**Low Temperature Casting**

**Information/Directions**

**Alloy:** A metal that is a combination of two or more base metal elements. Alloys are created to enhance a desired property in the metal(s).

**\*\*\*Wear gloves the entire time you are working\*\*\***

**Casting Alloy L3S**

**Lead Free Pewter**

**% Name Symbol Atomic # Atomic Mass**

98 ½% Tin Sn 50 118.710

1% Bismuth Bi 83 208.980

¼% Copper Cu 29 63.546

¼% Silver Ag 47 107.868

**Procedures for Casting**

1. Keep all flammables and combustibles away from the casting area.

2. Set the dial at 450º F or #5 on the melting pot.

3. Place L3S casting alloy into the melting pot and wait for it to completely melt.

4. Place a mold release into the mold (talc powder or graphite).

5. Spread mold release by closing and then shaking the mold and then removing the excess.

6. Put mold together using location lugs.

7. Place wood blocks against outside of the mold.

8. Place two (2) to four (4) spring clamps on the out side of the wood blocks.

9. When the alloy is melted and viscous place the prepared mold under the pouring spout.

10. Lift the handle and pour into the smaller of the two holes of the mold.

11. Maintain pouring until the sprue hole is filled.

12. Lower the handle and move the mold to another location to cool and solidify.

13. Allow the mold to cool for three (3) to five (5) minutes and keep the mold level.

14. Remove the wood blocks and clamps.

15. Take the casting out of the mold (It will still be hot).

16. Cut the gate and sprue off with a hack saw---do not break off.

17. Put the mold back together. Unplug the mold and leave some alloy in it.

18. Sand/grind your base with the disc sander, sand at the 9 o'clock position.

19. Buff your object with a brass bristle brush.

20. Clean your area and turn in your casting.

f:castinfo