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Subject: Understanding Shrinkage in Silver Casting  
Posted by [Tofty](#) on Thu, 06 Sep 2012 21:05:16 GMT  
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Hi,  
I am planning an order of quite a large object in silver that needs to be as dimensionally accurate as possible.  
I am wondering how to take account of the expected shrinkage of the object from casting:  
Should i scale up the model by about 2% (which is the deviation measured from previous printed objects),  
or will the shapeways operators make the necessary changes to the model to ensure it's final dimensional accuracy?

I really want to get this right first time due to ithe protibitive cost.

The model is around 28x28x109mm

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#### File Attachments

1) [Tofty Ag Render 021b.jpg](#), downloaded 181 times

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Subject: Re: Understanding Shrinkage in Silver Casting  
Posted by [Tofty](#) on Wed, 19 Sep 2012 14:45:52 GMT  
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Is there really no one who can give an answer to this question?

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Subject: Re: Understanding Shrinkage in Silver Casting  
Posted by [BillBedford](#) on Wed, 19 Sep 2012 15:54:55 GMT  
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2% shrinkage seems a lot for the casting process. I suggest that it is much less than that if there is any at all.

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Subject: Re: Understanding Shrinkage in Silver Casting  
Posted by [Fredd](#) on Wed, 19 Sep 2012 17:37:56 GMT

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Here's some info on the silver material.

<http://www.shapeways.com/materials/silver-design-guidelines>. Good luck with getting it printed.

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Subject: Re: Understanding Shrinkage in Silver Casting

Posted by [Tofty](#) on Sat, 03 Nov 2012 09:11:22 GMT

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Just an update in case this information is useful to anyone;

I went ahead and ordered the above model in silver with a 2% increase in scale and this factor turned out to be pretty much perfect.

All internal dimensions remained within tolerances and the threads were all very good.

Here are a few pictures of the finished light:

Thanks Shapeways.

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