



Gypsum-bonded, quick-heatable jewellery embedding compound for precious-metal

Gilcast S HS offers:

- advantageous processing consistency
- smooth casting surfaces with optimum reproduction of details
- easy removal
- quick heat-up possible

Key data

Mixing ratio:	
powder : water	100 : 36 - 40
Processing time	approx. 9 minutes
Waiting time before heat-up	60 minutes

Processing

-Strew GILCAST S HS into the prepared quantity of water, mix briefly and then continue mixing for 60 seconds, if at all possible using a vacuum agitator. When using water with relatively high degrees of hardness, the processing time may have to be extended somewhat.

Warm water (30 - 35° C) reduces the processing time.

1 hour after beginning mixing, the cuvettes can be placed directly into the oven preheated to 750° C.

Casting cuvettes, for example, of 10 cm can be casted after 90 minutes of firing. Alternatively, they can also be fired with the usual heat-up cycle:

up to 300° C at 60° C per hour
up to 750° C at 100° C per hour.

Depending on the type of alloy involved, removal can be performed mechanically after cooldown to room temperature, or already after the glowing colour of the alloy has been made to disappear by immersing it in water.

For surface cleaning, a commercially available pickling agent can be used.

PLEASE NOTE!

Do **NOT** mix GILCAST S HS with other products

Shelf-life

in properly sealed, moisture-proof containers, approx. 12 months.

Packaging

Plastic buckets	20 kg
Paperbags with lining	25 kg
Fibre drums with lining	45 kg

The particulars above have been given to the best of our knowledge, and after careful checking. We warrant the faultless quality of our products, but accept no liability for processing results, which will usually be outside the sphere of our influence.