



Figure 4™ JCAST-GRN 10

Jewelry Castable

Figure 4

Optimized for clean and easy burnout of finely detailed, high-resolution jewelry patterns for direct casting

OUTSTANDING DETAIL AND RESOLUTION FOR JEWELRY CASTING

Designed for the jewelry casting professional, Figure 4 JCAST-GRN 10 produces accurate, reproducible, and highly detailed master patterns for jewelry casting. This high contrast green material is easy to cast with minimal ash and residue, producing high quality jewelry pieces rapidly.

Liquid Material

MEASUREMENT	CONDITION	VALUE	
Viscosity	@ 25 °C (71 °F)	190 cps	
Color		Green	
Solid Density	@ 25 °C (77 °F)	1.18 g/cm ³	0.043 lb/in ³
Liquid Density	@ 25 °C (77 °F)	1.09 g/cm ³	0.039 lb/in ³
Package Volume		1 kg bottle - Figure 4 Standalone 10 kg container - Figure 4 Production	
Layer Thickness (Standard Mode)		0.02 mm	0.0008 in
Vertical Build Speed (Standard Mode)		8 mm/hr	0.3 in/hr

APPLICATIONS

- Production master patterns for gypsum investment casting of:
 - A wide range of jewelry pieces
 - Rings
 - Brooches
 - Bracelets
- Suitable for a range of precious metals
- Highly detailed models for design validation, customer samples, etc.

BENEFITS

- Produces high quality castings
- High detail and feature resolution
- High accuracy and repeatability
- Easy feature visualization
- Direct casting, no tooling required

FEATURES

- Easy pattern burnout
- Strong/shippable patterns





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Post-Cured Material

MECHANICAL PROPERTIES			
MEASUREMENT	CONDITION	METRIC	U.S.
Tensile Strength (MPa PSI)	ASTM D638	13.7	1990
Tensile Modulus (MPa KSI)	ASTM D638	262	38
Elongation at Break	ASTM D638	12 %	
Coefficient of Thermal Expansion (CTE) (ppm/°C ppm/°F) > Tg	ASTM E831	143	79
Hardness, Shore	ASTM D2240	68D	
Water Absorption	ASTM D570	1.3 %	



Warranty/Disclaimer: The performance characteristics of these products may vary according to product application, operating conditions, or with end use. 3D Systems makes no warranties of any type, express or implied, including, but not limited to, the warranties of merchantability or fitness for a particular use.

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