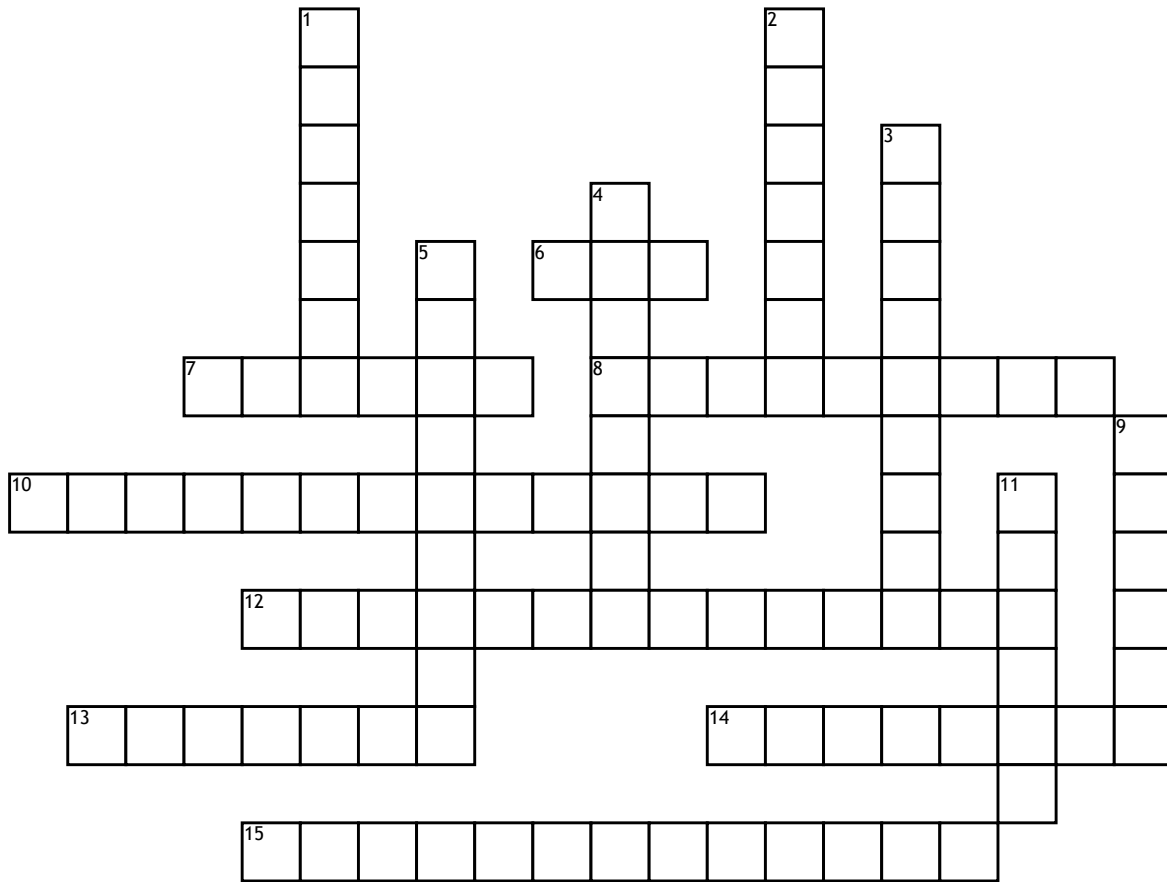


# Design for Investment Casting



**Across**

6. Molds can be made of this three letter material.

7. This process occurs during the de-waxing stage and it hardens the ceramic mold.

8. Multiple layers of the ceramic slurry are used to achieve the right shell

10. The full cluster of wax parts is dipped into a flask of this liquid material.

12. Molds for plastic and wax parts are made of this material

13. The act of melting two pieces of wax together is called \_\_\_\_\_ (same term for melting metals together)

14. This process involves removing the ceramic shell from a casted part.

15. Process Step 1

**Down**

1. Another name of group of molded parts connected to sprue.

2. Molds can also be made of this thinner and more ridged material

3. Volume allowances for solid contraction of metals signifies \_\_\_\_\_%

4. Final Product of Step 2

5. This process (7) is where the final part gets sanded and heat treated

9. This factor limits the number of parts of each cluster. (not Size)

11. During the Casting Phase (5) molten metal is poured into a \_\_\_\_\_ mold.