

HYDRACAST[®]

CASTING PLASTERS



STONESET

Hydracast Stoneset for the stone in place casting. Hydracast Stoneset has been specially formulated to protect precious stones such as diamonds, when they are set into the wax patterns, burned out and cast, to ensure no damage to the stones during the burnout cycle. The maximum temperature achieved during the burnout cycle **MUST NOT** exceed 630°C.

Stoneset holds the stones in place during the dewax period, and protects them from the heat during the remainder of the burnout process, and from the molten metal when cast. Stoneset will produce high definition, clean surface castings, with stones that remain as clear as they were before burnout.

Extensive permeability testing and development has taken place to ensure maximum carbon is released from the mould during burnout. It is formulated with the special additives to enhance stone-in-place casting results and improve cleanoff. Stoneset will cast all alloys melting below 1350°C.



GOODWIN REFRACTORY SERVICES

Spencroft Road, Newcastle-under-Lyme, England ST5 9JE

+44 (0)1782 663600

WWW.GRSCASTINGPOWDERS.COM



HYDRACAST®

CASTING PLASTERS



STONESET

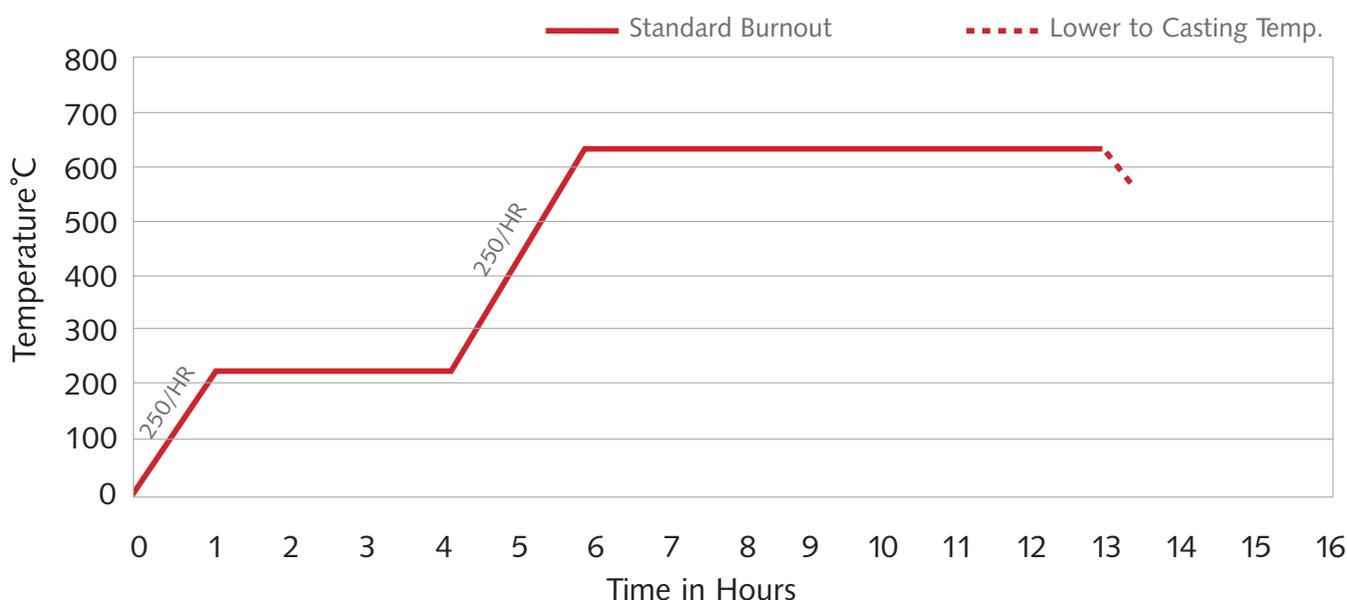
Do not remove flasks from furnace to cast until they have been held at casting temperature for a minimum of 1 hour. If held for less than 1 hour, the core of the flasks will be at a much higher temperature than the digital temperature display states, and may result in metal mould reaction.

- **DO NOT STEAM DE-WAX**
- **Do not burnout above 630°C**
- **Do not quench, only knock out when cold**

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	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 and mix	4
Vacuum mixer bowl	1
Pour flasks	1
Vacuum flasks	2
Total time taken	8



GOODWIN REFRACTORY SERVICES

Spencroft Road, Newcastle-under-Lyme, England ST5 9JE

+44 (0)1782 663600

WWW.GRSCASTINGPOWDERS.COM