

UltraGyp™ 30 gypsum cement

Properties*

Water:Powder Ratio	Set Time	Working Time	Setting Expansion
33:100	25–30 minutes	14–16 minutes	≤30

**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 & Pouring

1. Measure water.
2. Add investment to water.
3. Slowly and evenly add UltraGyp 30 to the water.

Note: Do not add large amounts of powder at one time, as this may prevent proper soaking of UltraGyp 30.

4. Allow the powder to soak until fully wetted and dispersed. Larger batches may require a longer soak time.
5. Mechanically mix until a smooth, uniform slurry is achieved at 200–400 RPM.
6. Pour carefully into the deepest area of the mold, allowing the slurry to flow evenly across the surface.
7. Avoid pouring a large volume directly onto the mold face. Lightly vibrate or agitate the filled mold, as appropriate to release trapped air.
8. Bench cure 2–4 hours.

Drying

Drying casts as soon as practical after manufacture to develop maximum physical properties. Dry to a constant weight.

For best results, use a drying room or oven with:

- Uniform air circulation with no dead-air areas
- Consistent temperature throughout the drying areas
- Ventilation that exhausts moist air and introduces fresh air.

Note: High humidity can slow drying. To help prevent calcination, do not expose dry or nearly dry molds to temperatures above 120°F (49°C). Higher temperatures may be used initially while substantial free water remains in the mold; reduce the drying temperature as the cast dries.

Before removing molds from the dryer, allow them to cool gradually toward room temperature to help prevent thermal shock.

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.
- Longer mixing times may increase mold strength and shorten set time.
- A 33:100 water-to-powder ratio may be used when greater fluidity and slightly longer working time are desired. Higher water content will reduce final strength.
- Longer mixing times may increase mold strength and shorten set time.

Storage

Keep container tightly closed when not in use. Store UltraGyp 30 gypsum cement indoors at temperatures between 65°F and 75°F (18°C and 24°C) and 45% – 55% relative humidity.

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

This product may cause severe skin burns and eye damage and may cause an allergic skin reaction. Avoid breathing dust and contact with skin and eyes. Wear appropriate personal protective equipment. See SDS for more information.

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