

Specifically designed for jewelry casting

The 900D is an excellent white wax resin specifically designed for jewelry casting. It boasts higher strength and lower shrinkage, resulting in precise dimensions and outstanding surface quality for the casted products.

3D printing jewelry casting resin

Colours: Yellow

- High wax content, can burn completely without ash.
- Higher intensity
- Smooth surface, clear sharp corners
- Low coefficient of thermal expansion
- Lighter weight, 45% lighter than ordinary resin
- Suitable for casting gold, diamonds, delicate models or thick-walled parts



content	Data value	testing method
color	yellow	
viscosity	260cps(25°C)	ASTM D1084-1997
density	1.2~1.3g/cm ³	ASM D1875-69(1980)
shrinkage	< 0.5%	Capillary method
hardness	50D	ASTM D2240-05(2010)



Storage (Precautions for use): White wax is easy to solidify at low temperature. If the ambient temperature is low, first heat the resin to above 25 degrees and stir evenly. The temperature of the printing chamber is above 25 degrees Celsius during printing.

Gypsum powder recommendation

(choose high strength gypsum powder can achieve better casting effect.)



<Prestige OPTIMA™>

Recommend:

- 1.Prestige OPTIMA : <https://www.certus-int.com/optima>
- 2.Gilcast HS SOFT : <https://www.srlidental.com>
- 3.GRS : <https://www.goodwin.co.uk/>
- 4.TT resin powder (TECAST RESINCAST)

Printing parameter settings

machine	layer height	exposure time	bottom exposure time
Gold Giant 12k	0.03mm	3s	30s
Mini giant pro	0.025mm	3.5s	60s

bottom layer count	transition layer vount	rest time after retract
6	4	1.5s
10	5	1s

How To Cast

—. Post-processing process

(Strictly follow each process to operate, do not skip or omit!)

Jewelry Type	95% ALCOHOL (CLEAN)	ULTRASONIC CLEANING	HOT WATER	UV CURING MACHINE (HIGH POWER MERCURY LAMP OVEN)
Thin-wall	1~2min	5min	80~100°C	10min
Thick-wall	2~3min	8min	80~100°C	15min
Filament	1~2min	5min	80~100°C	10min
Inlaid	2~3min	6min	80~100°C	15min

1. Rinse the resin on the surface with alcohol
2. Wash for another 5 minutes
3. Ultrasonic cleaning for 5 minutes
4. Place in hot water to cure for 30 minutes
5. Take out the model
6. Put it into the curing box again (800w curing for 15 minutes)

Remark:

1. Select the corresponding post-processing process according to the jewelry type.
2. It will turn white after curing, if it is still yellow, it means that the curing is not complete.
3. *The surface must be thoroughly clean and dry before entering the casting process, which is critical and will affect the casting effect.
4. *Please use resin powder for casting (**important**), it is recommended to use: Prestige OPTIMA or Gilcast HS SOFT

二.Casting aspects

INSTRUCTIONS FOR MIXING

Powder: Water Ratio (38% - 40%)	Powder (Kg.)	Water (cc.)	Powder (Lb.)	Water (cc.)
Automatic Vac. Mixing	1	380	1	172
Conventional Mixing	1	400	1	181.6
Water Temperature °C	21-24	21-24	21-24	21-24

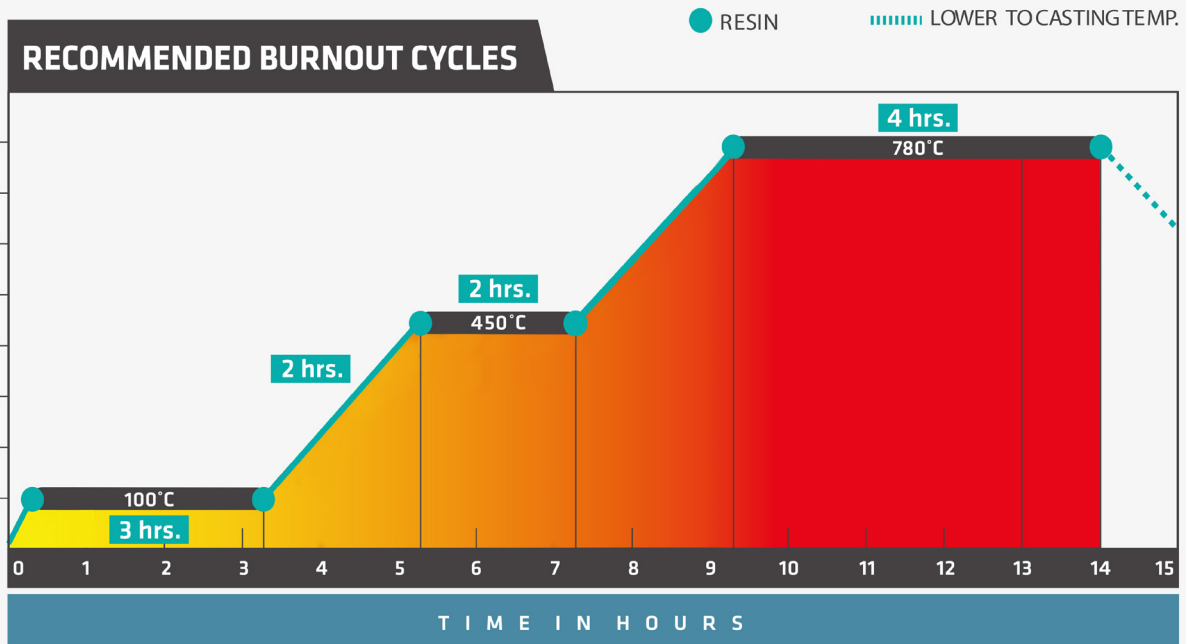
- Increasing the powder amount 1% will decrease the total working time for approximately 30 seconds.

Automatic Vac. Mixing Mach.	Minutes
Accurately Weigh Powder / Water	-----
Add Powder to Water	-----
Mixing & Vacuuming	5
Pour into Flask	2
Vacuum Invested Flask	1
Total Working Time	8

- Allow to sit undistributed for 90-120 minutes before burnout

Conventional Mixing Mach.	Minutes
Accurately Weigh Powder Water	-----
Add Powder to Water & Mix	4
Vacuum the Bowl	1
Pour into Flask	1
Vacuum Invested Flask	2
Total Working Time	8

- Allow to sit undistributed for 90-120 minutes before burnout



- Flip flask upwards while ramping down to casting temperature.
- Please contact the manufacturer for other recommended burnout cycles

Remarks:

It is recommended to use centrifugal casting machine when casting, which can make the molten metal flow to every place of the model, so that the success rate of casting is greatly improved.

The temperature of molten liquid during casting is controlled in the range of 1000°C, If the temperature of molten metal is too high, the inner wall of plaster mold will be broken and the casting effect will be affected.



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