

## Instructions for casting with 3DM-Cast resin

To connect the resin models to the casting tree, we suggest you to use wax supports of proper dimensions (indicative diameter: 4 mm) and to link well the junction between the supports and the resin model.

We suggest you to leave possible supports inside the rings in order to make the flowing of the metal easier.

Suggested mixing time 5 minutes under vacuum, and after pouring the investment apply no more than 90 sec. of vacuum suction (for de-gasification).

The successive step is to leave the flask on a flat and stable place for at least 4 hours.

The best results are achieved when using an oven properly ventilated inside, being careful to turn the cylinder with the gate upwards, 2-4 hours before the casting, in order to help the complete discharge of the burning gas.

As for the cylinders, we recommend the use of PLASTICAST or Ultra-Vest MAXX, specific chalk produced by Ransom & Randolph for casting resin.

The burnout cycle can be remarkably different according to the kind of oven used.

It is recommended to use a gradual and moderate ramp from 1°C to 5°C per minutes.

