



# SYNERGY INVESTMENT POWDER

**MANUFACTURED WITH NANOTECHNOLOGY**

***A Premium Investment Powder for Resin/CAD casting,  
which has been tested and approved worldwide.***

Synergy was developed by G3D in the United Kingdom - tried and tested by jewellery manufacturers worldwide. It is designed Primarily for investing, burnout and DIRECT CASTING of your resin/wax patterns.

Synergy is an investment powder for CAD/CAM resin direct casting

Highest Quality raw materials sourced and graded for Resin/CAD direct casting

Synergy can also be used to produce injection wax castings and will easily cast all gold alloys including high percentage Palladium White Gold

Can be used with any manufacturers resin but has been chemically designed to specifically match G3D resin with perfect burnout



**G3D** (a division of Goodwin Refractory Services Ltd)

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# SYNERGY

Do not burnout or steam de-wax flasks until a minimum of 90 minutes after investing. During this 90 minute period flasks should not be touched, this includes stripping bases and removing vacuum tape. Do not load flasks into a hot furnace. Always follow the recommended burnout cycle and never place flasks closer than 15mm to elements. Always ensure you do not over or under load your furnace, as this will affect the burnout cycle.

Do not remove flasks from furnace to cast until they have been held at casting temperature for a minimum of 1 hour.

If held for less than 1 hour, the core of the flasks will be at a much higher temperature than the digital temperature display states, and may result in metal mould reaction.

### CAUTION

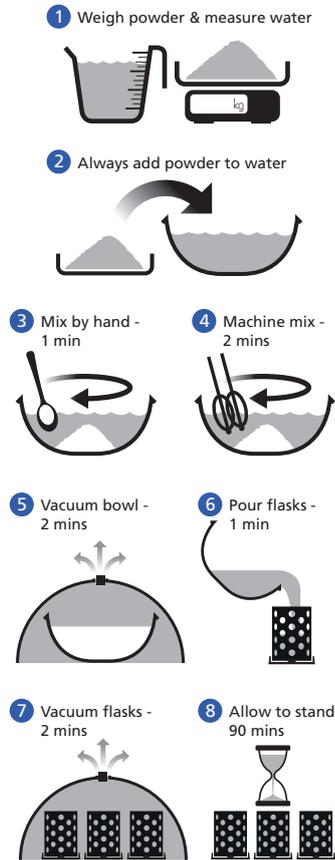
Always use Resin/CAD manufacturers post build procedure after your build to ensure optimum results using Synergy. Consult Resin/CAD manufacturer for post build procedure.

FOR BEST RESULTS CHOOSE G3D'S RP RESINS



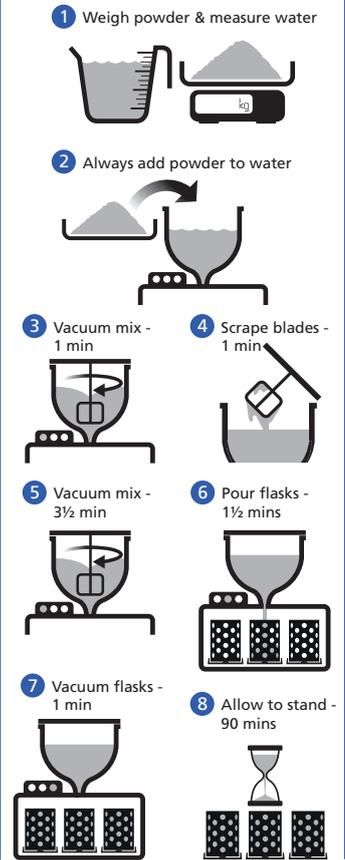
Water/Powder Ratio 40:100	
Conventional Mixing	Time (Mins)
Add Powder To Water	-
Hand Mix	1
Machine Mix	2
Vacuum Bowl	2
Pour Flasks	1
Vacuum Flasks	2
<b>Total Mixing Time</b>	<b>8</b>

### Conventional Mixing

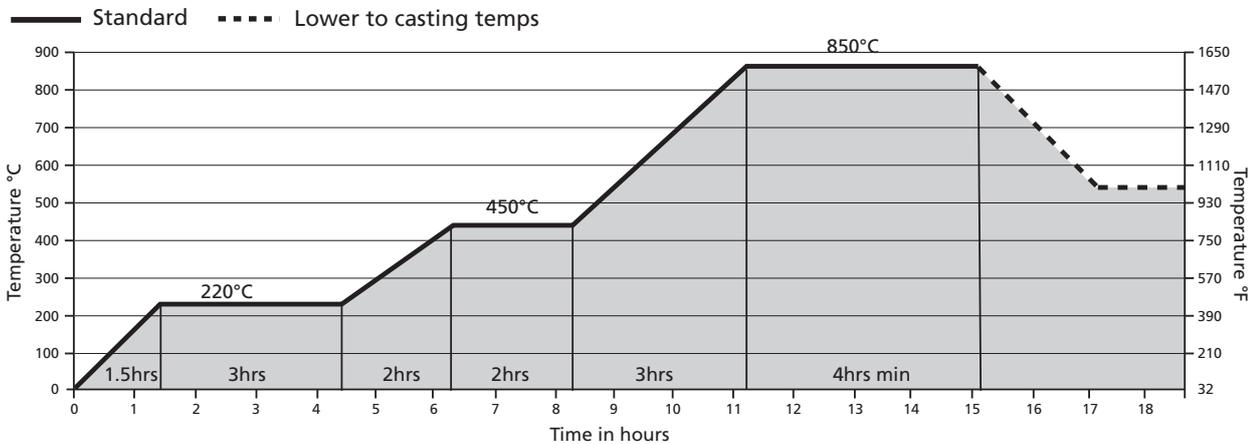


Water/Powder Ratio 38:100	
Vacuum Mixing	Time (Mins)
Add Powder To Water	-
Mix Under Vacuum	1
Scrape Blades	1
Mix Under Vacuum	3½
Pour Flasks	1½
Hold Under Vacuum	1
<b>Total Mixing Time</b>	<b>8</b>

### Vacuum Mixing



## BURNOUT PROCEDURE



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