

KC2000 INVESTMENT



Forgiving and Dependable for Large Production Volumes of Gold, Silver, and Brass

A forgiving and dependable jewelry investment casting powder used to form lost-wax molds for the casting of jewelry and fine art pieces with gold, silver, and other metal alloys. Water is mixed on-site by user prior to use to form the mold.

- Economical formula
- Easy break out for large volume production
- Highly consistent with smooth surface finish
- Recommended mixing ratio: 38-40 mL water to 100g powder

Typical Material Properties*

Silica (SiO ₂) (Quartz & Cristobalite)	Calcium Sulfate (Gypsum)
60-80%	20-40%

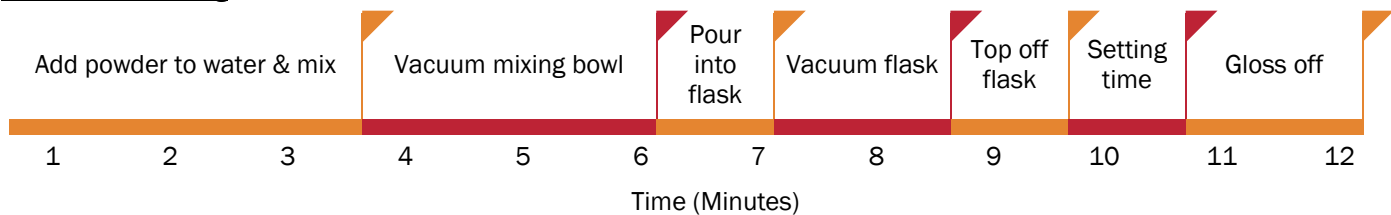
*These results are based on the testing methods, frequency and procedures of Ransom & Randolph or its approved suppliers. The levels referenced herein are only for general guidance and do not constitute a firm specification.

Mixing Instructions

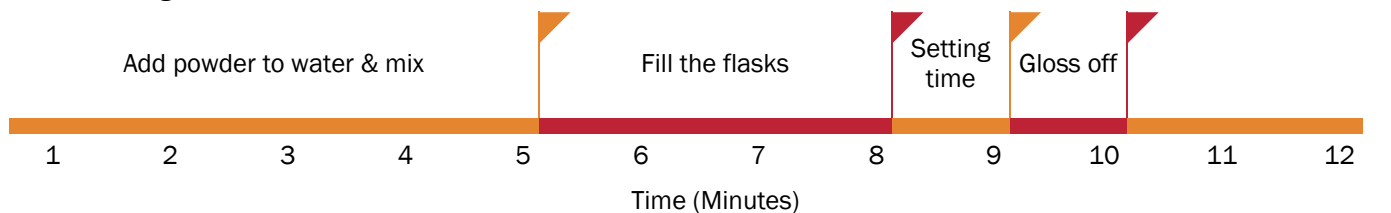
1. Weigh investment.
2. Measure water.
3. Add investment to water.
4. Mix 3-3.5 minutes.
5. Vacuum 20 seconds after boil.
6. Pour into flask.
7. Vacuum up to 90 seconds.
8. Let flask sit still for 2 hours.
9. Preheat furnace 300 °F (149 °C). **Note:** do not preheat for multiple flasks.
10. Remove sprue base.
11. Load into furnace.
12. Follow appropriate burnout cycle.

Recommended Working Time

Conventional Mixing



Vacuum Mixing



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
 800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com

    Made in the USA

Ransom & Randolph GmbH
 Leipziger Straße 40 | 04571 Rötha Germany
 +49 342 06373999

Investing with Innovation™

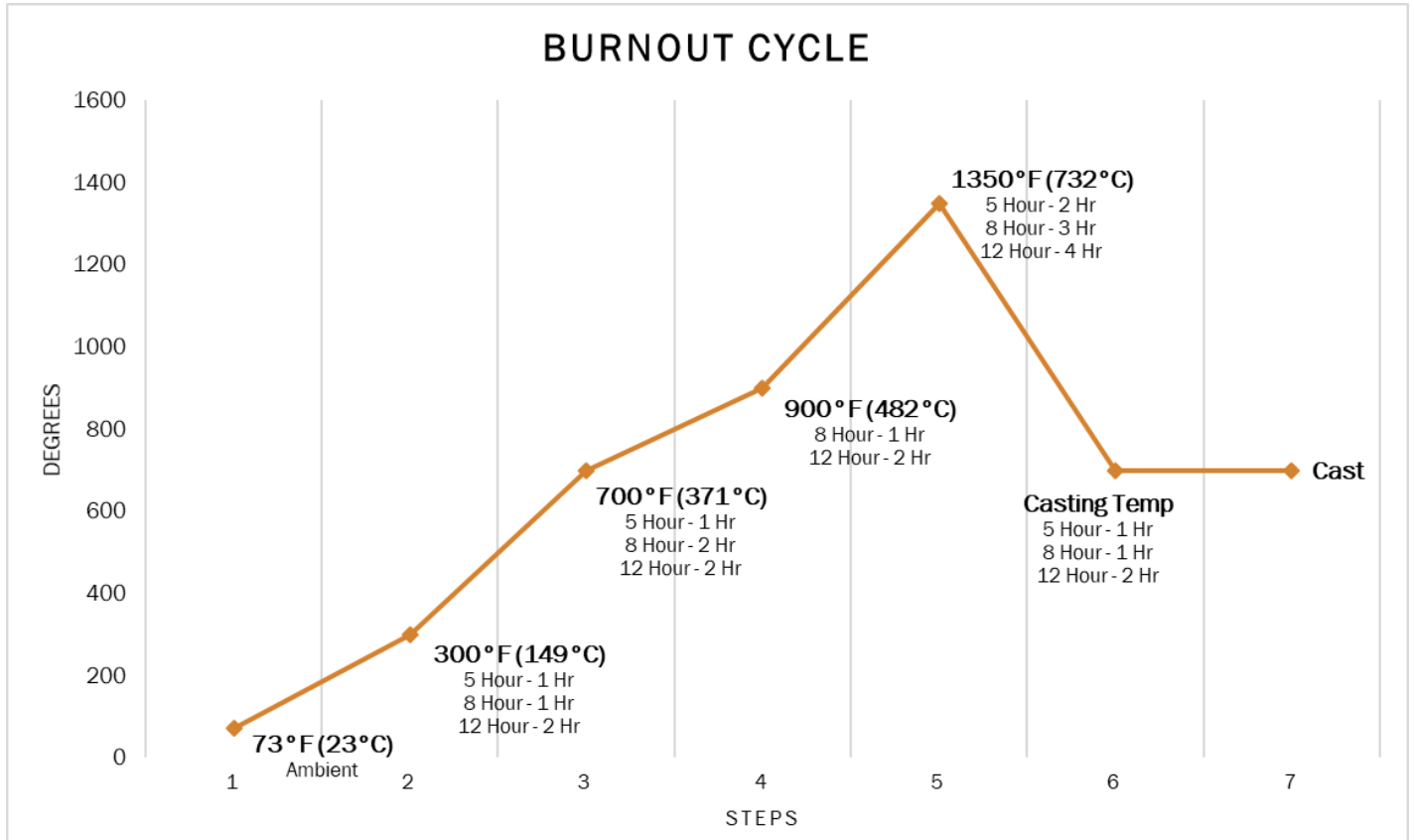
KC2000 INVESTMENT

Work time: Elapsed time between adding powder to the water and thickening of investment.

Water temperature: Water should be 70-75°F (21-24°C). Colder water = extends work time; Warmer water = shortens work time.

Water quality: Deionized (DI) or distilled.

Burnout Cycle



Casting Temperatures

Type of Ring	Temperature Range
Women's rings (intricate designs)	900-1000°F (482-538°C)
Men's rings (heavier designs)	700-900°F (371-482°C)
Note: During final 1-2 hours of burnout, adjust temperature so flasks are at correct casting temperature.	

Hold Time

Cycle Length	Size
5 hour	2.5 in x 2.5 in (63 mm x 66 mm)
8 hour	3.5 in x 4 in (89 mm x 100 mm)
12 hour	4 in x 8 in (100 mm x 200 mm)

Note: Graph is meant as a guide only. Adjustments should be made as necessary. 5, 8, and 12 Hour Cycles represent hold times only and do not include ramp time. Recommended ramp time of approximately 9°F (5°C) per minute.



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
 800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
 www.ransom-randolph.com

    Made in the USA

Ransom & Randolph GmbH
 Leipziger Straße 40 | 04571 Rötha Germany
 +49 342 06373999

Investing with Innovation™

KC2000 INVESTMENT

Storage & Handling

Avoid skin or eye contact. Avoid breathing dust. Wear protective equipment during handling. Wash thoroughly after handling. Close the protective bag tightly in the container of unused investment powder and close the container when not in use. Always store investment in a dry area.

Safety

North America: Danger. Contains crystalline silica. May cause cancer by inhalation. Causes damage to lungs through prolonged or repeated exposure by inhalation. See SDS for more information.

EU: Danger. Contains respirable crystalline silica. Causes damage to lungs through prolonged or repeated exposure. See SDS for more information.

As the conditions or methods of use are beyond our control, we do not assume any responsibility and expressly disclaim any liability for any use of this product. Information contained herein is believed to be true and accurate but all statements or suggestions are made without warranty, expressed or implied, regarding accuracy of the information, the hazards connected with the use of the material or the results to be obtained from the use thereof. Compliance with all applicable federal, state, and local regulations remains the responsibility of the user. All potential liability related to the sale and use of this product is limited to the cost of the particular goods sold in their respective transactions.



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Made in the USA

Issue Date: November 2, 2023

Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

Investing with Innovation™