

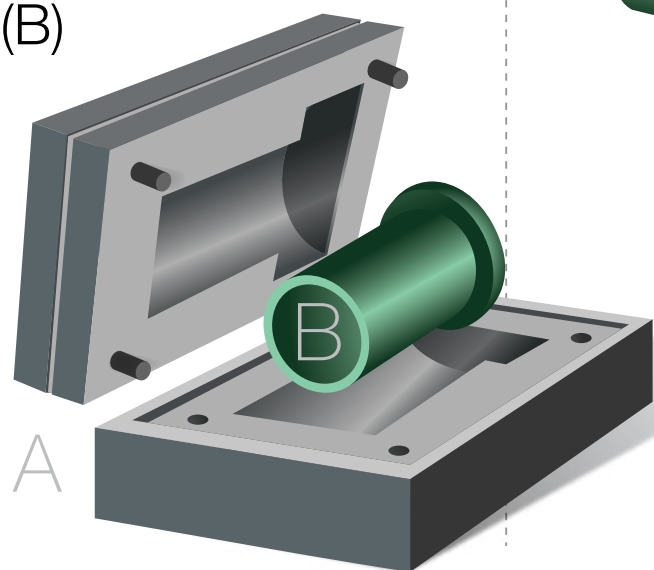
# Investment Casting Process Steps

**Kormax**

1

## Tooling and Pattern Making

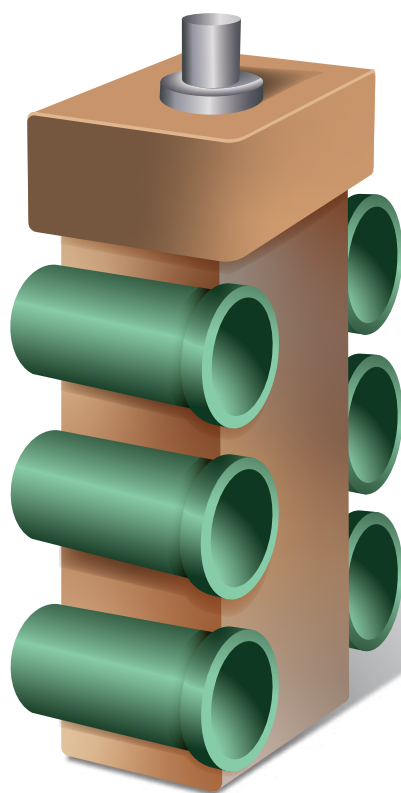
A tool is built to customer-provided specifications (A). Cold wax is then injected into the tool to create a wax pattern/prototype (B) that will hold precise dimensional requirements in the final casting.



2

## Pattern Assembly

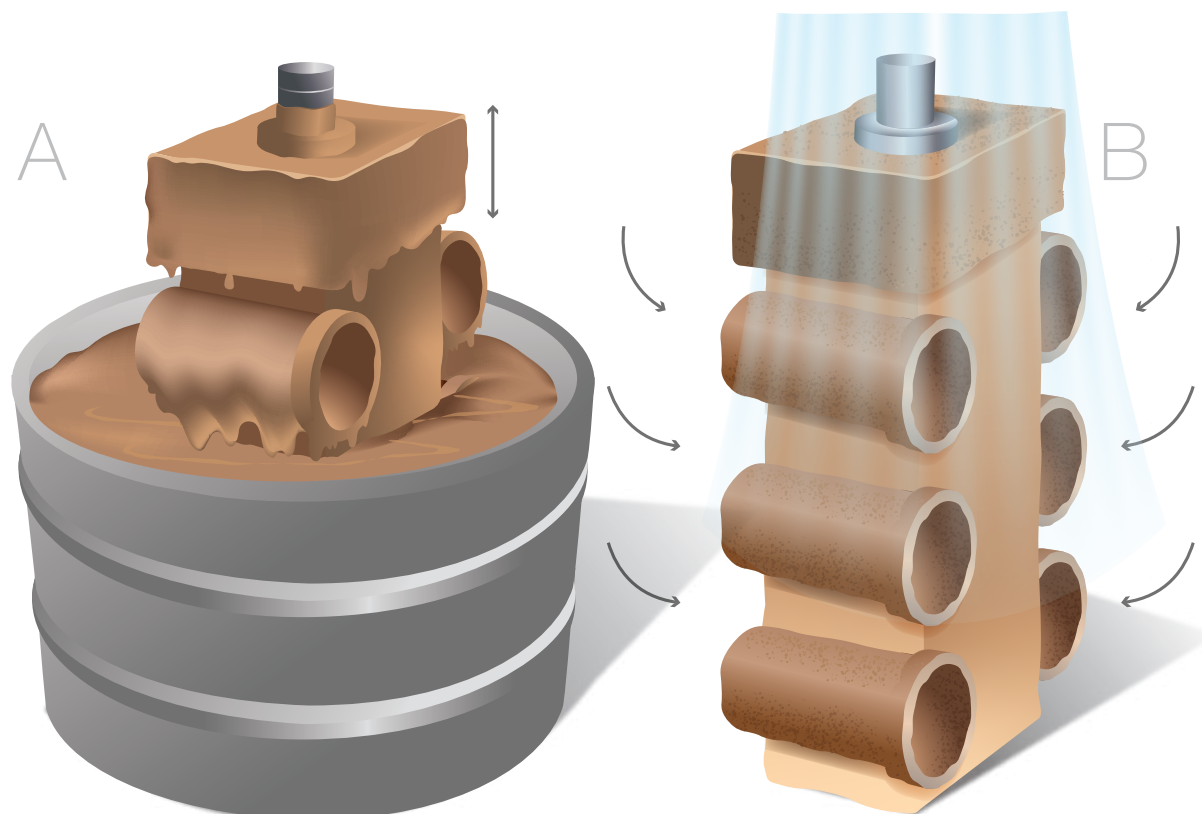
The wax patterns are assembled onto the sprue



3

## Dipping and Coating

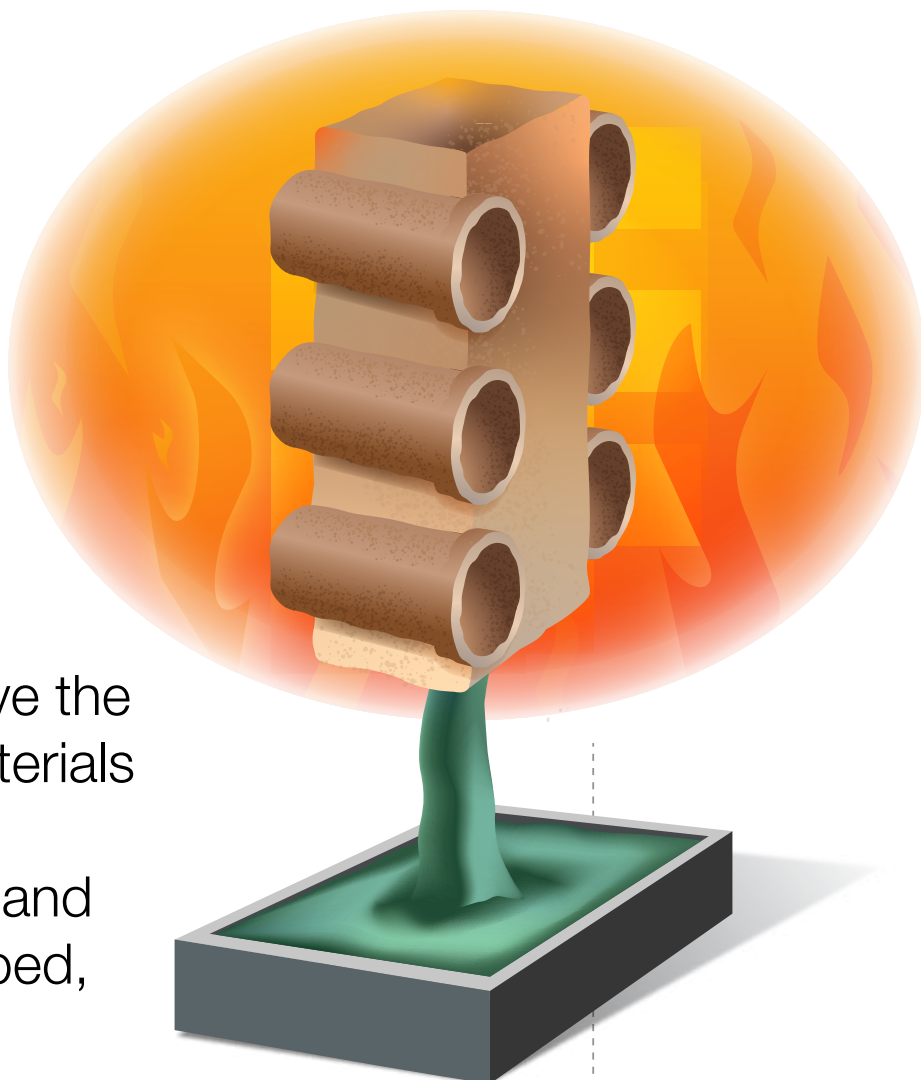
Successive layers of ceramic (A) and stucco (B) are applied to the sprue assembly to form a hard shell.



4

## De-Waxing and Firing

The moulds are flash-fired to remove the wax and sprue materials and then heated to 500 °F - 550 °F and placed on a sand bed, ready for pouring.



5

## Casting

Molten metal, 2910 °F to 3000 °F is poured into the hollow mould and then cooled.



6

## Knockout

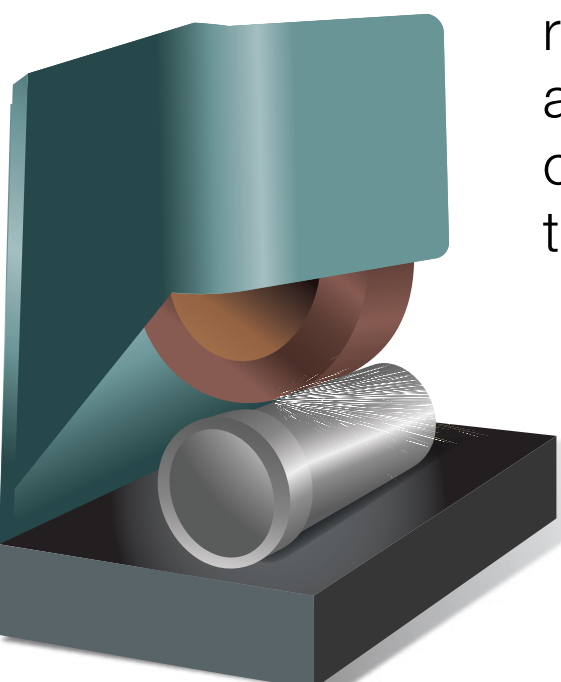
The ceramic shell is broken off, and the individual castings are cut away.



7

## Finishing

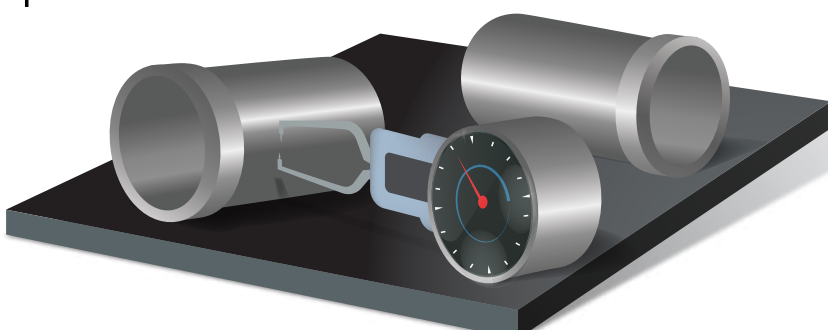
Excess metal is removed, surfaces are finished, and castings are heat treated



8

## Testing and Inspection

Casting undergo through testing and inspection to ensure that they meet dimensional tolerances and specifications



9

## Packing and Shipping

Castings are securely packaged for shipping to the customer.

