

Recommended Water / Powder Ratios

Regular Castings

40ml water to 100 g powder

Heavy Castings

38ml water to 100 g powder

To determine the number of pounds of investment needed to fill any particular flask, divide the cubic inch content of the flask by 20.

(1lb = 454 grams)

Weight		Water		Yields		Water		Yields	
lb	grams	Oz.	ml	in ³	cm ³	oz.	ml	in ³	cm ³
0.5	227	3.2	91	11	179	3.0	86	10.5	174
1	454	6.4	182	22	359	6.1	172	21	349
5	2268	32	908	110	1794	31	862	107	1745
10	4535	64	1816	219	3589	61	1724	213	3490
15	6803	96	2724	329	5383	92	2586	320	5235
20	9070	128	3632	438	7178	122	3448	426	6980
25	11338	160	4540	548	8972	153	4310	533	8725

Investment Powder & Water Requirements for Flask Sizes

Top figure—investment powder (oz.); bottom figure—water (ml)

Regular Castings

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Heavy Castings

38ml water to 100 g powder

Flask Diameter (in)	Height (in)													
	2	2.5	3	3.5	4	5	6	2	2.5	3	3.5	4	5	6
2	5oz. 57ml	6oz. 68ml	7.5oz. 85ml	9oz. 102ml	10oz. 114ml	-	-	5oz. 53.9ml	6oz. 64.6ml	7.5 oz. 80.8ml	9oz. 97ml	10oz. 107.8ml	-	-
2.5	8oz. 91ml	10oz. 114ml	12oz. 136ml	14oz. 160ml	16oz. 183ml	20oz. 228ml	-	8oz. 86.2ml	10oz. 107.8ml	12oz. 129ml	14oz. 150.9ml	16oz. 172.5ml	20oz. 215.6ml	-
3	12oz. 136ml	15oz. 170ml	18oz. 205ml	21oz. 240ml	1.5 lb 274ml	30oz. 340ml	32oz. 410ml	12oz. 129.3ml	15oz. 161.7ml	18oz. 194ml	21oz. 226.4ml	1.5 lb 258ml	30oz. 323ml	32oz. 345ml
3.5	1 lb 182ml	1.25 lb 228ml	1.5 lb 274ml	1.75 lb 320ml	2 lb 364ml	2.5 lb 456ml	3 lb 548ml	1 lb 172ml	1.25 lb 215ml	1.5 lb 258ml	1.75 lb 301ml	2 lb 344ml	2.5 lb 430ml	3 lb 516ml
4	18oz. 205ml	23oz. 262ml	27oz. 308ml	2 lb 364ml	2.25 lb 410ml	3 lb 546ml	3.5 lb 637ml	18oz. 194ml	23oz. 247.9ml	27oz. 291ml	2 lb 344ml	2.25 lb 387ml	3 lb 516ml	3.5 lb 602ml
5	-	-	-	-	3.75 lb 682ml	4.75 lb 864ml	5.5 lb 1000ml	-	-	-	-	3.75 lb 645ml	4.75 lb 817ml	5.5 lb 946ml

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