



GOLD STAR XL

Gold Star XL is a high quality economic gypsum bonded investment powder solution for casting Brass and Silver alloys.

The casting of Silver and Brass for the jewellery and costume jewellery market accounts for a large percentage of worldwide production. Costs need to be minimized and Gold Star XL achieves this whilst also producing superior castings and excellent surfaces, keeping finishing work prior to plating to an absolute minimum.

Gold Star XL is specifically formulated by optimizing the particle size distribution and thermal expansion to help casters compete in the most demanding of environments for casting Brass and Silver.



Gold Star Powders

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Do not remove flasks from furnace to cast until they have been held at casting temperature for a minimum of 1 hour. If held for less than 1 hour, the core of the flasks will be at a much higher temperature than the digital temperature display states, and may result in metal mould reaction.

- Do not cast with a flask temperature lower than 650°C
- Slurry temperature 21°C
- Leave for 90 min to stand before burnout

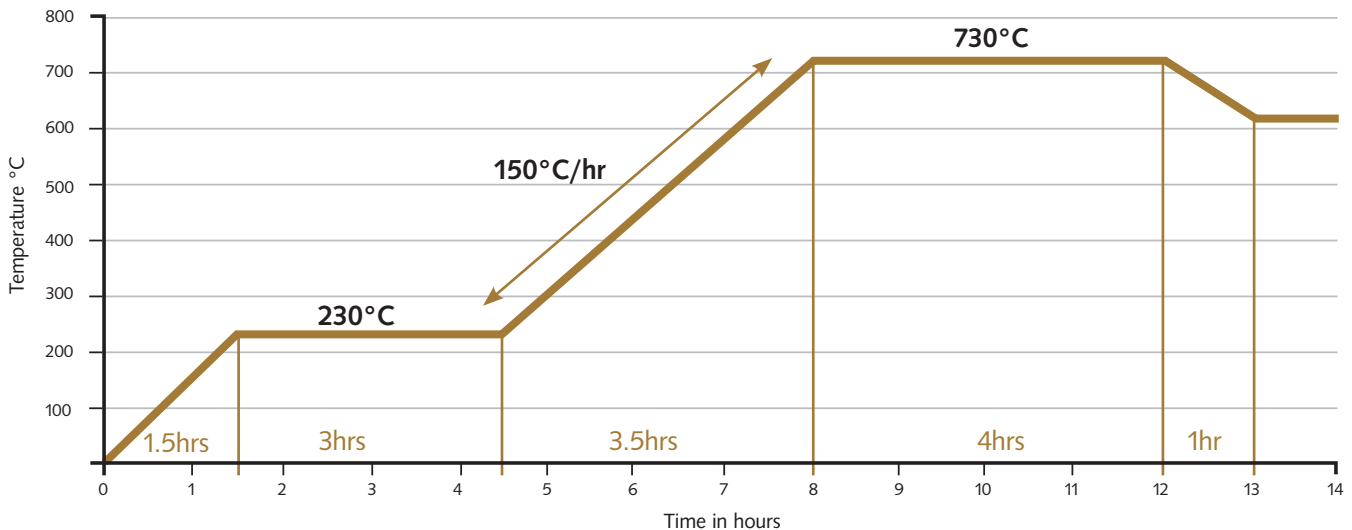
WATER TO POWDER RATIO

MACHINE VACUUM MIXING	38:100
HAND MIX THEN VACUUM	40:100

MACHINE VACUUM MIXING	Min.
Weigh out water and powder	0
Add powder to water	0
Mix under vacuum	5
Pour flasks	2
Vacuum flasks	1
Total time take	8

HAND MIX THEN VACUUM	Min.
Weigh out water and powder	0
Add powder to water and mix	4
Vacuum mixer bowl	1
Pour flasks	1
Vacuum flasks	2
Total time taken	8

BURNOUT CYCLE



Gold Star XL
is available in 22.5kg sacks

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