

### Burnout Cycles

For SC Series, KC2000, SV20

#### Casting Temperatures

Women's rings; intricate designs

900° - 1000°F (482°-538°C)

Men's rings; heavier designs

700° - 900°F (371°-482°C)

During final 1—2 hours of burnout, adjust temperature so flasks are at correct casting temperature.

#### 5 Hour Cycle

2.5 in x 2.5 in  
(63 mm x 66 mm)

#### 8 Hour Cycle

3.5 in x 4 in  
(89 mm x 100 mm)

#### 12 Hour Cycle

4 in x 8 in  
(100 mm x 200 mm)

**1350°F (732°C)**

5 Hour - 2 Hr  
8 Hour - 3 Hr  
12 Hour - 4 Hr

**900°F (482°C)**

8 Hour - 1 Hr  
12 Hour - 2 Hr

**700°F (371°C)**

5 Hour - 1 Hr  
8 Hour - 2 Hr  
12 Hour - 2 Hr

**300°F (149°C)**

5 Hour - 1 Hr  
8 Hour - 1 Hr  
12 Hour - 2 Hr

**73°F (23°C)**

Ambient

**Casting temp.**

5 Hour - 1 Hr  
8 Hour - 1 Hr  
12 Hour - 2 Hr

**Cast**

Note: Graph is meant as a guide only. Adjustments should be made as necessary.

5, 8, and 12 Hour Cycles represent hold times only and do not include ramp time.

Recommended ramp time of approximately 9°F (5°C) per minute.

**ALLIED MINERAL PRODUCTS, INC.**

Corporate Headquarters: Columbus, Ohio, USA | Phone: +1 -614-876-0244 | email: [info@alliedmin.com](mailto:info@alliedmin.com)

### Burnout Cycle for SC-D Investment Powders

Typical 8 hour Cycle

Most conventional burnout procedures may be applied, with the exception of paying special attention to the Maximum Burnout temperature.

2 Hour -	300°F / 149°C
2 Hour -	700°F / 371°C
<b>Maximum Temperature</b> 3 Hour -	Max. Temp.
1 Hour -	Casting Temp.

#### Maximum Temperatures

Diamond: 1050°F/566°C

Gemstones: 1100°F/593°C

Cubic Zirconia: 1350°F/732°C

#### Stone in Place Process

**Stones recommended:** Diamond, Sapphire, Ruby, Cubic Zirconia and Synthetic Stones

#### Investment Removal

Never quench—The sudden temperature shock normally results in cracking of the stones. Allow flask to sit at room temperature for at least two hours, at which time the tree can be loosened from the flask by tapping with a rubber mallet. When cool enough, soak the tree in an investment removal solution.

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