

## Casting Parameters for Silver & Gold with PIC100

### Burn out Cycle:

Please use the following burn out cycle, but make sure that the ring has been fully post cured in the OTO Flash unit. Please follow very carefully Post Curing Instructions.

### Please note:

Please make sure to let the investment sit outside for a minimum of two to three hours before you put in the oven so it is extremely dry or else it will start boiling.

Please make sure to use **Satin Cast 20 investment** for silver and gold.

Please make sure to cure the parts for a minimum of 10000 pulses on each surface.

**PLEASE MAKE SURE OVEN IS COLD WHEN YOU START BURNOUT CYCLE**

Make sure the investment is sitting at least one inch (25mm) above the oven floor.

Please make sure that you follow the burnout cycle recommended below for fine detail parts:

0 - 65°C in 1 hours hold 3 hours
65°-550°C in 2 hours hold 3 hours
550° - 825°C in 3 hours hold 3 hours (5 hours for extra large pieces)
825° - 725°C in 2 hours wait 2 hours then cast your part in silver

**\*\*\*Please note that if parts are not cured using the curing oven provided by Envisiontec the results will not be satisfactory\*\*\***