



INSTRUCTIONS

CF4™

NOTE: CONTENTS SETTLE DURING SHIPPING
Mix CF4™ thoroughly before each use & before beginning Step 1

*******Wear suitable eye and skin protection due to the splash risk of high temperature liquid*******

CF4™ must be adequately mixed after shipping to allow for even distribution of the materials that may settle. CF4 powders are heated to a liquid state, cast into a heated mold, and then allowed to cool before demolding. It hardens due to solidification. It is important to note for large pieces, the surface may solidify before the center. So do not demold before the center has solidified.

1. Pre-heat the casting mold. We recommend 170°-180°C.
2. Fill the melting tank with CF4 powder and heat until it melts. Liquid temperature should be ~300°C before casting. Do not overheat significantly. Melting point is ~240°-260°C.
3. Remove casting from mold when adequate time has elapsed to allow the center of the part to solidify.
4. The casting can be removed by melting or with water.
5. Waste water may require proper disposal due to nitrite-nitrate content. Check with local regulations.

For additional assistance, please contact Advanced Ceramics Manufacturing at 520.547.0850.

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