

## **EASY STEPS TO INVESTING WITH PRESTIGE JEWELRY CASTING INVESTMENTS**

### **MANUAL MIXING**

1. Weigh the powder and measure the appropriate amount of water at a ratio of 38 – 40/10 (38 to 40 mls. of water per 100 grams powder).  
Note: Use 38% water for heavy men's rings and larger designs. / Use 39% - 40% water for ladies rings. / use 40% water for fine filigree and delicate designs.
2. Add the powder to the water. Mix on low speed for 1 minute, then medium speed for 3 minutes.
3. Place mixing bowl under full vacuum. Vacuum mix until it rises, breaks, drops in the bowl and begins to boil. Continue to vacuum for an additional 1.5 minutes.
4. Remove bowl from vacuum. Pour investment down along the inside of the flask and as much as possible, avoid hitting the patterns directly with investment.
5. Place invested flasks under vacuum. Vacuum until the investment begins to boil and continue vacuuming for an additional 1.5 – 2 minutes.
6. Remove flasks from vacuum chamber and allow to sit in a calm, vibration free area for 1 – 2 hours. NOTE: One (1) hour for small flasks, Two (2) hours for flask 4" X 6", or larger.
7. Place flasks into a preheated burnout oven at the temperature listed in the instructions.