



Gypsum bound, glass-fibre reinforced investment for precious casting molten glass by the lost wax process.

Special advantages:

- adjusted working consistency
- smooth surface with good detail reproduction
- easy to demould
- constant quality

Charakteristik data

Mixing ratio	
Powder: water	3,1 - 3,2 kg : 1 l
Working time	app. 14 min
Gloss off time	app. 19 min
Setting time	app. 28 min
Viscosity	app. 23 dPaS

Waiting period before the preheating	app. 120 min
Preheating temperature	app. 900 °C
Rate of heating	75 °C / h

Processing

Before the mixing process, Gilglas and water shall have a temperature of 18 - 22 °C.

Water temperatures over 30 °C shorten the setting time, lower temperatures prolong the setting time.

The ratio of a mixture can be varied depending on molten glass or glass article within the above mentioned area.

Strew Gilglas in the given ratio into the water. The use of a vakuüm mixer isn't condition, but advantageous. Take care that powder and water is mixed thoroughly when mixed with hand. The waiting period before preheating should be at least 120 minutes. Afterwards bourn out the wax

with steam for 3 hours. Then fill the flask with glas and heat it up to 900 °C. At 200 °C a retention time is nessesary. The retention time at final temperature varies between 20 and 40 hours. The cooling phase lasts 4 days. At 650 °C and 470 °C a retention time is provided. Demoulding is carried out at room temperature after cooling down.

Please note:

Do not mix Gilglas with other products.

Packaging:

Paperbags with foil liner 50 kg

Attention

This investment contains quartz and cristobalite. Inhalation of dust therefore has to be avoided!

Shelf life

At least 6 months in well closed vapour proof units. Longer storage at temperatures above 30 °C shorten the shelf life.

The above recommendations are given to the best of our knowledge. We grant the quality of our products according to our specification. Any further liability cannot be accepted since the proper application of our products is outside of our control.

