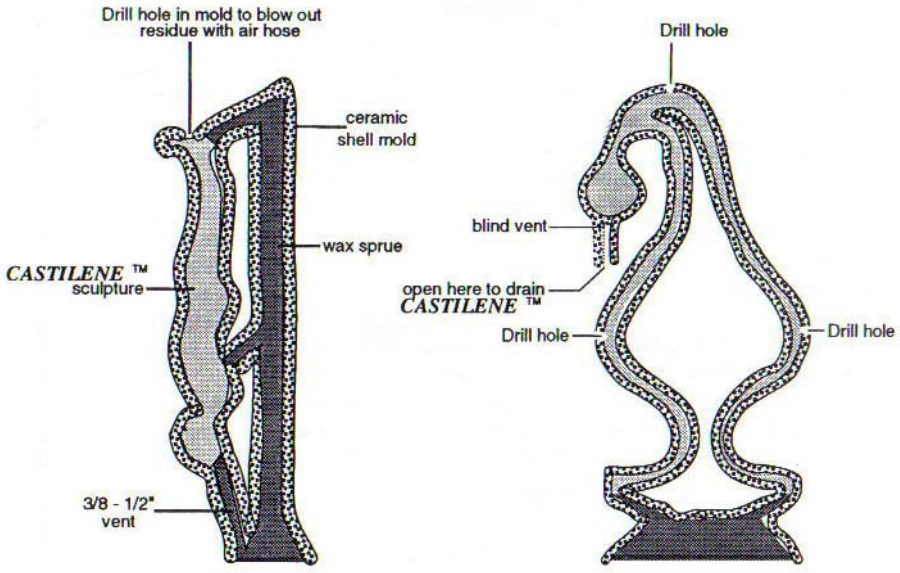
# New: Meltable/Brushable Clays from Chavant

## CASTILENE: IMPORTANT FOUNDARY PROCEDURE

Because CASTILENE™ is a new product, and therefore unfamiliar to some foundries, we offer the following suggestions for successful burnout.

The foundry should treat a CASTILENE™ sculpture much as a wax pattern would be treated when sprueing and gating with the exception that larger vents and drilled holes be used for better flushing and blowing out the powdery residue of the material.




CASTILENE™ contains an amount of organic material in its formulation and therefore should be burned out and for a longer time than straight wax models.

It is recommended that a temperature of 1500°F be maintained for 15 to 20 minutes longer than your normal burnout time for microcrystalline wax sculptures in ceramic shell molds. Apply a temperature of 1000°F or above for 1 to 2 hours longer (depending on the size of the mold) if using a plaster based investment.

A small amount of powdery residue may be left in the mold after burnout. This residue should be blown out with an air gun through the sprue and vents if using a ceramic shell and vacuumed out if using a plaster based investment. This procedure will insure fidelity to the surface detail of the casting.

If CASTILENE™ is trapped in an area of the mold that cannot drain freely, it may char into hard pieces of material that cannot be blown out. This will result in imperfections in the casting.

When draining, do not allow CASTILENE™ to burn or flame. Burning may cause the material to form charcoal pieces too large to blow out of the mold. After draining, the temperature of the mold may be raised to complete the burnout.