

# Hi-Wax Cast Resin

Applications: Thick-Walled Parts like men's rings

- ✓ Designed for thick-walled casting, ensuring effortless production!
- ✓ High wax content enables complete combustion and high casting success rate.
- ✓ Low shrinkage guarantees dimensional accuracy with zero deviation.
- ✓ Pearl White color provides easy observation and simplified model finishing.
- ✓ Upgraded formula delivers a smooth surface and easy demolding.

Specially developed for thick-walled castings, this Pearl White resin allows easy observation and model finishing. With a wax content exceeding 90%, it ensures easy burnout, zero ash residue, and effortless demolding, significantly improving casting success rates and surface smoothness.

# Precision Cast Resin

Applications: Thin-Walled & Delicate Structures

- ✓ Optimized for openwork and filigree casting, offering exceptional ease of use.
- ✓ High wax content ensures thorough burnout and reliable casting results.
- ✓ Low shrinkage maintains precise dimensions without errors.
- ✓ High precision and toughness capture intricate details perfectly.
- ✓ Jade Green color gives prints a fine, lustrous finish.
- ✓ Upgraded formula provides a smooth surface and easy demolding.

Designed for fine thin-walled castings, this resin combines high precision and strength to prevent wire breakage and deformation. It perfectly reproduces delicate structures and complex details. Its light champagne gold hue exudes elegance, while the high-toughness formula prevents filament breakage. Achieves 0.05mm precision for sharp details, and burns cleanly for easy demolding.



## Post-Printing Curing Treatment

Cure prints in a high-power UV curing station (UV intensity  $\geq 60\text{mW/cm}^2$ ). Thin parts require ~5 minutes, thick parts 15–20 minutes.

(Tip: Baking at 80°C for 20 minutes before curing improves casting results.)

### Casting Plaster Preparation



Select specialty plaster powder for 3D printed resin castings (e.g., "SRS" 3D CAST Jewellery Investment powder). Mix at 100:38 (Powder : Water ratio).



Add plaster to water (not vice versa). Mix 3–5 minutes with a stirrer, then vacuum degas for 2 minutes.



Pour slurry into the casting flask containing the printed model (ensure vents are large and downward-facing). Vacuum degas the flask for another 2 minutes.



Let the flask rest 2–2.5 hours before placing it in the casting furnace.

### Casting Conditions (Room Temperature Loading)

| Process Overview    | Time Settings | Temperature Settings | Note  |
|---------------------|---------------|----------------------|---|
| Furnace Heating     | 1 Hour        | 180°C                | Heat from room temperature to 180°C.  |
| Plaster Dehydration | 4 Hour        | 180°C                | Thorough dehydration ensures better results.  |
| Dewaxing            | 3 Hour        | 750°C                | Heat from 180°C to 750°C over 3 hours.  |
| Resin Burnout       | 3 Hour        | 750°C                | Hi-Wax Cast Resin: Hold at 750°C for 3 hours.   |
|                     |               | 780°C                | Precision Cast Resin: Hold at 780°C for 3 hours.  |
| Casting Ready       | 2 Hour        | 550~600°C            | Cool to metal-specific casting temperature (e.g., 550°C for copper, 600°C for gold/silver) over 1 hour, hold 1 hour before pouring. |

### Burnout Cycle

