

iForm Cast05

Specifically designed for jewelry casting

Color: Yellow

Wavelength: 405nm

- High wax content, easy to cast
- Low shrinkage
- Low ash
- Fine surface detail
- high strength and stiffness
- Suitable for casting gold and silver



Color	Yellow	/
Viscosity	450~550cps (25℃)	ASTM D1084
Density	1.06~1.075g/cm ³	ASTM D1875-69

iForm Cast05 will become solidify at low temperature. At this point, the resin needs to be soaked in hot water until it returns to liquid and ensure the ambient temperature is above 25℃.

Printing parameter settings

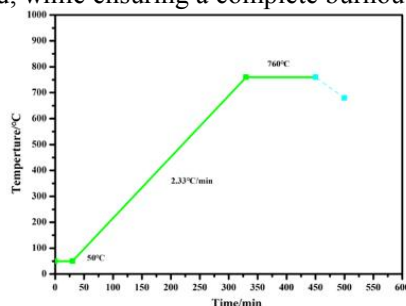
Layer height	Exposure time	Bottom exposure time	Film
0.05mm	5.5s~6.5s	30s~40s	ACF
Bottom Layer Count	Transition Layer Count	Rest Time After Lift	Rest Time After Retract
6	10	2s	2s

Washing and Post -Curing info

1. Soak Cast05 prints in alcohol(95%) for 30minutes
2. Put Cast05 prints and alcohol(95%) into the ultrasonic machine for 5minutes
3. Put Cast05 prints in 90~100℃ water, and then Cure in a high power UV curing box for 30mintues
4. Dry the Cast05 prints (**important**)
5. Store to avoid exposure to the air.

Standard burnout schedule

The following burnout schedule is designed to help reduce thermal expansion of resin in the mold, while ensuring a complete burnout for thick jewelry parts.



PHASE	TIME	SCHEDULE °C
Hold	30mintues	50℃
Ramp	300mintues	2.33℃/min
Hold	120mintues	760℃
Casting Window	Desired casting temp	