Instructions

Galaxy II universal investment

Properties*

Working Time	Liqiud:Powder
5–6 minutes	23:100

Liquid Dilution Rate	Liquid (mL)	Water (mL)
Tilite and Non-Precious Alloys	20.0	3.0
C&B and Ceramic Alloys	16.0	7.0
Pressable Crowns, Veneers & MOD	15.0	8.0
Pressable Inlays (M0, D0)	11.0	12.0
Printed Resin Partial	16.0	7.0

**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 & Ring Preparation

Use a removable or burn-away ring for flash fire burnout.

Mixing & Investing

1. Use desired liquid dilution rate.
2. Weigh investment.
3. Add investment to diluted binder.

Vacuum Mixer

4. Hand spatulate for 30 seconds.
5. Mix for 1 minute under vacuum at a 400–500 RPM.
6. Pour into ring with vibration, avoid pouring directly onto the pattern.

**Leave the flask undisturbed for 15 minutes.*

Oven Loading & Burnout Cycle

1. Remove sprue base.
2. Follow the appropriate burnout cycle,
   ** Proceed to page 2.*

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

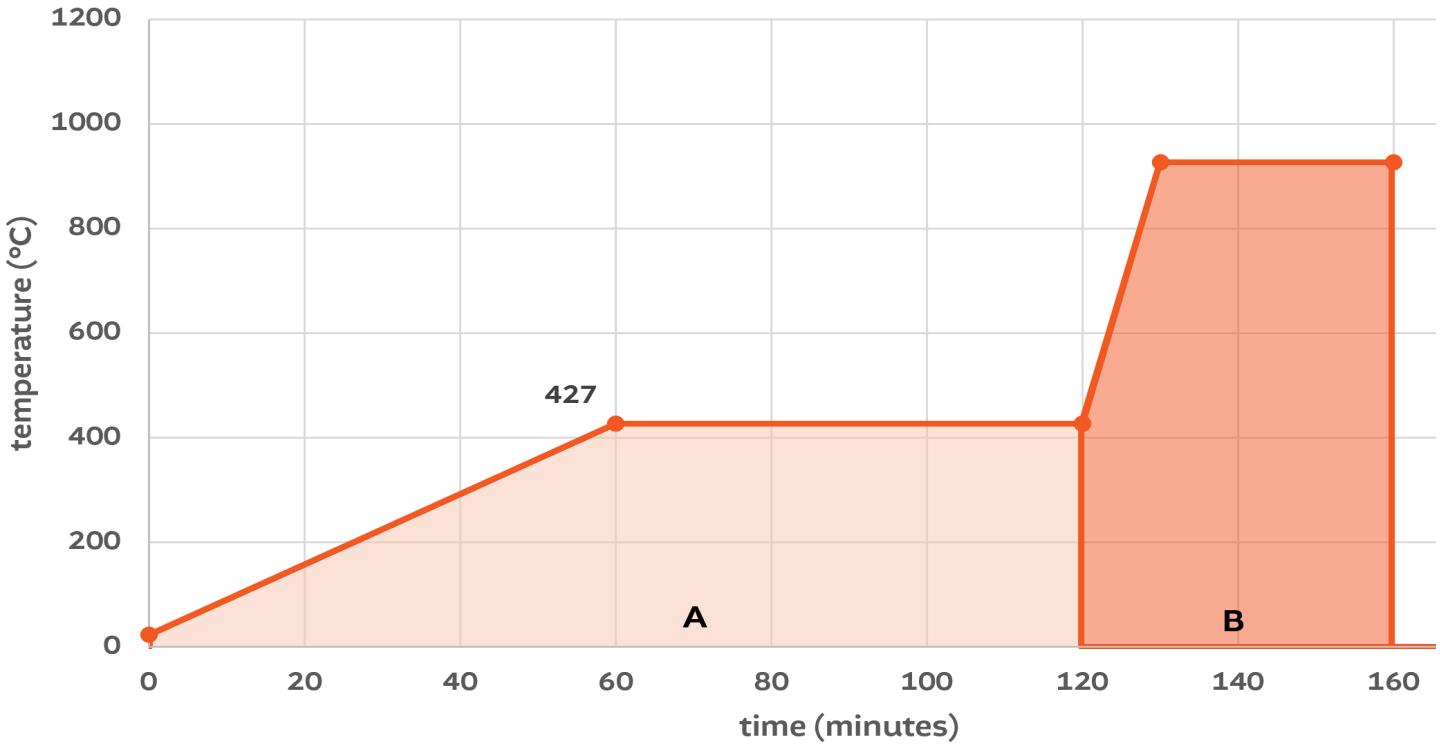
Tips

- Use only with supplied binder.
- 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 ring.
- 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 rings undisturbed while curing.
- While loading the oven, do not place rings too close to the heat source.
- Rings should be elevated at least 1 inch (2.54 cm) above the oven floor to allow for proper air circulation.

Flash fire burnout

- Trim off any excess glaze from the mold.
- Using a flaskless mold, run the mold under water for 1 minute before loading into a preheated oven at 1500–1700°F (815–927°C); hold for a minimum of 1 hour.

Ramped burnout



Burnout Schedule		Phase	Time (minutes)	Schedule °C	Schedule °F
A	Dry	Ramp	60	6.7 °C/min	12 °F/min
		Hold	60	427 °C	800 °F
B	Casting	Ramp	As Fast As Possible		
		Hold	30	Alloy Manufacturer's Recommendation	

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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.

Rev. 2026-09-09

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