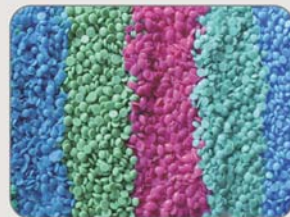


Yihui Casting™ 艺辉



2012

2012·首饰铸造器材
JEWELRY CASTING EQUIPMEN & SUPPLIES

广州市艺辉铸造科技有限公司
Yihui Casting Technology Co.,Ltd .

关于艺辉 ABOUT US

艺辉铸造科技有限公司是专业的失蜡铸造整体解决方案提供商,生产制造精密铸造用机器设备及原料.致力于铸造技术的研发和应用!为精密铸造工业的进步和发展进行着不懈的努力!产品主要有艺辉牌系列铸造石膏粉、艺辉牌蜡珠、石英坩埚、石墨坩埚、石墨模具、熔金机、压模机、真空注蜡机、铸造机及配件等;我们的产品适用于首饰、钟表、眼镜、牙科、琉璃等精密失蜡铸造行业。为了更好地服务客户,我们分别在深圳、广州、义乌、东莞和香港设立了公司或办事机构,欢迎您的莅临指导!

我们不仅提供设备、原料及加工,我们还对客户承诺:

品质保证:我们拥有产品质量检测实验室,确保每批产品皆通过最严格的质量控制标准的检测;并保证每批产品的可追溯性;我们对供应商进行定期的审核与评估!

技术支持:我们更拥有丰富的贵金属冶炼和铸造经验,专业的铸造技术人员,可以在客户的生产过程中提供全方位的帮助与专业的建议,成为客户可信赖的合作伙伴!保持技术的持续改善与创新!追求技术和效率的完美结合!

客户服务:尊重客户,注重与客户的沟通!用一颗感恩的心服务客户!最大限度的满足客户的需求!让我们秉持“专业、敬业、合作、共赢”的理念,不断地推出和提供优质的产品和服务!

Yihui Casting Technology Co., Ltd. is a professional lost wax investment casting solution provider, as well as manufacturer of precision casting equipment and casting consumable materials. Who has been strived to the research and development of casting technology application for more than 10 years .

Our product range mainly include : Yihui brand casting investment powder, Yihui Brand wax beads, ceramic crucible, graphite crucible, graphite mould, jewelry casting machines , like mold vulcanizer , vacuum wax injector , investment mixer , burnout oven , gold melting furnace jewelry casting machine and tools.

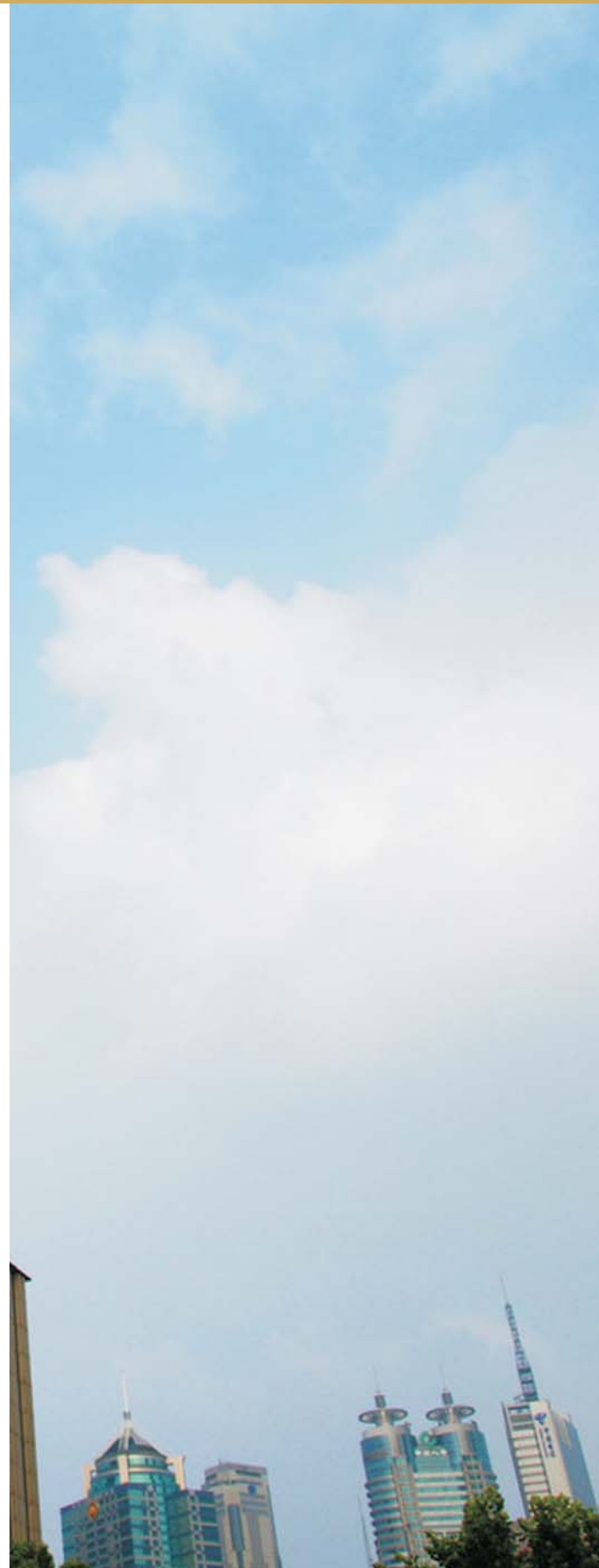
Our products are widely used in jewelry, watches, glasses, dental, and other precision loss wax casting industry. In order to better serve our customers, we opened branch offices in Shenzhen, Guangzhou, Yiwu, Dongguan and Hong Kong, welcome your visiting to our company !

We provide not only equipments and materials, but also make commitments to our customers:

Technical support: with rich experience of precious metal smelting and casting, and professional casting technicians, we can offer full support and proposals to our customers during the process of production, as a trustworthy partner. Keep our technology continually improved and innovated, pursue the perfect scheme of technology and efficiency!

Customer Service: Respect our customers and pay attention to the communication with them! Appreciate them from the bottom of our heart! Try our best to meet their requirements all the way!

Let us hold the concept of "**Profession, Devotion, Cooperation, Double-win**" , continually provide our customers with quality products and best service!



欢迎浏览

www.yihuicasting.com



通过访问网站您可以了解：

You will understand following info through our website:

- 1.产品信息 Product info
- 2.技术支持 Technical support
- 3.联系方式 Contact details
4.

联系我们 Contact us



广州市艺辉铸造科技有限公司 Yihui Casting Technology Co.,Ltd .

广州公司

地址 广东省广州市番禺区沙湾镇福涌工业区福兴路二街二号
电话 +86-20-34737899
手机 +86-13922305922
传真 +86-20-34735899
邮箱 gz@yihuicasting.com

深圳公司

地址 广东省深圳市罗湖区文锦北路水贝茂名大厦八楼
电话 +86-755-25618858
手机 +86-13600183359
传真 +86-755-25618859
邮箱 sz@yihuicasting.com

东莞公司

地址 广东省东莞市长安镇荣文路74号
电话 +86-769-85536466
手机 +86-18665151088
传真 +86-769-85536456
邮箱 dg@yihuicasting.com

义乌公司

地址 浙江省义乌市宗泽路380号
电话 +86-579-85580946
手机 +86-15355376399
传真 +86-579-85580945
邮箱 yw@yihuicasting.com

Guangzhou Branch

Address : No 2 of second street , Fuxin Road, Fuyong
Industry park, Shawan town, Panyu district,
Guangzhou.
Tel: +86-20-34734999
Fax : +86-20-34735899

Shenzhen Branch

Address : 8 floor of Maoming Mansion , North road
of Wenjing, Luohu district, Shenzhen.
Tel: +86-755-25618858
Fax: +86-755-25618859

Dongguan Branch

Address : No 74 Rongwen Road ChangAn town ,Dongguan.
Tel: +86-769-85536466
Fax : +86-769-85536456

Yiwu Branch

Address : No 380 Zongze Road Yiwu, Zhengjiang
Province.
Tel: +86-579-85580946
Fax : +86-579-85580945



石膏粉系列产品是英国原装进口高质量产品，经过最高规格检验出厂 生产工厂系通过ISO9001认证工厂 拥有最先进的产品应用和开发实验设施，高素质的开发和应用技术人员 这更有利于我们对开发新产品、分析材料特性、评估产品应用过程和为客户铸造提供最佳解决方案！

系列产品适合不同产品的不同要求，完全满足对贵金属铸造表面光滑，铸件细腻，无缺陷的要求!同时每个型号我们都有50磅和100磅两种包装！我们也针对铂金和钯金的生产,专门引进了日本的A-1(min)石膏粉.同时为了为客户节约生产成本,我们也研发了更加适合国内客户需求的艺辉牌铂金钯金石膏粉和艺辉牌不锈钢石膏粉.

UK imported high quality casting investment with strict quality standards control, factory passed ISO9001 equipped with advanced R&D testing facilities and professional engineers. This helps us to figure out the best solution during the process of new products design and audit. Different series are made for various requirement to make a smooth, perfect surface casting items. We have 50 Pounds and 100 pounds packages. As the increased requirement of palladium and platinum casting, we imported Japan A-1(min) casting investment. What's more, considering the cost factor we developed Yihui Brand casting investment for palladium and platinum casting, which is more welcomed in domestic market.



艺辉牌00石膏粉
 产品型号：艺辉牌00
 产品规格：50磅/小袋 100磅/大袋
 适用范围:适合足金,银铜铸造

Yihui Brand 00 Casting Investment
 Model : Yihui Brand 00
 Specification : 50Pound/ bag 100pound/ bag
 Application:Suitable for gold, silver and copper casting



艺辉牌33石膏粉
 产品型号：艺辉牌33
 产品重量：50磅/袋
 产品适用范围：艺辉牌33:适合足金,银铜铸造

Yihui Brand 33 Casting Investment
 Model : 33
 Specification : 50Pound/ bag
 Application:Suitable for gold, silver and copper casting



艺辉牌33石膏粉
产品型号：艺辉牌33
产品重量：100磅/桶
产品适用范围：艺辉牌33:适合足金,银铜铸造

Yihui Brand 33 Casting Investment
Model : 33
Specification : 100 pounds/ drum
Application:Suitable for gold, silver and copper casting



艺辉牌66石膏粉
产品型号：艺辉牌66
产品重量：50磅/袋
产品适用范围：艺辉牌66适合K金,足金铸造

Yihui Brand 66 Casting Investment
Model : YH-66
Specification : 50Pound/ bag
Application:Suitable for gold, K gold casting.



艺辉牌66石膏粉
产品型号：艺辉牌66
产品重量：100磅/桶
产品适用范围：艺辉牌66适合K金,足金铸造

Yihui Brand 66 Casting Investment
Model : YH-66
Specification : 100 pounds/ drum
Application:Suitable for gold, K gold casting.



艺辉牌99石膏粉
产品型号：艺辉牌99
产品重量：50磅/袋
产品用途：适合铍 铜 K金铸造

Yihui Brand 99 Casting Investment
Model : YH-99
Specification : 50Pound/ bag
Application:suitable for be, copper and gold casting



艺辉牌99石膏粉
产品型号：艺辉牌99
产品重量：100磅/桶
产品用途：适合铍 铜 K金铸造

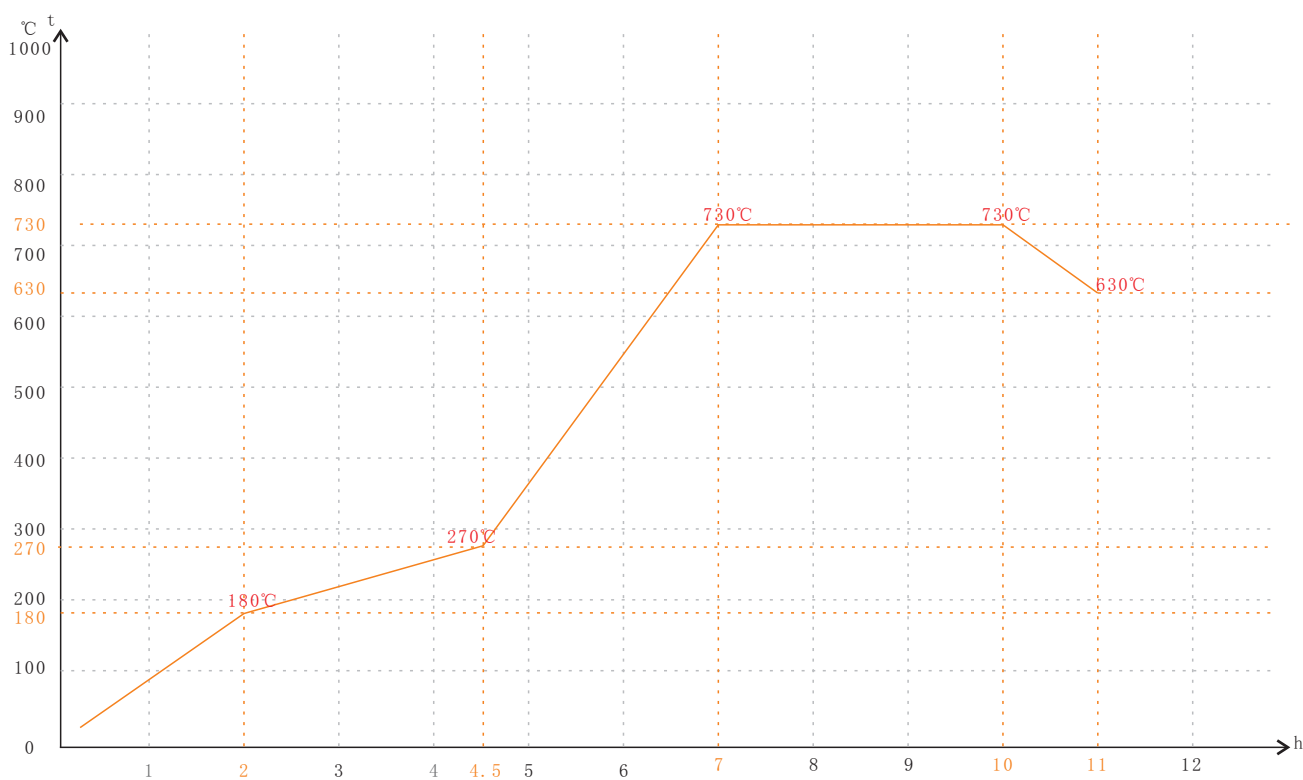
Yihui Brand 99 Casting Investment
Model : YH-99
Specification : 100 pounds/ drum
Application:suitable for be, copper and gold casting



艺辉牌蜡镶石膏粉
 产品型号：YH-SCT-A
 产品重量：100磅/桶
 产品用途：适合蜡镶铸造

Yihui brand gemstones inlay casting investment
 Model: YH-SCT-A
 Specification: 100 pounds/ drum
 Application: suitable for gemstones inlay casting

烧结程序示意图：



艺辉牌石膏开粉程序

一. 配粉比例：

- 1) 量石膏粉1000 克
- 2) 量水380-400 毫升(水温要求在22°C左右)
- 3) 把水放入容器内,然后加入石膏粉
- 4) 搅拌3.5 到4 分钟
- 5) 倒入钢盘,然后再抽真空1.5 到2 分钟
- 6) 平放静置60-120 分钟

二. 烧结：

- 1) 室温到180°C须120分钟,从180°C到270°C须150分钟,保持270°C用150 分钟
- 2) 由270°C平均加温到730°C用150 分钟
- 3) 保持730°C用180 分钟
- 4) 然后回降到630°C左右,开始铸造.

三. 产品说明:

艺辉牌系列石膏粉是原装英国进口高质量产品,经过最高规格检验出厂,系列产品适合不同产品的不同要求,完全满足对贵金属铸造表面光滑,铸件细腻,无缺陷的要求!

Usage Instruction :**I. Mixing rate :**

- 1) Casting investment 1000g
- 2) water 380-400ml (water temp about 22°C)
- 3) Pour water into mixing chamber, then add casting investment
- 4) Start mixing for 3.5-4 mins
- 5) Inject mixed investment into flasks, then start vacuum 1.5-2 mins
- 6) Take the flaks out, and wait 60-120 mins before burning it.

II. Burn process :

- 1) Put the flaks filled with investment into oven, turn up the temp to 270°C within 60 mins, and keep at 270°C with 180 mins.
- 2) Rise temp evenly from 270°C to 730°C in 150 mins
- 3) Keep at 730°C with 180 mins.
- 4) Start casting when the temp turn down to around 630°C

III. Decription

UK imported high quality casting investment with strict quality standards control, various series are made to fit different requirements.

铸造常见问题解决方法**一.铸件飞边或毛刺**

不正确的水粉比例；石膏粉的存放方法不当
搅拌和抽真空的时间超过规定的时间(8-9分钟)
钢盅在炉里加热的时间上升的太快

二.铸件不完整

蜡树的树干太小；蜡模没有完全燃烧
铸造时钢盅的温度太低；铸造时金属的温度太低；金属的重量不足

三.铸件不够光滑

蜡模没有燃烧干净，仍有碳质在石膏模中，炉温太高(超过788°C)

四.铸件有微孔

金属温度太高；钢盅的温度太高
金属中有太多的“旧”金属(不要超过一半)；金属加入太多的助熔剂

五.铸件表面有微粒

钢盅太快入炉；焗炉升温太快
金属中有异常微粒；钢盅的铁锈没有清除干净

六.铸件粗糙

粉水没有完全混合，蜡模的焊接技术不好；搅拌时间不够或太长钢盅加热太快；脱蜡的温度不可超过150°C，超过150°C蜡会沸腾侵蚀铸件表面
另注:

铸造的顺序按照铸件的温度从高到低进行；
石墨有吸湿气的倾向，铸造之前要适当使之干燥

Solution of Common Casting Problem**1. Burr or flashing edge.**

Improper mixing rate of water and investment, or store investment in a wrong way.
Overtimed mixing and vacuum(more than 8-9 mins)
(Temp rises too fast in the burnout oven)

2. Incomplete casting items.

Truck of wax tree is too small, incompletely-burnt wax mould.
Flask temp is too low when while casting, metal temp is too low while casting, or insufficient weight of metal.

3. Unsmooth surface of casting items.

incompletely-burnt wax mould with carbonaceous materials inside investment mould, temp of burnout oven is too high.

4. With tiny holes on the surface

Metal temp is too high, also flask temp is too high.
An excess of old metal mixed in the casting metal(should be half less), put too much flux while melting.

5. Small particles on the surface

Oven temp is too high.
There are some tiny particles in the metal, rust on the flasks.

6. Rough surface

Incompletely mixing of water and investment, improper soldering of wax tree, insufficient mixing time or over-speed temp rising of flaks,. Dewaxing temp is more than 150°C to corrode casting metal surface.

Remarks:

Casting operation order should be from high temp to low temp.
Graphite is easy to absorb humidity, please be sure to dry it before use

备注：以上数据仅供参考，请根据具体情况调整参数

Remark: Above info is for reference only, it is subject to factory manual.



艺辉牌316不锈钢铸造石膏粉

产品包装：纸箱包装
产品重量：25KG/箱
适应范围：不锈钢铸造

Yiui Brand 316 Stainless Steel Casting Investment

Package : Carton
Weight : 25kg/Carton
Application : Suitable for stainless steel casting



艺辉牌850钯金铸造石膏粉

产品型号：850
产品包装：纸箱包装
产品重量：25KG/箱
适应范围：钯金

Yihui Brand 850 Palladium Casting Investment

Model : YH-850
Package : Carton
Weight : 25kg/Carton
Application : Suitable for palladium



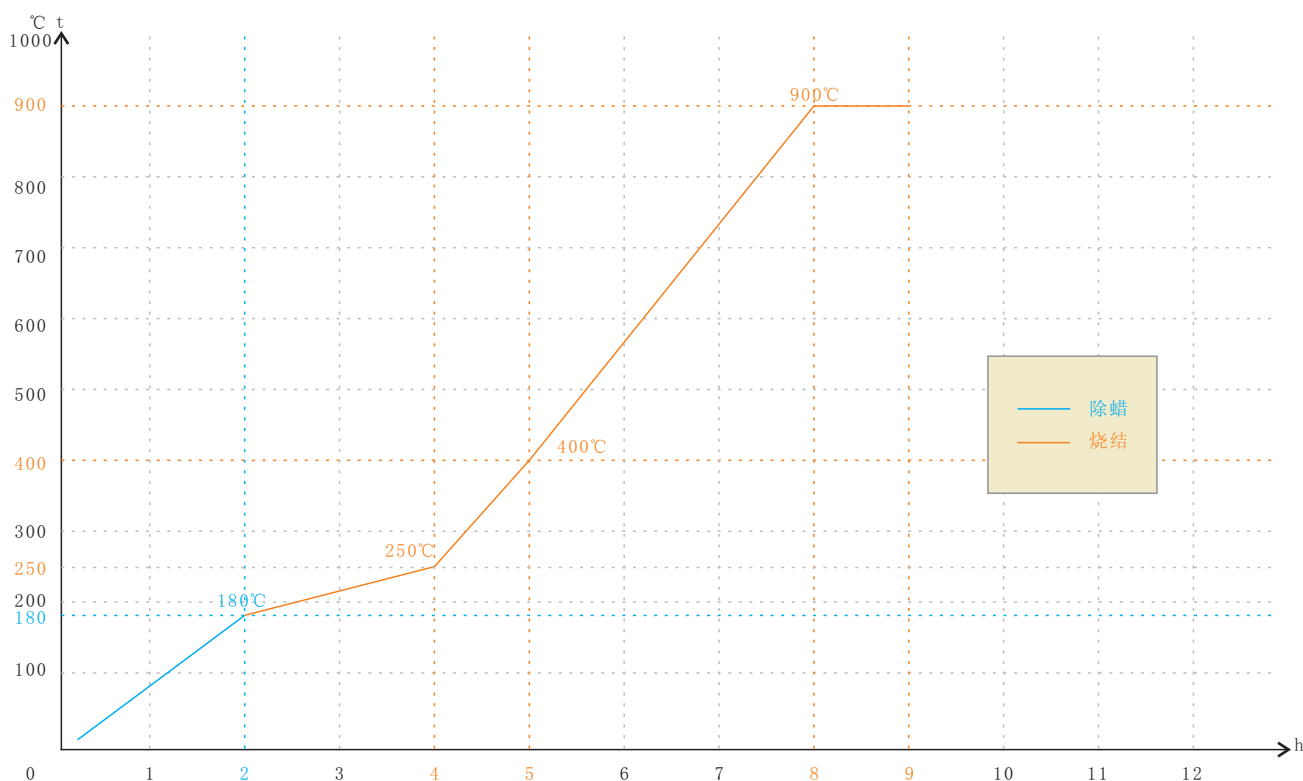
艺辉牌990铂金铸造石膏粉

产品包装：纸箱包装
产品重量：25KG/箱
适应范围：铂金

Yihui Brand 990 Platinum Casting Investment

Package : Carton
Weight : 25kg/Carton
Application : Suitable for platinum

烧结程序示意图：

**艺辉牌不锈钢 钯金 铂金石膏粉开粉程序****1. 调配催干剂：**

催干剂与水的比例:催干剂60毫升+水1000毫升,搅拌均匀.制成混合液.

用后请封好瓶盖.

2. 调配不锈钢石膏

把不锈钢石膏加入到混合液中,用电动搅拌机搅拌5-10分钟.

粉与混合液的比例:不锈钢石膏3333克+混合液1000毫升.

3. 开粉：

在这阶段,钢盅必须放置在专用吸水纸上,让水份平均地排去,利用吸水纸也可确保防漏不锈钢石膏粉.

以下(4)(5)两项操作为参考数据,请按实际情况稍作调整

4. 抽真空：

抽真空时间约8分钟左右

5. 不锈钢石膏烧结时间程序(如上图示)

除蜡:由室温到180°C需时间120分钟

烧结:由180°C到250°C需时间120分钟

由250°C到400°C需时间60分钟

由400°C到900°C平均每30分钟升温100°C,即需时150分钟达到900°C,维持900°C温度约60分。

Usage instruction**1) Siccative mixing**

Mixing rate: 60ml siccative + 1000ml water to make mixed liquid.

Then cover on.

2) Stainless steel investment power mixing

Add investment power into the mixed liquid, electrically stir it with 5-10mins,

mixing rate: 3333g stainless steel investment + 1000ml mixed liquid.

3) Investment casting process: put the flaks on the special absorbent paper.

4) Vacuum: vacuum flaks filled with mixed investment around 8 mins.

5) Burn steps, following process for reference only:

Turn the oven to 180°C with 120 mins.

Rise temp from 180°C to 250°C with 120 mins.

Turn up the temp from 250°C to 400°C with 60 mins.

Increase temp from 400°C to 900°C evenly with 150 mins, 100°C up per 30 mins, when temp arrived 900°C keep 60 mins.

备注：以上数据仅供参考，请根据具体情况调整参数

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2012

专业、敬业、合作、共赢
profession, devotion, cooperation, double-win

专业的精密失蜡铸造器材提供商
Professional supplier in paraffin casting equipment

YIHUI CASTING TECHNOLOGY CO.,LTD No 2 of second street , Fuxin Road, Fuyong Industry park, Shawan town, Panyu district, Guangzhou.

Tel: +86-20-34734999 Fax: +86-20-34735899

info@yihuicasting.com www.yihuicasting.com