











Stages Of Investment Casting Process

Wax				
				
We start by making a pattern in brass. This is an exact replica of the final component.	And use the pattern to cast cavities in a die for wax casting.	Molten wax is injected in to the die.	The wax piece is removed from the die.	The wax pieces are assembled in a cluster of tree, where the branches are ingates.
Ceramic				
				
Then the wax cluster is dipped in a ceramic slurry.	And held under falling ceramic powder.	The cluster is alternately dipped in a ceramic slurry and held under a sand shower, until the required shell thickness is achieved.	The wax is removed from mould.	The mould is 'dead burnt'.

Steel



We cast directly in to the hot mould.



The mould is knocked out.



The cast tree is cleaned for ceramic, residuals by shot blasting.



The pieces are removed from the runners and sprues, and the ingate is ground off.



Dispatch