

R&R® RANCLENE

Pattern Cleaner

R&R RANCLENE pattern cleaner is a specially formulated aqueous wax pattern cleaner. The product is designed to both etch the pattern and remove the silicone release agent. The product can also be used for removing flow lines on components prior to assembly.

APPLICATION RECOMMENDATIONS

Patterns cleaned in R&R RANCLENE can be dipped in water based primary slurries after they have dried.

After the wax patterns are cleaned and rinsed with water, an acclimation period of at least one hour is recommended in the primary slurry area of the shell room to ensure wax patterns are not expanding or contracting from changes in temperature.

R&R RANCLENE can be used full strength as packaged for difficult to release patterns that require a heavy coat of release agent. It may also be used full strength for patterns that have difficult part geometry.

R&R RANCLENE can be diluted with water to 75% concentration for normal use, making it more economical to use. (NOTE: At greater than 10% water dilution, material needs to be remixed before pattern immersion).

TYPICAL PROCESS RECOMMENDATION

1. If diluted with greater than 10% water, mix tank prior to immersing patterns.
2. Agitated immersion in R&R RANCLENE for 30 seconds.

NOTE: This may vary depending on part geometry or amount of silicone to be removed.

3. Agitated immersion in room temperature water for 15 seconds in an overflow tank.
4. Agitated immersion in room temperature water for 15 seconds in a second overflow tank.

Overflow water rinse tanks may be arranged so that the second tank overflows into the first and the first overflows into a drain. (Consult your local authorities before pouring liquids down the drain.)

Perforated tubing or piping may be added to the bottom of the water rinse tanks. By pumping air through these lines during the rinse process, agitation will be enhanced.

RECOMMENDED TESTING METHODS

The following test can assist with monitoring the effectiveness of the cleaning material:

1. Wetting Test.

Dip a clean wax bar or pattern into primary binder prewet to its mid-point.

Remove from binder and observe the surface.

Good wetting indicators: uniform coat, no binder breaks

Poor wetting indicators: wax peeks through the binder coat, binder breaks and forms holes



R&R
DENSPLY

EUROPEAN AGENT:

HTM Tradeco Ltd.
Phone: 208/4434323 (UK)
Fax: 208/8040127 (UK)
htmtradecoltd@aol.com

Ransom & Randolph

3535 Briarfield Blvd.
Maumee, OH 43537 USA
USA Phone: (800)800-7496
Phone: (419)865-9497
FAX: (419)865-9997
www.ransom-randolph.com

SAFETY & ENVIRONMENT

R&R RANCLENE pattern cleaner contains no hazardous components as defined by the Chemical Hazard Information and Packaging Regulations 1993 (CHIP) and has low Inhalation Index. **R&R RANCLENE pattern cleaner does not contain chlorinated or aromatic hydrocarbon solvents.** For more detail, you may find the Material Safety Data Sheet at www.ransom-randolph.com.

ECONOMY

The use of an aqueous pattern cleaner such as R&R RANCLENE provides significant cost savings due to its low volatility compared to those of the solvents generally used to clean wax trees. In addition, the silicone particles can be skimmed off the wash tank. With this type of maintenance, R&R RANCLENE can be kept for long periods of time.



R&R
DENSPLY

UPDATE: August 31, 2010

EUROPEAN AGENT:

HTM Tradeco Ltd.
Phone: 208/4434323 (UK)
Fax: 208/8040127 (UK)
htmtradecoltd@aol.com

Ransom & Randolph

3535 Briarfield Blvd.
Maumee, OH 43537 USA
USA Phone: (800)800-7496
Phone: (419)865-9497
FAX: (419)865-9997
www.ransom-randolph.com