



SYMPHONY

TECHNICAL DATASHEET



Premium Investment Powder suitable for casting all Karat White, Rose and Yellow Gold From Wax & Resin Trees

GSP Symphony is an enhanced investment powder, developed for direct Resin / CAD casting, extensively tested and approved by jewellery manufacturers worldwide.

With the fast-paced advancements in 3D printing technology, resin formulations, and design demands, GSP remains dedicated to advancing our investment casting powders to meet the industry needs. Symphony is compatible with all manufacturers' casting resins and waxes and can easily cast all alloys, including high percentage Palladium White Gold.

The mixing, investing, and burnout processes remain consistent with standard investment powder procedures, ensuring seamless integration into existing workflows.

Key benefits of Symphony investment powder for CAD / CAM resin direct casting include:

- The highest quality raw materials sourced and graded for direct casting.
- Enhanced green strength to withstand high Resin / CAD expansion,
- Compatibility with any Resin manufacturer, clean cut surface finish with sharp edges free from inclusions.
- Easy removal after casting, similar to regular GSP investment powders.
- With its high cristobalite content, Symphony can endure a top burnout temperature of 850°C (1562°F), ensuring it can handle additional expansion stresses and eliminate residual carbons that might affect casting quality. It also has the ability to use a fast burnout cycle to have a casting within 6 hours of investing.
- It is also suitable for producing injection wax castings and can cast all Gold alloys, including high percentage Palladium White Gold.



GOODWIN REFRACTORY SERVICES INDIA PVT. LTD.

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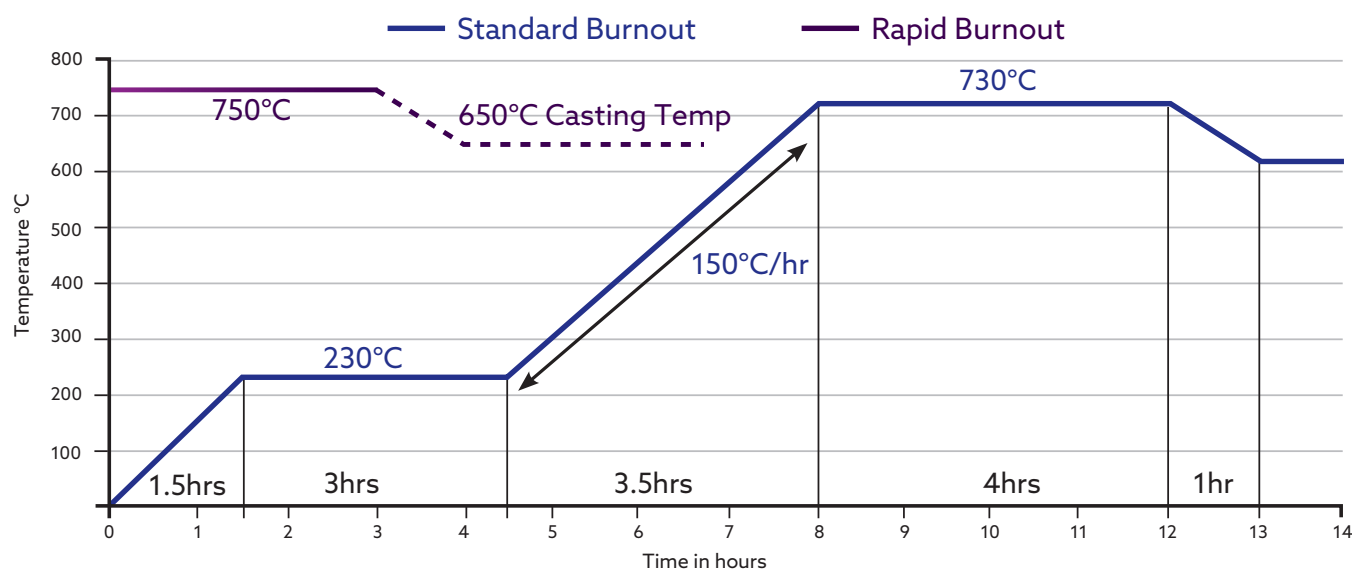
Do not remove flasks from furnace to cast until they have been held at casting temperature for a minimum of 1 hour. If held for less than 1 hour, the core of the flasks will be at a much higher temperature than the digital temperature display states, and may result in metal mould reaction.

- Slurry temperature 21°C
- Leave for 90 min to stand before burnout

POWDER/ WATER RATIO	100/38
WORKING TIME @ 25°C SLURRY TEMP.	8-10 min.
GLOSS OFF TIME @ 25°C SLURRY TEMP.	12-14 min.
THERMAL EXPANSION AT 750°C	1.25%
SETTING EXPANSION AFTER 2 HOURS	1.10%
VOLUME YIELD PER KG. OF POWDER	755 ml.

MACHINE VACUUM MIXING	Min.
Weigh out water and powder	0
Add powder to water	0
Mix under vacuum	4
Pour flasks	2
Vacuum flasks	2
Total time take	8

HAND MIX THEN VACUUM	Min.
Weigh out water and powder	0
Add powder to water	0
Mix by hand	1
Mix with machine	3
Vacuum mixer bowl	1
Pour flasks	1
Vacuum flasks	2
Total time taken	8



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