



FOUNDRY Scarpa

Plaster casting for shoe moulds

SCARPA™ is a specially formulated plaster for the shoe industry. It is used for casting of aluminium mould plates.

SCARPA™ offers the following benefits to the shoe mould foundries:



- SCARPA™ contains only the purist closely graded raw materials to give utmost consistency in addition to high green and fired strengths. The product can be adjusted to suit individual customer requirements.
- SCARPA™ gives an excellent surface finish with high definition and close dimensional accuracy.
- SCARPA™ is highly resistant to surface breakdown reducing fettling costs after casting.
- SCARPA™ mixes easily to give a creamy consistency with minimal air entrapment.
- SCARPA™ can be packed in either 25kg bags or bulk bags up to 1500kg.

Technical Information - SCARPA™

Powder/water ratio	40%
Work time @ 22°C	10 - 12 minutes (can be supplied to specific requirements)
Initial set time	15 minutes
Thermal expansion	280°C + 0.30%





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MIXING INSTRUCTIONS

Add the powder to the water in the recommended proportions in a mechanical mixer and mix for 4 minutes. Ideally the resultant slurry should be vacuumed for 1 minute before being poured around the pattern, followed by a further vacuum after the pattern has been covered. After vacuuming fill the pattern to the top. If there is insufficient time for both vacuum cycles omit the first cycle. Gentle vibration will also assist in the removal of air bubbles.

DRYING CYCLE

The moulds are allowed to stand for a minimum of 2 hours before the drying cycle commences. The moulds may be heated up at a rate of 100°C per hour to 280°C where they must be held for a period of between 4 to 10 hours (size dependant).

After drying the moulds are allowed to cool to casting temperature at the natural cooling rate of the furnace.

