



Advisory



Upgrade / Repair / Retrofit



Safety Alert

Projet DP 3000
Burnout Parameters

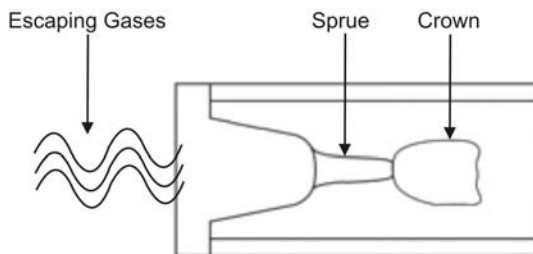
ProJet DP3000

Purpose

This procedure provides the burnout parameters needed when using ProJet DP3000 in an investment casting process. The information provided in the following procedure is specific to the ProJet DP3000 material and is not intended to be a substitute for or to supersede the standard operating procedure for a particular machine or build material.

Procedure

1. Set the oven temperature to 500 °F or less to start.
2. Orient the casting rings horizontally as shown in the figure below. This allows gas to fully escape during the burnout process.



3. Set the climb rate to 15 degrees per minute.
4. Bring the oven temp to 800 ° F and hold for 30 minutes.
5. Climb to the final temperature (for your particular investment material), and hold for 1 hour.
6. Add an additional 10 minutes to the final hold for each additional ring.



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Frequently Asked Questions

Question: What is the best final temperature to use?

Answer: Please follow the recommendations of your investment manufacturer for final temperature.

Question: What sprue technique is best for this material?

Answer: Use the same techniques you always use for the specific alloy and pattern you are casting.

Question: What is the best investment to use?

Answer: Extremely ultra fine investments have a tendency to trap gasses and can cause incomplete castings. Most of the major investment brands work very well.

Question: Why do I need a longer burn out time?

Answer: The material does not run out of the ring like wax. It burns out and is virtually ash free when completely burned out. This requires a complete burn out procedure.