

910 Investment Core Material

910 investment core material is a calcium sulfate bonded investment used for cores. It is used with non-ferrous alloys which do not exceed temperatures of 2200° F (1200° C). 910 investment core material has good green strength, good thermal shock resistance, is easily removed after casting and can be used directly in contact with the wax pattern.

Application Recommendations

Water/Powder Ratio by Weight*	28/100
Working Time	10-11 minutes
Setting Time	12-14 minutes

*To improve the strength of 910 investment core material, replace a portion of the water with Core Hardener 2000™ binder. Flow characteristics are reduced when using higher percentages of Core Hardener 2000 binder. It is recommended to use 2 parts water to 1 part Core Hardener 2000 binder by volume.

1. Calcium sulfate bonded core materials require core pins to hold them in place. Place core pins through the wax until they protrude at least ½" into the cavity to be cored. This distance will vary depending on the size of the core. They should extend about ½" outside the wax so the shell can be built around them.
2. Powder should be added to water in the proper proportions and mixed by hand or mechanically to make a smooth consistency.
3. Pour the core material into the cavity. Some vibration may be used to help fill the core easier and remove entrapped air. Allow the completed core to set 3-4 hours before further processing.
4. It is important to remember that when a complete-fill core material is used, you must allow extra time during dewaxing and burnout to completely dry and burn out the core. Failure to burn out the core completely may lead to outgassing when metal is poured.
5. Where autoclave dewaxing is used to remove the pattern, the pressure must be released very slowly to prevent destruction of the core material.
6. Placing vents into the cores to help in drying and eliminating gases during casting is recommended.

Storage & Handling

Shelf life is 1 year from date (MMDDYY) in batch lot number on label. Rotate stock to maximize shelf life.

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