Instructions

READYBUILT™ Suspended-Slurry-System

Properties*	Green	Hot, 1200 °C	Post Fired
MOR	~800 psi	~1200 psi	~800 psi
AFL	~12.5 lbf	~19.0 lbf	~12.5 lbf
Deflection	~0.30 mm	~1.50 mm	~0.30 mm

**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.*

READYBUILT Primcote®

1. Remix the READYBUILT Primcote material prior to use to ensure a homogeneous blend of material. Remixing time will vary with the size of the slurry, but should take minutes. Remix slurry either by hand or with a handheld prop mixer. Remix until the liquid at the top of the slurry is blended and the mixture is creamy in appearance. Martial has been remixed successfully when it is in the target viscosity range, 14–16s Zahn #4.
2. Remove the propeller mixer from the tank after initial remixing as the material does not need to be mixed during dipping.
3. Patterns must be clean and free from silicones or other contaminants before dipping.
4. It is not usually necessary to use a prewet between coats. If a prewet is needed, use deionized water only. Drain the pattern before dipping into the slurry.
5. Dip pattern in slurry and apply stucco.
6. Once finished dipping shells, replace slurry tank lid to prevent evaporation.
7. When using READYBUILT Primecote material again, remix to a creamy consistency prior to dipping if there is a visual separation of liquid at the top of the tank and that no material has settled on the edges. If there is no separation visible, dip without remixing.

Slurry Control Procedures: READYBUILT Primcote

1. READYBUILT Primecote material requires simple viscosity control.
2. Control viscosity with water adjustments only. As the viscosity increases, add water to bring the slurry back into target viscosity ranges, 14–16s Zahn #4. Use distilled or deionized water as opposed to tap water; which can contain contaminants that can negatively affect slurry life, and remixed until water is incorporated.
3. Antifoam, wetting and bactericide agents are already formulated into READYBUILT Primecote material and other additions may not be compatible. Contact R&R's technical team before making additions to the slurry.

READYBUILT Intermediate

1. Remix the READYBUILT Intermediate slurry prior to use to ensure a homogeneous blend of material. Remixing time will vary with the size of the slurry. Slurries can be remixed using handheld prop mixers or a stationary high shear mixer Remix until the liquid at the top of the slurry is blended and the mixture is creamy in appearance. Target viscosity is 7–9s on a Zahn #5.
2. Remove the propeller mixer from the tank after initial remixing as the material does not need to be mixed during dipping.
3. Dip patterns with READYBUILT Primecote applied into drum or tank and apply stucco. READYBUILT Intermediate is optional and is part dependent. Ideal for patterns with holes and high corners. Contact R&R's Technical Team to decide if READYBUILT Intermediate is best.

4. Once finished dipping shells, replace slurry drum/tank lid to prevent evaporation.
5. When using READYBUILT Intermediate material again, remix to a creamy consistency prior to dipping if there is a visual separation of liquid at the top of the tank or hard settled material on the edge of the container. If there is no separation visible, dip without remixing.

Slurry Control Procedures: READYBUILT Intermediate

1. READYBUILT Intermediate material requires simple viscosity control. 7–9s on a Zahn #5.
2. Control viscosity with water adjustments only. As the viscosity increases, add water to bring the slurry back into target viscosity range. Use distilled or deionized water as opposed to tap water; which can contain contaminants that can negatively affect slurry life.
3. Antifoam, wetting and bactericide agents are already formulated into READYBUILT Intermediate material and other additions may not be compatible. Contact R&R's technical team before making additions to the slurry.

READYBUILT Back Up

1. Remix the READYBUILT Backup slurry prior to use to ensure a homogeneous blend of material. Remixing time will vary with the size of the slurry. Slurries can be remixed using handheld prop mixers or a stationary high shear mixer Remix until the liquid at the top of the slurry is blended and the mixture is creamy in appearance. Target viscosity is 11–13s on a Zahn #5.
2. Remove the propeller mixer from the tank after initial remixing as the material does not need to be mixed during dipping.
3. Dip patterns with READYBUILT Primecote or READYBUILT Intermediate applied into drum or tank and apply stucco.
4. Once finished dipping shells, replace slurry drum/tank lid to prevent evaporation.
5. When using READYBUILT Backup material again, remix to a creamy consistency prior to dipping if there is a visual separation of liquid at the top of the tank. If there is no separation visible, dip without remixing.

Slurry Control Procedures: READYBUILT Back Up

1. READYBUILT Backup material requires simple viscosity control. 11–13s on Zahn #5.
2. Control viscosity with water adjustments only. As the viscosity increases, add water to bring the slurry back into target viscosity range. Use distilled or deionized water as opposed to tap water; which can contain contaminants that can negatively affect slurry life.
3. Antifoam, wetting and bactericide agents are already formulated into READYBUILT Backup material and other additions may not be compatible. Contact R&R's technical team before making additions to the slurry.

Storage

Always keep READYBUILT Primcote, Intermediate and Back Up materials sealed tightly when not in use to prevent evaporation. Protect from freeing. READYBUILT materials must be maintained about 72 °F (22°C) to prevent the material from precipitating irreversibly and making the product unsuitable for use. Shelf life is 1 year from date (MMDDYY) in batch lot number on label. Rotate stock to maximize shelf life.

Safety

Danger. Contains crystalline silica. Causes damage to lungs through prolonged or repeated exposure by inhalation. May damage fertility. May damage the unborn child. 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.

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