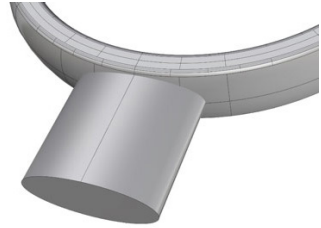


General Recommendations

1. Shake the resin well before each use
2. Cover the vat if not being used to prevent light curing the resin
3. Make sure the supports that are connected to the sprue are thick enough to ensure good burnout (at least 3 x 6 mm)
4. The oven must allow air flow for complete burnout of the patterns.



Post process guidelines

1. First rinse with warm water, then spray with Photocentric Resin Clean or use a Photocentric Wash unit.
2. Drying your parts with an air gun will help ensure all holes are open.
3. Place the parts in an oven at 120°C for 4 hours.
4. Surfaces should be tack free. If still tacky, return items to the oven

Casting guidelines

Ransom & Randolph Plasticast investment powder has been tested. Water to powder ratio of 38:100. An investment vacuum mixer is recommended.

Mixing by hand

1. Add powder to a bowl of water
2. Mix for 3 minutes and pour into the flask
3. Agitate under vacuum for 2 minutes to let air bubbles out.

Mixing by a vacuum mixer

1. Mix for 5 minutes and pour into flask
2. Agitate under vacuum for 1 minute to let any air bubbles out

Leave the flask undisturbed on a stable surface, to set for 3 hours.

Burnout cycle

1. 6 hours at 150 °C
2. Immediately turn up to the maximum temperature (780 °C For Plasticast)
3. Hold at the maximum temperature for 8 hours
4. Cool down for 2 hours to the casting temperature and hold for 1 hour

Ransom & Randolph Plasticast

