

910 Investment Core Material

Ideal for Non-Ferrous Alloys (Not to Exceed 2200° F [1200° C])

910 investment core material is a calcium sulfate bonded investment used for cores. It is used with non-ferrous alloys which do not exceed temperatures of 2200° F (1200° C). 910 investment core material has good green strength, good thermal shock resistance, is easily removed after casting and can be used directly in contact with the wax pattern.

Application/Mixing Instructions

Mixing Ratio/Properties	
Water/Powder Ratio by Weight	28/100
Working Time	10 to 11 minutes
Setting Time	12 to 14 minutes

1. Calcium sulfate bonded core materials require core pins to hold them in place. Place core pins through the wax until they protrude at least ½" into the cavity to be cored. This distance will vary depending on the size of the core. They should extend about ½" outside the wax so the shell can be built around them.
2. Add the measured powder to the water and mix thoroughly by hand or mechanically. To strengthen the core material, you can replace a portion of the water with CORE HARDENER 2000™ binder.
3. Pour the core material into the cavity. Some vibration may be used to help fill the core easier and remove entrapped air. Allow the completed core to set 3-4 hours before further processing.
4. It is important to remember that when a complete-fill core material is used, you must allow extra time during dewaxing and burnout to completely dry and burn out the core. Failure to burn out the core completely may lead to outgassing when metal is poured.
5. If an autoclave is used to remove the wax pattern, the pressure must be released very slowly to prevent destruction of the core material.
6. Placing vents into the cores to help in drying and eliminating gases during casting is recommended.

Note: date of manufacture is indicated by first 6 digits of lot number (MM/DD/YY). R&R recommends using 910 investment core material within 12 months.

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RANSOM & RANDOLPH

Maumee, OH 43537 USA

Toll Free: 800.800.7496

Phone: 419.865.9497

Fax: 419.865.9997

www.ransom-randolph.com

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