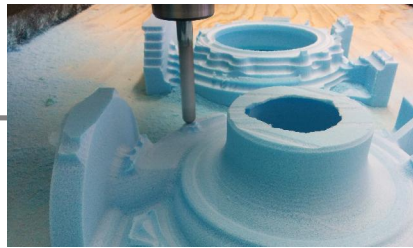


Replicast® Process Map



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



Stage 2: Machine polystyrene pattern



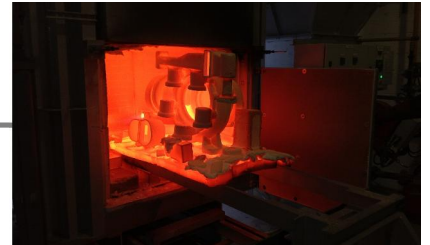
Stage 3: Assemble and wax component for improved surface finish.



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



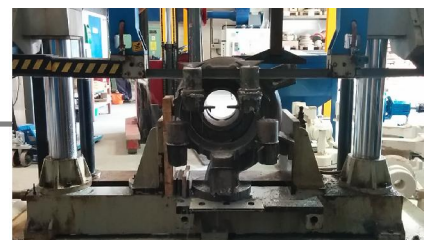
Stage 9: Sand is fixed to support the shell by vibration and a vacuum.



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