

石膏粉 Investment powder

石膏粉系列产品是英国原装进口高质量产品，经过最高规格检验出厂。生产工厂系通过ISO9001认证工厂，拥有最先进的产品应用和 开发实验设施，高素质的开发和应用技术人员。这更有利于我们对开发新。这更有利于我们对开发新产品、分析材料特性、评估产品应用 过程和客户铸造提供最佳解决方案！

系列产品适合不同产品的不同要求，完全满足对贵金属铸造表面光滑、铸件细腻、无缺陷的要求！同时每个型号我们都有50磅和100 磅两种包装！我们也针对铂金和钯金的生产，专门引进了日本的A-1 (min) 石膏粉，同时为了替客户节约生产成本，我们也研发了更加 适合国内客户需求的艺辉牌铂金钯金石膏粉和艺辉牌不锈钢石膏粉。

UK imported high quality casting investment powder with strict quality standards control, factory passed ISO9001 equipped with advanced R&D testing facilities and professional engineers. All helps us to figure out the best solution during the process of new products design and audit.

Different series are available for various requirement to make a smooth, perfect surface casting items. We have 50 pounds and 100 pounds package. As the increased requirement or palladium and platinum casting, we imported Japan A-1(min) casting investment powder. Wat's more, considering the cost factor we developed Yihui Brand casting investment powder for palladium and platinum casting, which is more welcomed in domestic market.



艺辉牌石膏粉开粉程序 Usage instruction of Yihui brand investment powder

一、配粉比例:

- 1、量石膏粉1000克。
- 2、量水380~400毫升（水温要求在22°C左右）。
- 3、把水放入容器内，然后加入石膏粉。
- 4、搅拌3.5~4分钟。
- 5、倒入钢盅，然后再抽真空1.5~2分钟。
- 6、平放静置60~120分钟。

二、烧结:

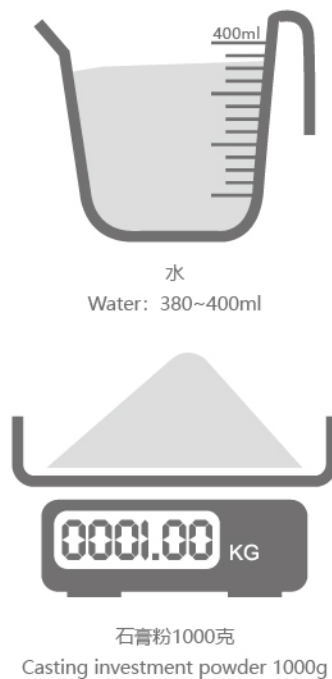
- 1、室温到180°C需120分钟，从180°C到270°C需150分钟，保持270°C用150分钟。
- 2、由270°C平均加热到730°C用150分钟。
- 3、保持730°C用180分钟。
- 4、然后回降到630°C左右，开始铸造。

I. Mixing rate:

1. Casting investment powder 1000g.
2. Water 380~400ml (Water temp about 22°C) .
3. Pour water into mixing chamber, then add casting investment powder.
4. Start mixing for 3.5~4mins.
5. Inject mixed investment powder into flasks, then start vacuum 1.5~2mins.
6. Take the flasks out, and wait 60~120mins before burning it

II. Burn process:

1. Put the flasks full with investment powder into oven, turn up the temp to 270°C within 60mins, and keep at 270°C with 180 mins.
2. Rise temp evenly from 270°C to 730°C in 150 mins.
3. Keep at 730°C with 180mins.
4. Start casting when the temp run down to around 630°C.



艺辉牌袋装大件石膏粉 Yihui brand bagged large gypsum powder

技术参数:

型号: P.33.C150
规格: 50磅/袋
适用范围: 适合金、银、铜铸造
Technical parameters:
Model: P.33.C150
Specification: 50 lbs/bag
Application: suitable for gold, silver and copper casting



艺辉牌袋装11石膏粉 Yihui brand 11 powder investment

技术参数:

型号: P.11.B050
规格: 50磅/袋
适用范围: 适合银、铜铸造
Technical parameters:
Model: P.11.B050
Specification: 50 lbs/bag, 100 lbs/bag
Application: suitable for silver and copper casting



艺辉牌袋装33石膏粉 Yihui brand 33 Investment powder

技术参数:

型号: P.33.B050
规格: 50磅/袋
适用范围: 适合金、银、铜铸造
Technical parameters:
Model: P.33.B050
Specification: 50 lbs/bag
Application: suitable for gold, silver and copper casting



艺辉牌桶装33石膏粉 Yihui brand 33 investment powder

技术参数:

型号: P.33.D100
规格: 100磅/桶
适用范围: 适合金、银、铜铸造
Technical parameters:
Model: P.33.D100
Specification: 100 lbs/drum
Application: suitable for gold, silver and copper casting



艺辉牌袋装66石膏粉 Yihui brand 66 investment powder

技术参数:

型号: P.66.B050
规格: 50磅/袋
适用范围: 适合铍、铜、K金铸造
Technical parameters:
Model: P.66.B050
Specification: 50 lbs/bag
Application: suitable for beryllium, copper, K gold casting



艺辉牌桶装66石膏粉 Yihui brand 66 investment powder

技术参数:

型号: P.66.D100
规格: 100磅/桶
适用范围: 适合铍、铜、K金铸造
Technical parameters:
Model: P.66.D100
Specification: 100 lbs/drum
Application: suitable for beryllium, copper, K gold casting



艺辉牌袋装99石膏粉 Yihui brand 99 investment powder

技术参数:

型号: P.99.B050
规格: 50磅/袋
适用范围: 适合铍、铜、K金铸造
Technical parameters:
Model: P.99.B050
Specification: 50 lbs/bag
Application: suitable for beryllium, copper, K gold casting



艺辉牌桶装99石膏粉 Yihui brand 99 investment powder

技术参数:

型号: P.99.D100
规格: 100磅/桶
适用范围: 适合铍、铜、K金铸造
Technical parameters:
Model: P.99.D100
Specification: 100 lbs/drum
Application: suitable for beryllium, copper, K gold casting





艺辉牌袋装树脂石膏粉 Yihui brand resin investment powder

技术参数：
型号：P.RC.B050
规格：50磅/袋
适用范围：铸造树脂专用
Technical parameters:
Model: P.RC.B050
Specification: 50 lbs/bag
Application: suitable for resin casting



艺辉牌桶装树脂石膏粉 Yihui brand resin investment powder

技术参数：
型号：P.RC.D100
规格：100磅/桶
适用范围：铸造树脂专用
Technical parameters:
Model: P.RC.D100
Specification: 100 lbs/drum
Application: suitable for resin casting



艺辉牌袋装蜡镶石膏粉 Yihui brand gemstone inlay investment powder

技术参数：
型号：P.SC.B050
规格：50磅/袋
适用范围：适合蜡镶铸造
Technical parameters:
Model: P.SC.B050
Specification: 50 lbs/bag
Application: suitable for gemstones inlay casting



艺辉牌桶装蜡镶石膏粉 Yihui brand gemstone inlay investment powder

技术参数：
型号：P.SC.D100
规格：100磅/桶
适用范围：适合蜡镶铸造
Technical parameters:
Model: P.SC.D100
Specification: 100 lbs/drum
Application: suitable for gemstones inlay casting



艺辉牌铂金石膏粉 Yihui brand investment powder for platinum

技术参数：
型号：S.900.C25
包装：纸箱包装
重量：25kg/箱
适用范围：铂金
Technical parameters:
Model: S.900.C25
Package: Carton
Weight: 25 kg/carton
Application: Suitable for platinum



艺辉牌不锈钢石膏粉 Yihui brand investment powder for stainless steel

技术参数：
型号：P.316.C25
包装：袋装
重量：25kg/袋
适用范围：不锈钢铸造
Technical parameters:
Model: P.316.C25
Package: Carton
Weight: 25 kg/carton
Application: Suitable for Stainless steel casting



艺辉牌不锈钢、钯金、铂金石膏粉开粉程序

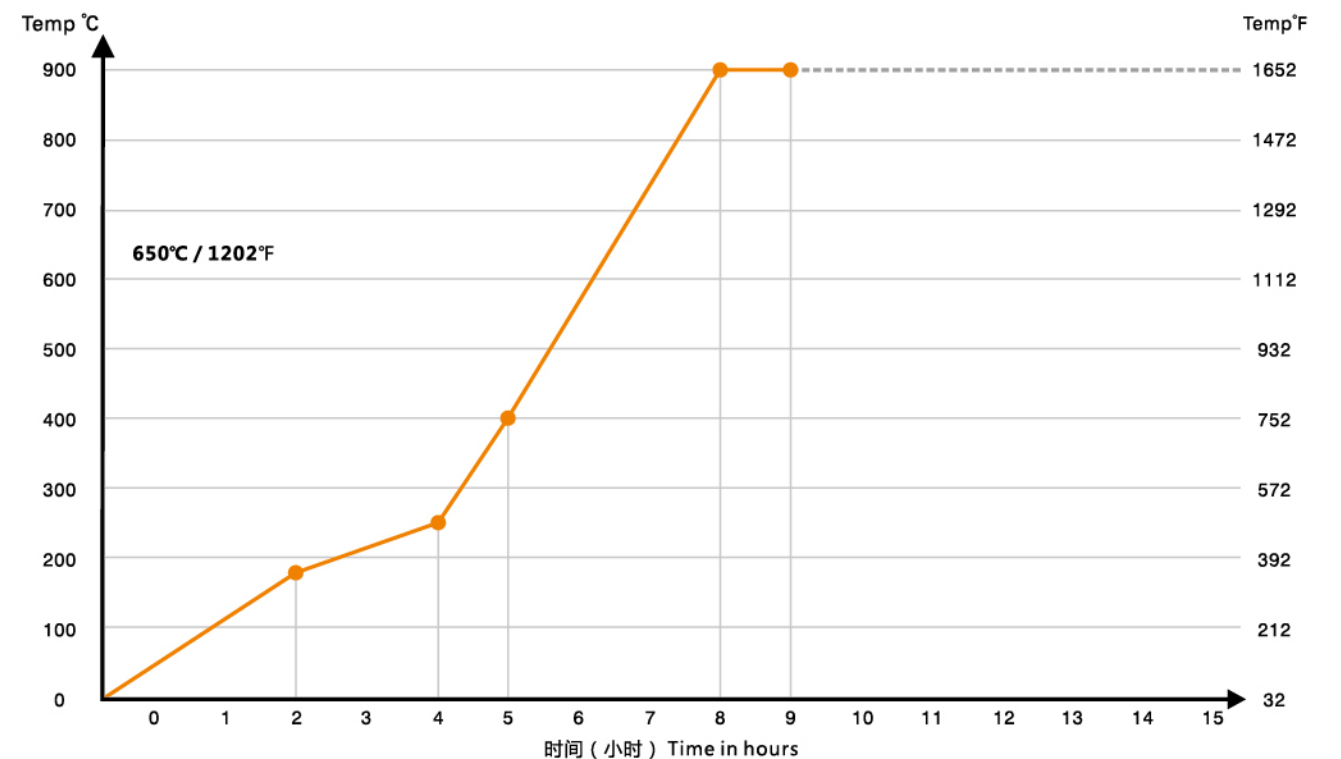
Usage instruction of Yihui brand investment powder for stainless steel, palladium and platinum

- 1、调配催干剂**
催干剂与水的比例：催干剂60毫升+水1000毫升，搅拌均匀，制成混合液，用后请封好瓶盖。
- 2、调配不锈钢石膏**
把不锈钢石膏粉加入到混合液中，用电动搅拌机搅拌5~10分钟。粉和混合液的比例：不锈钢石膏粉3333克+混合液1000毫升。
- 3、开粉**
在这阶段，钢盅必须放置在专用吸水纸上，让水份平均地排去，利用吸水纸，也可确保防漏不锈钢石膏粉。
- 4、抽真空**
抽空真空时间约8分钟左右。
- 5、不锈钢石膏粉烧结时间程序（如下图示）**
除蜡：由室温到180°C需时间120分钟。
烧结：由180°C到250°C需时间120分钟。
由250°C到400°C需时间60分钟。
由400°C到900°C平均每30分钟升温100°C，即需时150分钟达到900°C，维持900°C温度约60分钟。
注：以上（4）、（5）两项操作作为参考数据，请按实际情况稍作调整。

- 1. Siccative mixing**
Mixing rate: 60ml siccative+1000ml water to make mixed liquid, then cover on.
- 2. Stainless steel investment power mixing**
Add investment power into the mixed liquid, electrically stir it with 5~10mins, mixing rate: 3333g stainless steel investment power+1000ml mixed liquid.
- 3. Investment casting process**
Put the flask on the special absorbent paper.
- 4. Vacuum**
Vacuum flask filled with mixed investment power around 8mins.
- 5. Burn steps, following process for reference only**
Dewaxing: turn the oven to 180°C with 120mins.
Burning: rise temp from 180°C to 250°C with 120mins.
Turn up the temp from 250°C to 400°C with 60mins.
Increase temp from 400°C to 900°C evenly with 150mins, 100°C up per 30mins, when temp arrived 900°C keep 60mins.
Remarks: The above step (4) and (5) are for reference only, please adjust the setting data based on particular use.

烧结程序示意图 Platinum powder burnout cycle

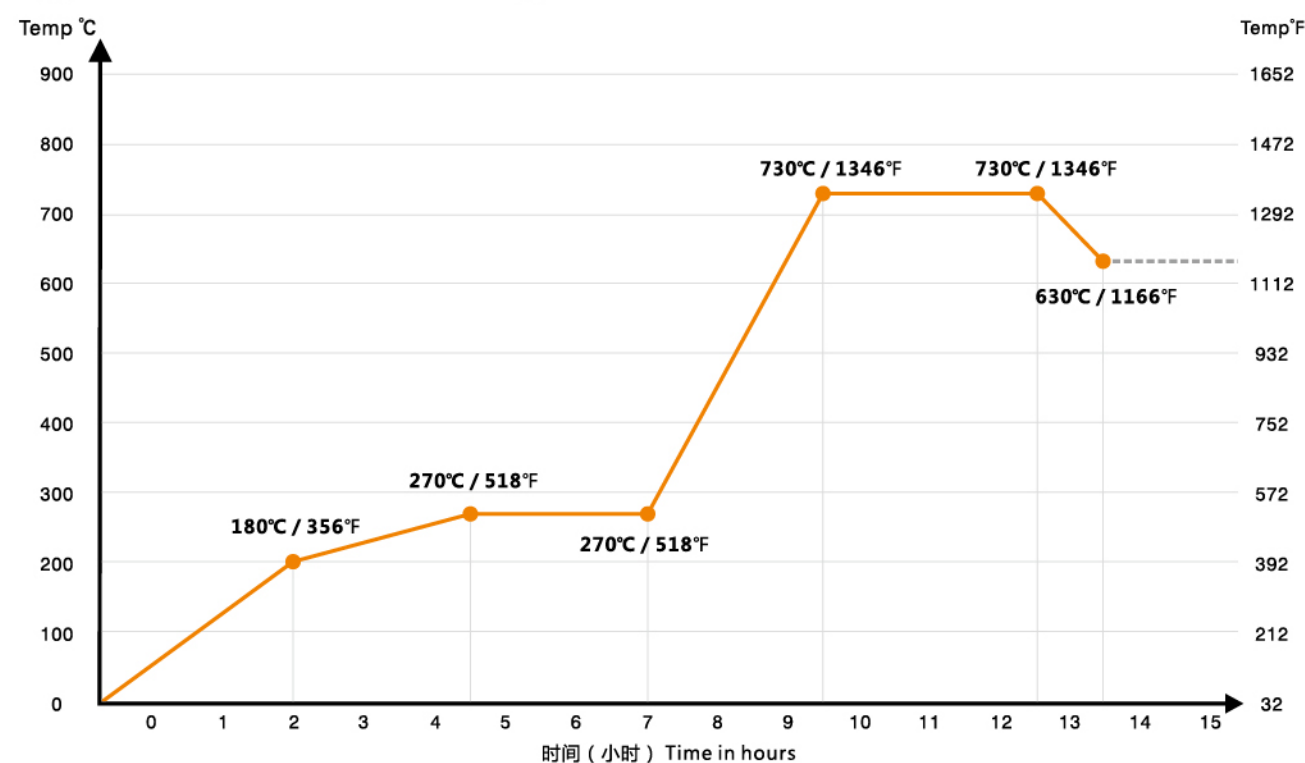
适用于艺辉牌钯金、铂金、不锈钢石膏粉
Apply to Yihui brand investment casting powder for palladium, platinum, stainless steel.



金\银\铜烧结程序示意图 Gold\Silver\Brass powder burnout cycle

适用于艺辉牌00、11、33、66、99石膏粉

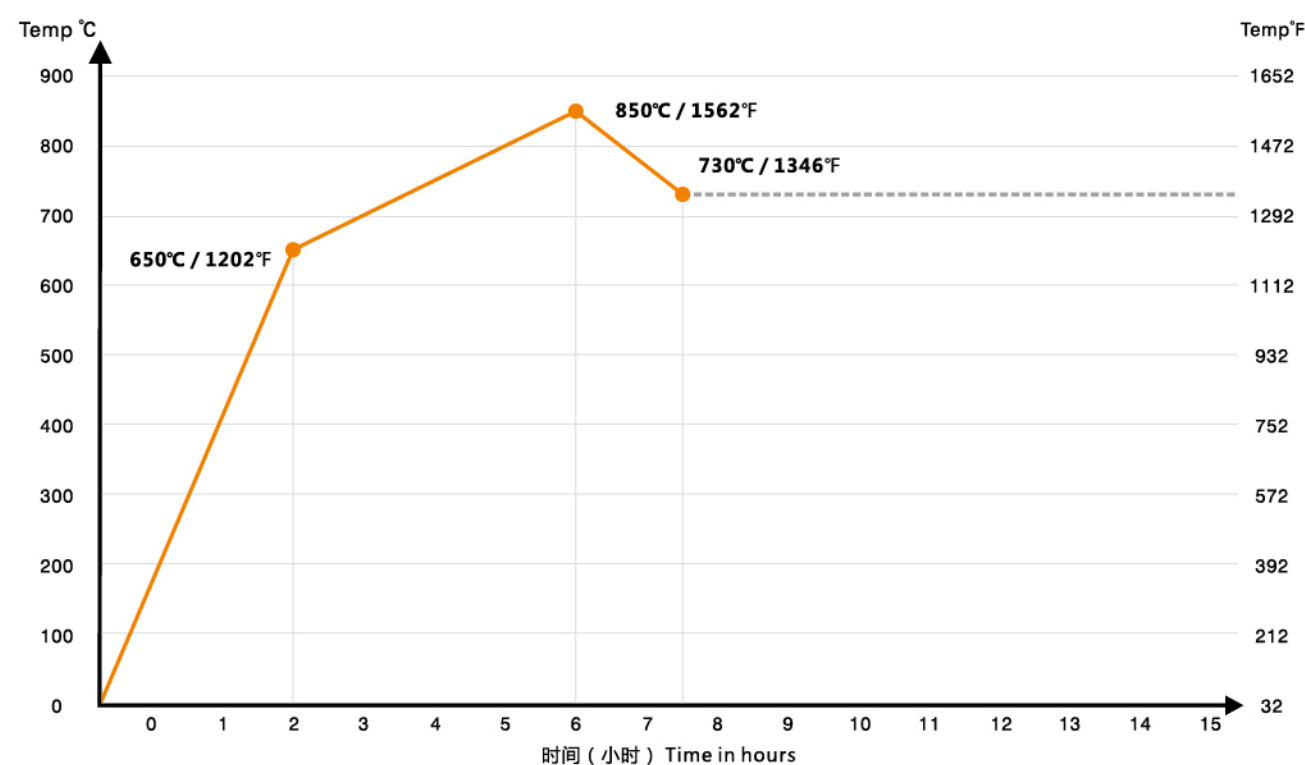
Apply to Yihui brand 00, 11, 33, 66, 99 investment casting powder.



树脂石膏粉烧结程序示意图 Resin powder burnout cycle

适用于艺辉牌树脂石膏粉

Apply to Yihui brand resin investment powder.



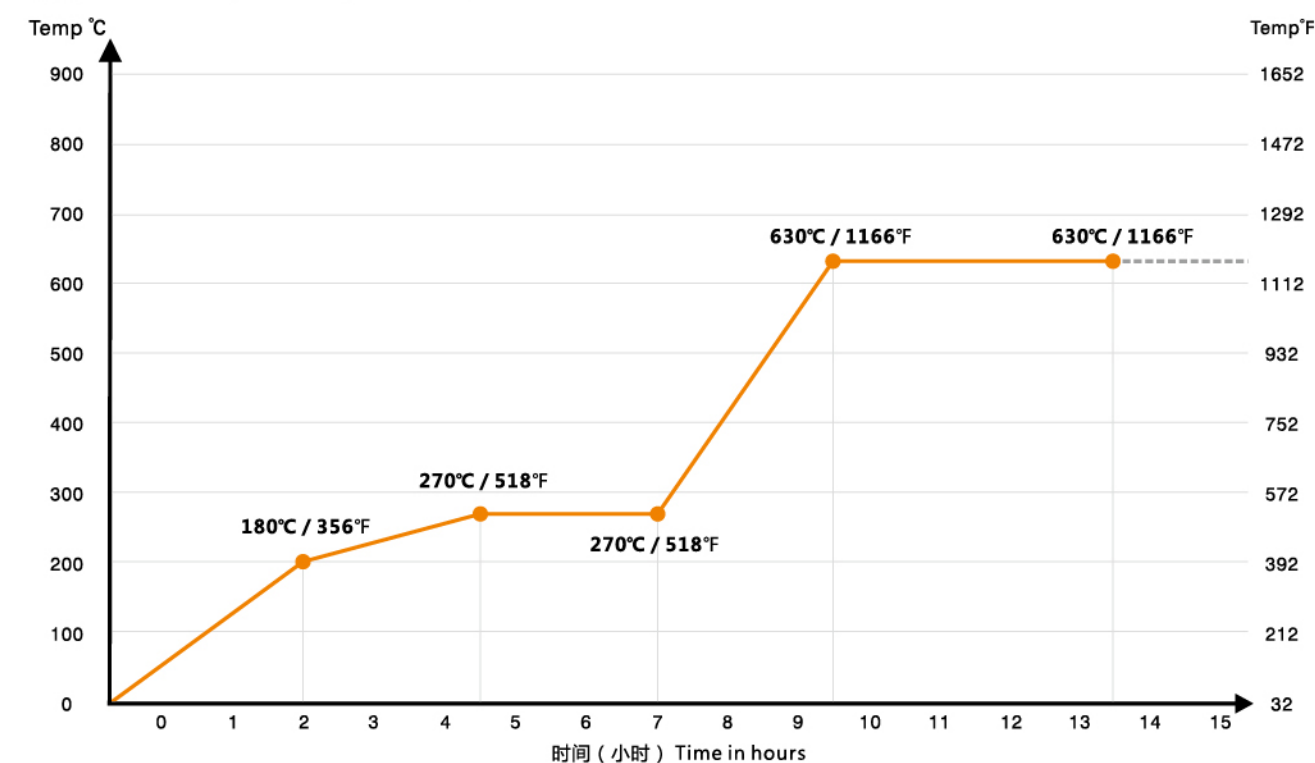
备注：以上数据仅供参考，请根据具体情况调整

Remark : Above info is for reference only, it is subject to factory manual.

蜡镶石膏粉烧结程序示意图 Gemstone inlay investment powder burnout cycle

适用于艺辉牌蜡镶石膏粉

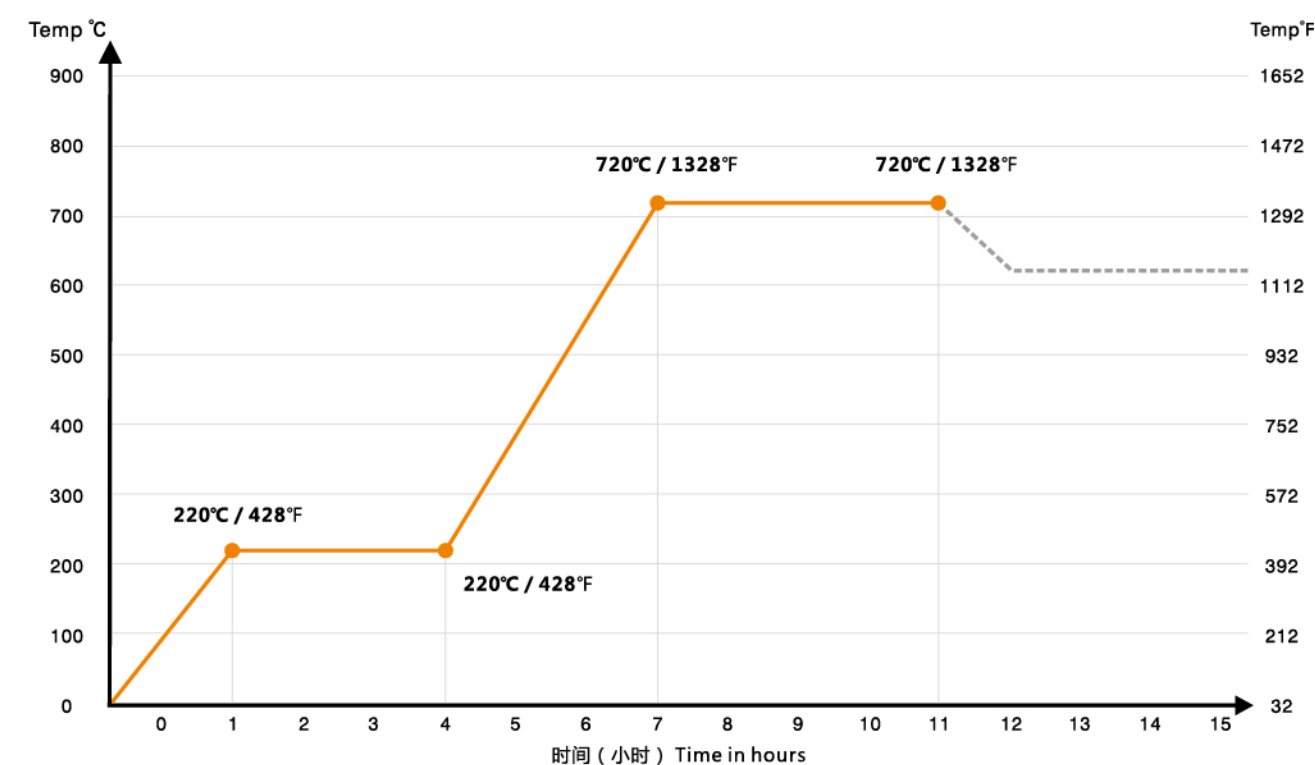
Apply to Yihui brand gemstone inlay investment powder.



铍铜烧结程序示意图 Brass powder burnout cycle

适用于艺辉牌铍铜石膏粉

Apply to Yihui brand brass powder.



备注：以上数据仅供参考，请根据具体情况调整

Remark : Above info is for reference only, it is subject to factory manual.