

R&R® Solitaire Investment

1. Weigh the required amount of R&R SOLITAIRE investment. To determine the proper amount of water and powder to use per flask, use the online flask calculator located at www.ransom-randolph.com/resources.html or calculate the volume of your flask ($V = \pi r^2 h$) and multiply by the appropriate factor in the chart below.

	W:P 38/100		W:P 39/100		W:P 40/100		W:P 41/100		W:P 42/100	
	Per in ³ volume	Per cm ³ volume	Per in ³ volume	Per cm ³ volume	Per in ³ volume	Per cm ³ volume	Per in ³ volume	Per cm ³ volume	Per in ³ volume	Per cm ³ volume
Investment Needed										
Grams	21.0	1.28	20.7	1.26	20.4	1.25	20.1	1.23	19.8	1.21
Pounds	0.05		0.05		0.04		0.04		0.04	
Ounces (Weight)	0.74		0.73		0.72		0.71		0.70	
Water Needed										
Grams	8.00	0.49	8.10	0.49	8.20	0.50	8.20	0.50	8.30	0.51
Pounds	0.02		0.02		0.02		0.02		0.02	
Fluid Ounces	0.28		0.29		0.29		0.29		0.29	

2. Measure or weigh the required amount of water (1 g = 1 ml, 1 fluid oz = 29.6 ml) and place in mixing bowl.
Note: changes in temperature affect working time, to reduce variations, water and powder temperatures should be held to 72°F-75°F (22°C-24°C). Working time is defined as the time the powder is added to the water to the time the investment becomes thick.
Note: deionized water is recommended to maintain consistency of the working time.
3. Always add the preweighed quantity of investment to water. Adding the water to the powder will make it difficult to mix and will affect the working time.
4. Wet out the powder with a mixing paddle or a wire whip. This should take no more than 30 seconds.
Note: if using a vacuum investment mixing unit, mix with no vacuum on slow speed until the powder is completely wetted (approximately 1 minute).
5. Mix with mechanical mixer for 3 minutes. Good mixing is important to activate essential ingredients that make the investment perform to its fullest potential.
Note: if using a vacuum investment mixing unit, start vacuum, increase mixing speed and mix for an additional 3 minutes.
6. Place the mixed investment in a vacuum chamber and apply enough vacuum to cause a rapid boil. The investment should be vacuumed until it rises and breaks. Do not exceed 2 minutes. If a longer time is required, the vacuum pump may be undersized, there may be an air leak or the vacuum system may be in need of repair.
7. Pour the vacuumed investment into and down the side of the flask. Avoid pouring it directly over the patterns to prevent wax pattern breakage. Fill flask at least 1" (2.54 cm) over pattern.
Note: if using a vacuum investment mixing unit, pour the investment down along the inside of the flask allowing it to flow up, around, through and over the top row of patterns.

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8. Vacuum the invested flask about 1½ minutes. Vibrating or tapping the flask during this operation will assist in releasing air bubbles from the pattern/investment interface. Release vacuum and fill the flask to the top of the metal edge. Do not overfill.
Note: if using a vacuum investment mixing unit, after flasks are filled, continue to vacuum for 1½ to 2 minutes. Vibration may be applied, if available.
9. Immediately transfer the invested flask to a vibration free storage area. It is extremely important not to disturb the flask during the gloss-off phase as well as during the initial hardening process.
10. To achieve appropriate green strength, allow the investment to sit undisturbed (bench cure) for 2-6 hours.
Note: if bench cure will exceed 6 hours, maintain moisture by rewetting, covering with a wet cloth and sealing in a plastic bag. This will reduce potential cracking of molds due to uneven drying.
11. After bench curing for 2-6 hours, remove the sprue base and investing collar.
12. Ideally, flasks should be loaded into a burnout oven, preheated to 300°F (150°C), button side down. Flasks should be elevated at least 1" (2.54 cm) above oven floor to allow proper air circulation and wax drainage. Do not place flasks too close to the heat source or to each other.
Note: if loading into a cold oven, 300°F (150°C) temperature must be reached as fast as possible.
13. If steam dewax is used, transfer the flasks immediately from dewax into an oven preheated to 300°F (150°C). Do not allow flasks to stand at room temperature for more than 10 minutes.
14. Follow the wax burnout schedule suitable for your application.
Note: wax burnout schedules described are recommendations. Adjustments may be required for various furnace types, flask sizes and oven loading.

Wax Burnout Schedule				
		Flask size: up to 3" x 3" (7.6 cm x 7.6 cm)	Flask size: up to 4" x 6" (10.2 cm x 15.2 cm)	Flask size: up to 4" x 8" (10.2 cm x 20.3 cm)
Water Removal	Ambient to 300°F (150°C) as fast as possible (can be preheated)	Hold 1 hour	Hold 3 hours	Hold 3 hours
Thermal Transition	Raise to 700°F (370°C)	Raise over 1 hour Hold 1 hour	Raise over 2 hours Hold 2 hours	Raise over 2 hours Hold 2 hours
Pattern Removal	Raise to 1166°F (630°C)	Raise over 2 hours Hold 2 hours	Raise over 2 hours Hold 2 hours	Raise over 3 hours Hold 3 hours
	Reduce to casting temperature and allow for stabilization	Hold 1 hour	Hold 2 hours	Hold 2 hours

Note: refer to the mold casting temperatures recommended by your alloy supplier.

Note: in no case should your flask temperature exceed 1166°F (630°C) as stone quality may be compromised.

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Important Tips

- Use deionized water for best results.
- Investment should always be added to the water.
- Equipment must be kept clean and free of set investment.
- 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.
- Leave a minimum clearance from the patterns of ¼" (.05 cm) at the sides and 1" (2.54 cm) at the top and bottom.

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

EU: Danger. Contains respirable crystalline silica. May damage fertility. May damage the unborn child. May cause damage to lungs through prolonged or repeated exposure. See SDS for more information.

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