



# Gold Star Gem Set

## Mixing Instructions

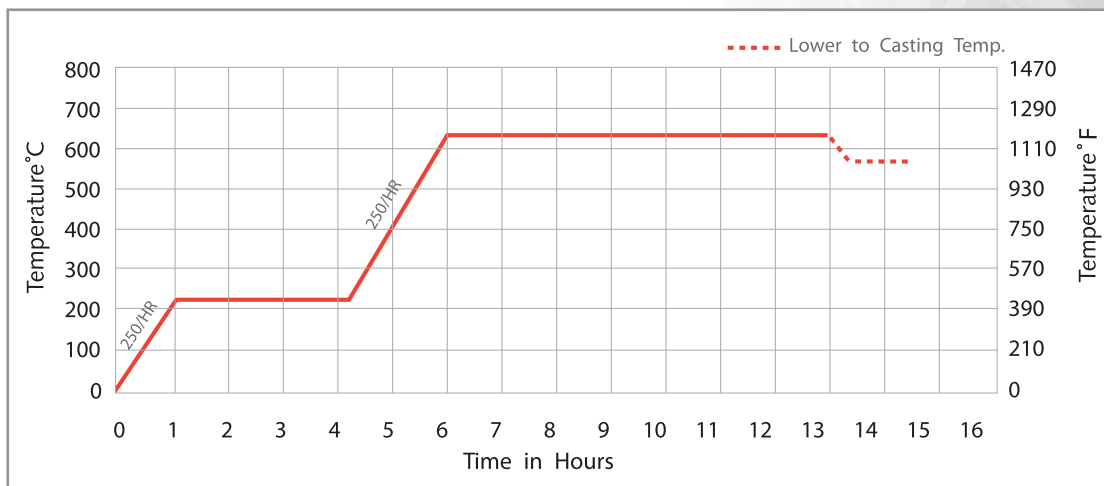
Water : Powder Ratio	Vacuum Mixing	Conventional Mixing
	38 : 100	40 : 100

Machine Vacuum Mixing	Min.
Weigh out water & powder	-
Add powder to water	-
Mix under vacuum	5
Pour flasks	2
Hold flasks under vacuum	1
<b>Total time taken</b>	<b>8</b>

Conventional Mixing	Min.
Weigh out water & powder	-
Add powder to water and mix	4
Vacuum the bowl	1
Pour flasks and vacuum the flasks	3
<b>Total time taken</b>	<b>8</b>

- Do not steam de-wax.
- Do not burnout above 630°C.
- Do not quench, only knock out when cold.
- Leave for 90 minutes to stand before burnout.

## Recommended Burnout Cycles



Note: 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.