

RANTYRE

Investment

*Used in making molds
for the vulcanization of tires*

PROPERTIES:

Consistency	W/P = 46/100 (by weight)
Setting Expansion	< 0.2%
Compressive Strength, 1 Hour	approximately 55 kg/cm ² (5.39 MPa)
Fired Strength	approximately 30 kg/cm ² (2.94 MPa)
Pour Time	10-11 minutes
Set Time	< 26 minutes

DIRECTIONS:

Mix 100 parts investment powder to 46 parts water (by weight). Mechanically mix for two to three minutes. Vacuum the mix until the investment rises and breaks to eliminate entrapped air.

Pour the investment into the framed pattern (silicon rubber), under vacuum; this operation normally takes 3 to 4 minutes. Then vibrate (if possible) the molds for 30 seconds to 1 minute to finish eliminating the last entrapped air bubbles.

Stop the vacuum. Take the molds out of the mixing machine and place them on a table; it is important that they do not receive mechanical shocks as this may cause cracking.

The molds can be stripped from the rubber pattern after 30-35 minutes.

After separating the mold from the pattern, the mold can begin the curing cycle. If there is a need to store the molds for more than 2 hours prior to curing, then attempts should be made to prevent the mold from partially drying.

RECOMMENDED CURING CYCLE:

Raise the temperature from 20°C to 180°C in two hours.

Raise the temperature from 180°C to 300°C in 5 hours.

Hold at 300°C for 5 to 7 hours.

In 30 minutes go down to 260°C.

Cast the metal

WARNING!

Rantyre investment contains respirable crystalline silica (RCS). Do not breathe dust. May cause delayed lung injury (silicosis, pneumoconiosis). Follow OSHA Safety and Health Standards for crystalline silica. See Material Safety Data Sheet (MSDS) for detailed information.



R&R

DENSPLY

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