

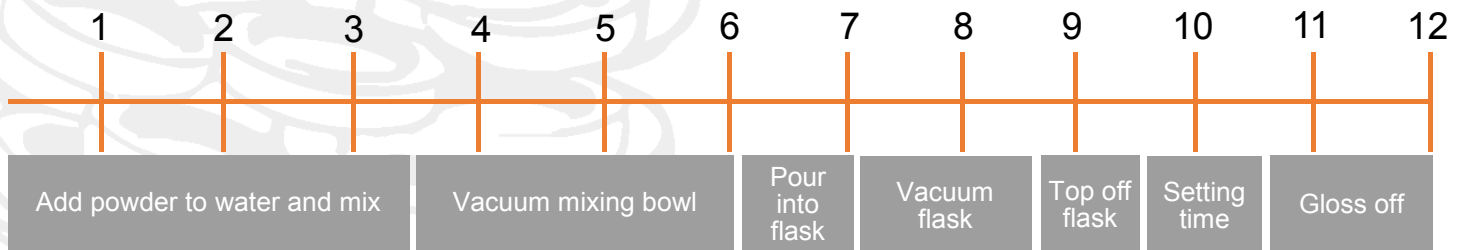
Mixing Instructions

For SC Series, KC200 and SV20

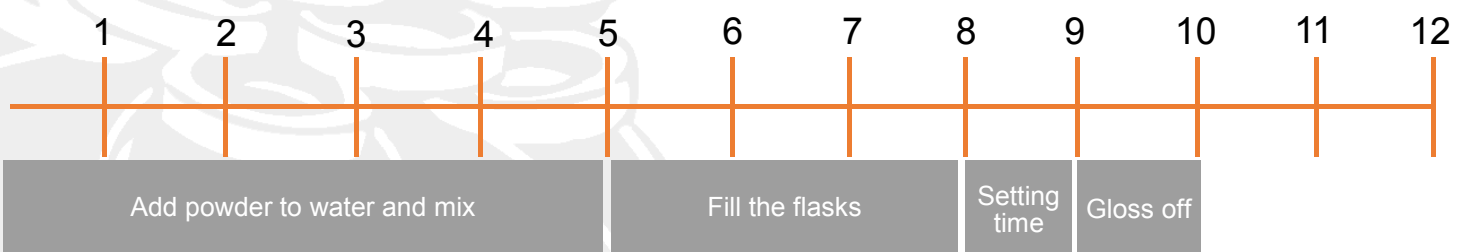
1. Weigh investment	2. Measure water	3. Add investment to water	4. Mix 3-3.5 minutes	5. Vacuum 20 seconds after boil	6. Pour into flask
7. Vacuum up to 90 seconds	8. Let flasks sit still for 2 hours	9. Preheat furnace 300°F / 149°C (Do not preheat for multiple flasks)	10. Remove Sprue base	11. Load into furnace	12. Follow appropriate burnout cycle

Recommended Work Time (Minutes)

Conventional Mixing



Vacuum Mixing



Work time: elapsed time between adding powder to the water and thickening of investment

Water temperature: Water should be 70°F (21°C) to 75°F (24°C). Colder water = extends work time; Warmer water = shortens work time

ALLIED MINERAL PRODUCTS, INC.

Corporate Headquarters: Columbus, Ohio, USA | Phone: +1 -614-876-0244 | email: info@alliedmin.com