

Platinum investment & binder

Properties*

Binder:Powder Ratio	Working Time
30:100	20–25 minutes

**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.*

Pattern & Flask Preparation

- Use an absorbent base and liner inside the solid steel flask with a tall collar.
- Cut a small hole in the center of the absorbent base to allow wax to flow freely during burnout.

Mixing & Investing

1. Dilute Binder. 1:14 B:W
2. Weigh investment in a mixing bowl.
3. Measure diluted binder.
4. Do not add all the investment at once.
5. Add investment to the liquid slowly.
6. Once all the powder is added, mix for 15 minutes, stopping periodically to scrape the sides.
7. Vacuum for 1–2 minutes.
8. Pour into the flask, avoid pouring directly onto the pattern. Apply vibration if possible. Do not fill the flask all the way; just enough to cover the pattern.
9. Vacuum up to 90 seconds.
10. Fill the flask 1.5 inches (3.8 cm) above the top of the flask with vibration if possible.
11. Let the flask sit for 5 hours, undisturbed.
12. Carefully remove any investment material remaining above the flask.

Oven Loading & Burnout Cycle

1. Load into oven.
2. Follow the appropriate burnout cycle.
 - * Proceed to page 2.

Note: Adjustments may be required for various furnace types, flask sizes, and oven loading.

Tips

- Use demineralized water at 72–75°F (22–24°C)
- Working time is defined as the time from when the powder is added to the water until the investment becomes thick.
- Keep equipment clean of any set investment.
- Maintain a minimum pattern clearance of 1/4 inch (0.5 cm) at the sides and 1 inch (2.54 cm) at the top and bottom of the flask.
- Do not vacuum while mixing.
- To check a vacuum system for leaks, place water in a glass or ceramic container in the vacuum chamber. It should boil vigorously in 20 seconds.
- It is extremely important to leave flasks undisturbed while curing.
- While loading the oven, do not place flasks too close to the heat source.
- Flasks should be elevated at least 1 inch (2.54 cm) above the oven floor to allow for proper air circulation.
- If absorbent base must be removed before burnout, remove very carefully.
- Use only with the supplied binder.

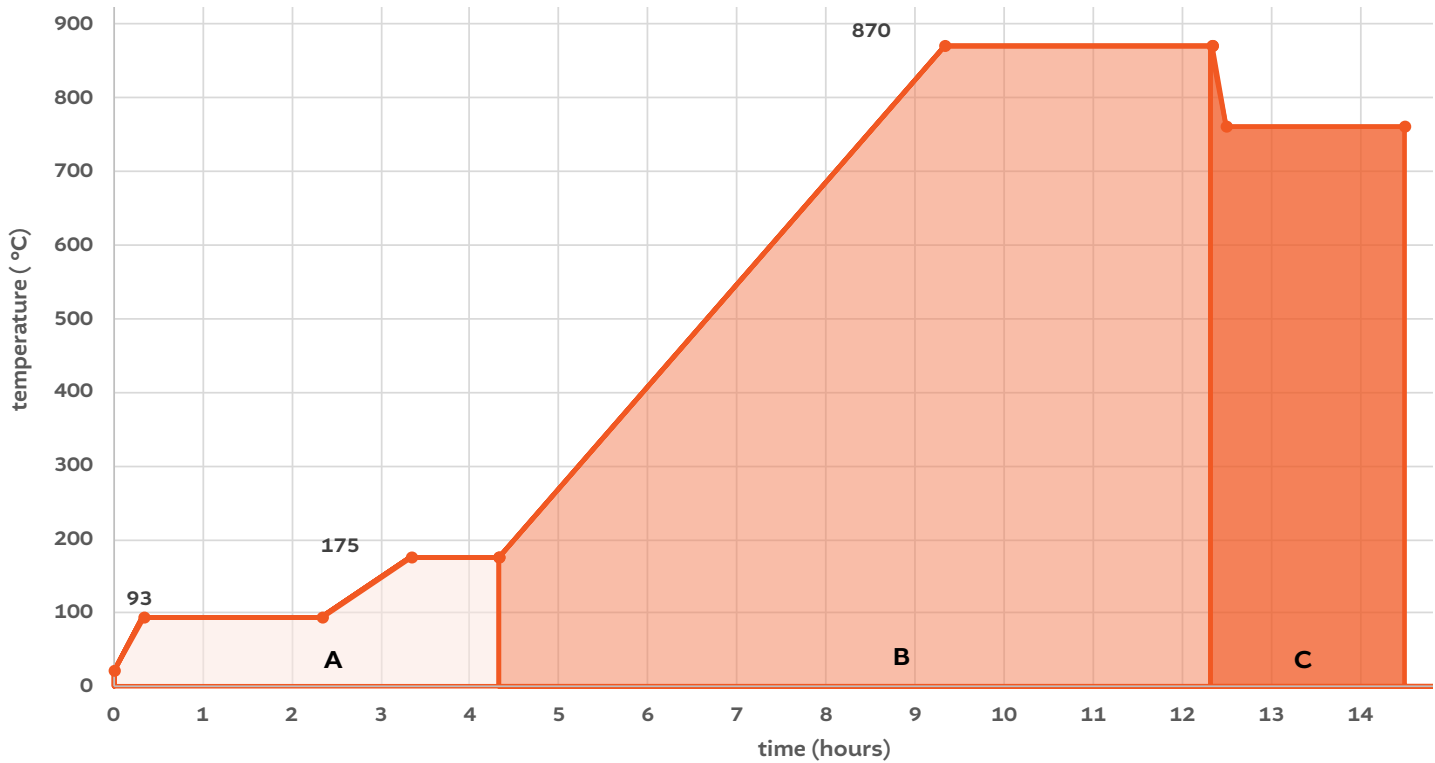
Calculate with Confidence

Scan to access R&R Flask Calculators



Ransom-Randolph.com/flask-calculators

Flash-Fire burnout



Burnout Schedule		Phase	Time (hours)	Schedule °C	Schedule °F
A	Dry	Ramp	As Fast As Possible		
		Hold	2	93	300
		Ramp	1	1.4 °C/min	2.5 °F/min
		Hold	1	175	350
B	Pattern Removal	Ramp	5	2.3 °C/min	4.2 °F/min
		Hold	3	870	1600
C	Casting	Ramp	As Fast As Possible		
		Hold	2	Alloy Manufacturer's Recommendations	

*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.

Storage

Keep container tightly closed when not in use. Store investment in a dry area at room temperature. Shelf life is 2 years from the date of manufacture found in the first six digits of the lot number on the label in MMDDYY format.

Safety

Danger. Contains crystalline silica. Causes damage to lungs through prolonged or repeated exposure by inhalation. Avoid skin or eye contact. Avoid breathing dust. Wear protective equipment when handling. Wash hands thoroughly after handling. See SDS for more information.

North America: May cause cancer by inhalation.

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.

Rev. 2026-08-12