

ROMANOFF INTERNATIONAL

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J" FORMULA PLATINUM INVESTMENT (Z14-305-50J & Z14-305-606)

IMPORTANT INSTRUCTIONS

Romanoff's "J" Formula Platinum Investment is the world's most popular investment. It has been carefully formulated to produce better platinum, palladium, stainless and other high temperature metal castings than other platinum investments.

BEFORE INVESTING

Before opening the drum, roll it back and forth for about one minute to assure uniformity of the powder. Cut a 3/4" (19mm) hole in the center of a 4" (100mm) x 4" (100mm) non-asbestos paper (76-0881-SQ) square and attach a wax button (use lower temperature sprue wax only) about 1" (25mm) in diameter. Attach this button by heating the bottom of it and straddle it over the 3/4" hole. Mount your wax patterns to the button at a minimum 45 degree angle up from the button.

Place a flask (usually 3" (75mm) x 3" (75mm) over the wax patterns and centered on the 4" (100mm) x 4" (100mm) square. Then use hot wax to attach and seal the outside of the flask to the 4" x 4" base. Carefully place a sheet of non-asbestos paper completely around the inside of the flask to line the inside. This paper should be 2 1/2" (53mm) wide so that it will be 1/4" (6mm) short of each end of the flask. This allows for the necessary absorbency of the binder and allows space for the investment to attach to the inside of the flask. We recommend our 2 1/2" wide non-asbestos paper #76-0855 for the correct rate of absorbency. Place a masking tape extension around the top of the flask to allow the investment to rise during vacuuming. It is important that you fill the flask up to the top the first time rather than "top off" with a second filling.

INVESTING (Measure water and binder by VOLUME not by WEIGHT)

Be sure to wear clear safety glasses and rubber gloves and full rubber apron when handling the binder solution. Also, wear a proper dust mask to avoid inhalation of the powder. The importance of accurate weighing and adequate mixing cannot be overemphasized. Guessing at the proportions or proportioning "by eye" is the surest way to casting failures. Follow these instructions carefully. The bottle of binder concentrate supplied contains 16 ounces (474ml), 50 lbs. (22.7kg) of platinum investment requires 16 ounces (474ml) of concentrated binder which is needed to make the Binder Working Solution. Pour 120 fluid ounces (3552ml) of Distilled water into a clean one gallon (4liter) empty bottle. Add eight (8) fluid ounces (237ml) of binder concentrate to the water. Shake the bottle to mix the binder and water. This combination makes one gallon of Binder Working Solution. Mix 100 parts investment powder with 30 parts binder working solution. (EVEN THOUGH WE ARE GIVING YOU EXACT MEASUREMENTS, WE HAVE FOUND THAT EVERY CUSTOMER USES A SLIGHTLY DIFFERENT LIQUID/POWDER RATIO TO BEST SUIT HIS/HER NEEDS). "SEE PREPARATION CHART ON REVERSE SIDE." A strong electric mixer with a stainless steel flat blade should be used. The ordinary type of household electric mixer will not prove satisfactory and will burn out in a very short time. The powder should be added slowly to the liquid as the mixer runs at a slow speed. Mixing should continue for about six to seven minutes at a slow speed, then run at high speed for two to three minutes. This mixture will become more 'fluid' as you continue to mix it.

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After thorough mixing, vacuum in the bowl for two (2) minutes and vacuum the flask for two (2) minutes). If properly proportioned, mixed and vacuumed, it should pour into the flasks as a smooth, heavy cream. The flasks are then put aside at room temperature to set UNDISTURBED. For 90 minutes. (120 minutes if using flasks larger than 3" x 3".) This time period is important. You should also place several paper towels under the attached paper base to insure complete absorption of the binder solution. The non-asbestos paper base is not removed. (THE INVESTMENT DOES NOT BECOME DRY AND HARD - THIS IS NORMAL). (IT WILL BE THE CONSISTENCY OF PUDDING OR TOOTHPASTE). It will become dry and hard during the burnout cycle.

THIS MUCH POWDER	REQUIRES THIS MUCH DISTILLED WATER (93.75%)***	+	AND THIS MUCH BINDER (6.25%)	=	Binder working solution
1 lb (454g)	4.8 oz fl (142 ml)		0.32 oz fl (9.5ml)		5.12 oz (151.5 ml)
5 lb (2270g)	24 oz fl (710 ml)		1.6 oz fl (47.4 ml)		25.6 oz (757 ml)
10 lb (4540g)	48 oz fl (1420 ml)		3.2 oz fl (94.7 ml)		51.2 oz (1514.7 ml)
25 lb (11350g)	120 oz fl (3552 ml)		8 oz fl (237 ml)		128 oz (3789 ml)

***If you find that the liquid/powder mix is too thin (watery) reduce the water (not the binder) by 5-10%.

OVERNIGHT BURNOUT

1. Room temperature up to 200F (93C) in 30 mins.
2. Hold at 200F for two (2) hours.
3. Climb up to 350F (177C) in one (1) hour.
4. Hold at 350F for 1 hour.
5. Climb to 1600F (871C) over 5 hours.
6. Hold at 1600F for one (1) hour.
7. Flasks are now ready to cast.
IF USING HIGH TEMPERATURE PLASTIC WAXES,
ADD: (BET #4 & #5)
 - 4a. Climb up to 700F (371C) in 30 minutes.
 - 4b. Hold at 700F for 1 hour.
 - 4c. Climb up to 1600F in four (4) hours
[Replaces step 5]

Solidscape Waxes

Need to be sprayed with Romanoff #78-049 to minimize contact with the binder. Spray the wax lightly on all surfaces then let it dry. Do this 4 times to ensure a good protective coating.

If putting Solidscape waxes in the same flask as regular waxes, place the Solidscape waxes at the top of the tree to reduce the time they are in contact with the water/binder.

After casting, allow the flask to cool until it can be held in a non-asbestos glove. Then quench in water, and use a high pressure water gun to remove the bulk of the investment. The quickest way to remove the balance of the investment is with the "J" Break, #80-137-1CAR Investment Remover Solution.

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