing the particle-size distribution and thermal expansion to help casters to compete in the most demanding of environments.

The casting of brass & silver for the fashion accessories along with small industrial pieces accounts for a large percentage of worldwide fashion accessories production, and is an area where costs must be minimized. AIICP DIVINE CAST helps achieve this but at the same time produces castings with excellent surfaces, therefore reducing metal loss and keeping finishing work, prior to plating, to an absolute minimum.

AIICP DIVINE CAST can also, under strictly adhered to conditions, successfully cast silver, producing good quality castings with smooth surface finish.

The cost of DIVINE CAST is at least 25% lower than a competitive, conventional investment powder, although it is less abuse-resistant than other AIICP products.



## Technical Information

Do not remove flasks from furnace to cast until they have been held at casting temperature for a minimum of 1 hour. If held for less than 1 hour, the core of the flasks will be at a much higher temperature than the digital temperature display states, and may result in metal mould reaction.

- Do not cast with a flask temperature lower than 650°C
- Slurry temperature 21 °C
- Leave for 90 min to stand before burnout

### WATER TO POWDER RATIO

|                       |        |
|-----------------------|--------|
| MACHINE VACUUM MIXING | 38:100 |
| HAND MIX THEN VACUUM  | 40:100 |

| MACHINE VACUUM MIXING        | Min. |
|------------------------------|------|
| Weigh out water and powder   | 0    |
| Add powder to water          | 0    |
| Mix under vacuum             | 1    |
| Stop mixer and scrape blades | 0.5  |
| Mix under vacuum             | 3.5  |
| Pour flasks                  | 2    |
| Vacuum flasks                | 1    |
| Total time take              | 8    |

| HAND MIX THEN VACUUM       | Min. |
|----------------------------|------|
| Weigh out water and powder | 0    |
| Add powder to water        | 0    |
| Mix by hand                | 1    |
| Mix with machine           | 3    |
| Vacuum mixer bowl          | 1    |
| Pour flasks                | 1    |
| Vacuum flasks              | 2    |
| Total time taken           | 8    |

