Stage 1: 3D CAD Design, Casting methoding and CAM

Stage 2: Machine polystyrene pattern

Stage 3: Assemble and wax component for improved surface finish.

Stage 4: Coat polystyrene pattern with ceramic slurry and backup

Stage 5: Dry pattern between coats.

Stage 6: Shell assembly is fired after coating and drying.

Stage 7: Ceramic sub assemblies can be joined together.

Stage 8: Ceramic shell assemblies are packed into a casing box with

Stage 9: Sand is fixed to support the shell by vibration and a vacuum.

Stage 10: Metal is poured into the inert ceramic mould. Emissions reduced due to absence of a resin binder in the sand.

Stage 11: Post casting the shell is removed

Stage 12: Feeders cut off, part fettled, heat treated and finished