



Setting the Standard

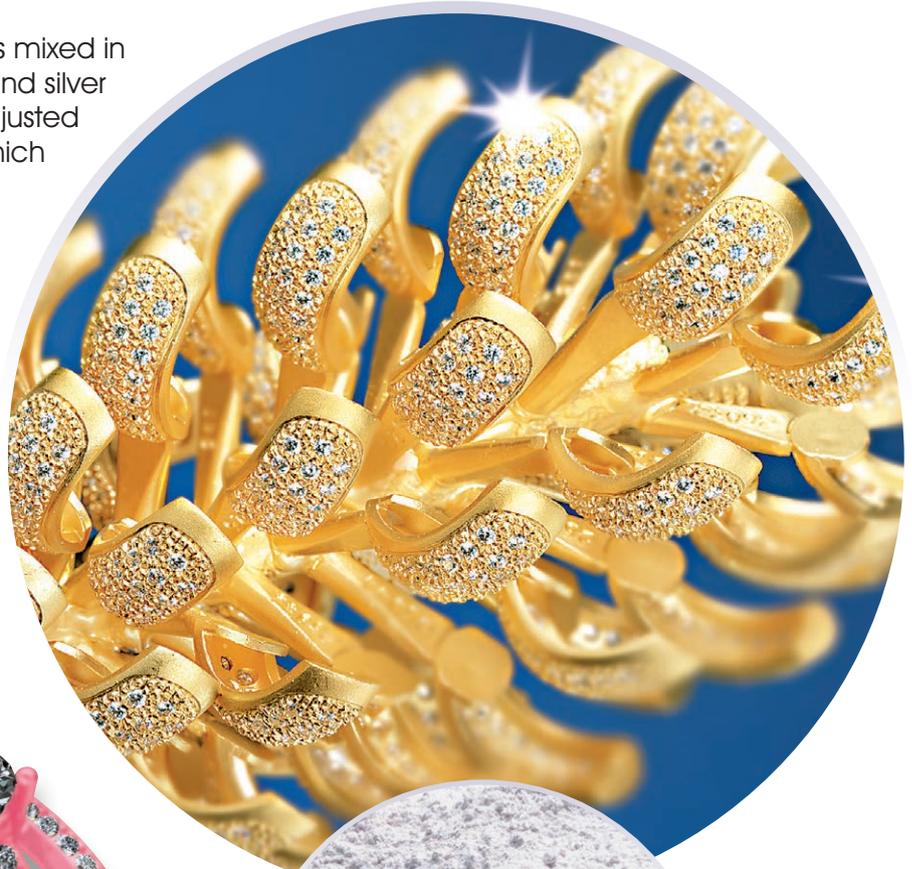


INVESTMENT POWDERS STONECAST

Special application powder for stone-in-place casting or wax setting. SRS can be relied on for highly effective solutions for stone-in-place castings because it is SRS who pioneered the inclusion of special additives into investment powder for this kind of application.

SRS Stonecast is simple to use and is mixed in the normal way for standard Gold and silver investments. All that needs to be adjusted is the burnout cycle temperature which must not exceed 630°C.

Today, SRS Stonecast is the industry leader for wax setting investment powders. It works by ensuring that the correct de-oxidising additives are present, thereby minimising the risk of damage to diamonds or other precious stones. These include problems with burnt diamonds, accelerated set times, incomplete filling, spalling and flashing over or under stones.



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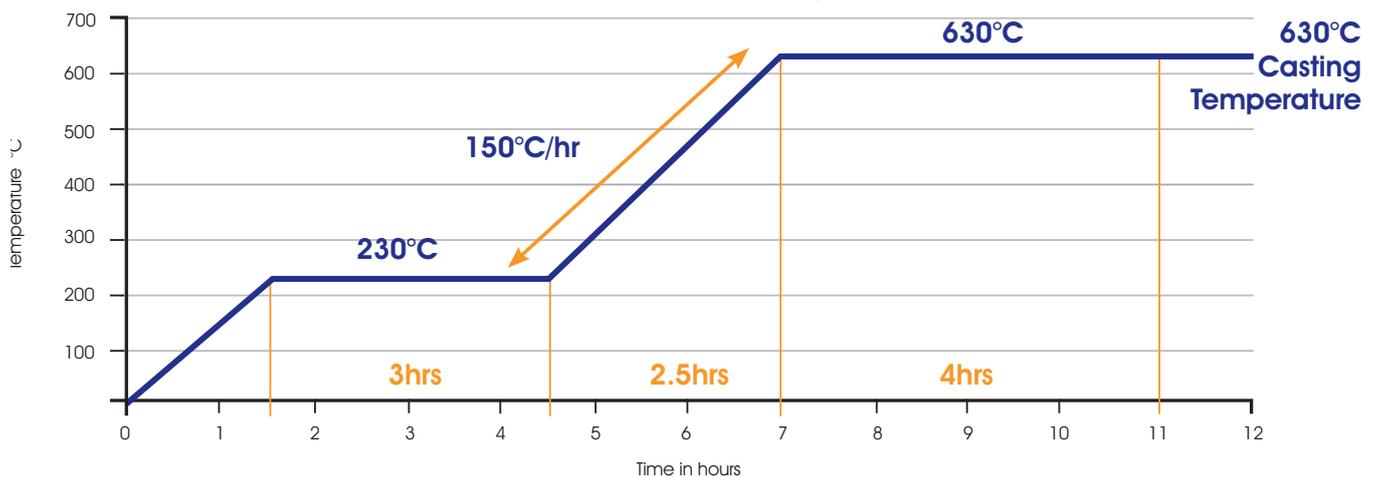
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Do not remove flasks from furnace to cast until they have been held at casting temperature for a minimum of 1 hour. If held for less than 1 hour, the core of the flasks will be at a much higher temperature than the digital temperature display states,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

- Slurry temperature 21°C
- Leave for 90 min to stand before burnout

MIXING INSTRUCTIONS	
POWDER TO WATER RATIO 100 TO 38	
MIXING BY HAND	MIXING BY MACHINE
1 Add powder to water	1 Add powder to water
2 Mix for 3 minutes	2 Mix for 4 - 5 minutes under full vacuum
3 Vacuum mixture for 1 minute	3 Pour flasks
4 Pour flasks	4 Vacuum flasks for 2 minutes
5 Vacuum flasks for 2 minutes	5 Remove flasks immediately from vacuum and to stand on a firm surface for 2 hours
6 Remove flasks immediately from vacuum and to stand on a firm surface for 2 hours	

Stonecast Burnout Cycle



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