

R&R[®] Ranclene Pattern Cleaner

Specially Formulated Aqueous Wax Pattern Cleaner

R&R RANCLENE pattern cleaner is a specially formulated aqueous wax pattern cleaner, designed to both etch the pattern and remove the silicone release agent. R&R RANCLENE pattern cleaner can also be used for removing flow lines on components prior to assembly.

Application Recommendations

Patterns cleaned in R&R RANCLENE pattern cleaner can be dipped in water based primary slurries after they have dried.

After the wax patterns are cleaned and rinsed with water, an acclimation period of at least 1 hour is recommended in the primary slurry area of the shell room to ensure wax patterns are not expanding or contracting from changes in temperature.

R&R RANCLENE pattern cleaner can be used full strength, as packaged, for difficult to release patterns that require a heavy coat of release agent. It may also be used full strength for patterns that have difficult part geometry.

R&R RANCLENE pattern cleaner can be diluted with water to 75% concentration for normal use, making it more economical to use.

Note: at greater than 10% water dilution, material needs to be remixed before pattern immersion.

Typical Process Recommendation

1. If diluted with greater than 10% water, mix tank prior to immersing patterns.
2. Agitated immersion in R&R RANCLENE pattern cleaner for 30 seconds.
Note: this may vary depending on part geometry or amount of silicone to be removed.
3. Agitated immersion in room temperature water for 15 seconds in an overflow tank.
4. Agitated immersion in room temperature water for 15 seconds in a second overflow tank.

Overflow water rinse tanks may be arranged so that the second tank overflows into the first and the first overflows into a drain (consult your local authorities before pouring liquids down the drain).

Perforated tubing or piping may be added to the bottom of the water rinse tanks. By pumping air through these lines during the rinse process, agitation will be enhanced.

Recommended Testing Method

The following Wetting Test can assist with monitoring the effectiveness of the cleaning material:

1. Dip a clean wax bar or pattern into primary binder prewet to its midpoint.
2. Remove from binder and observe the surface.
Good wetting indicators: uniform coat, no binder breaks.
Poor wetting indicators: wax peeks through the binder coat, binder breaks and forms holes.



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Issue Date: 021717 / Replaces: 081116

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Safety & Environment

R&R RANCLENE pattern cleaner contains no hazardous components as defined by the Chemical Hazard Information and Packaging Regulations 1993 (CHIP) and has low Inhalation Index. **R&R RANCLENE pattern cleaner does not contain chlorinated or aromatic hydrocarbon solvents.** For more detail, you may request a copy of the Material Safety Data Sheet (MSDS) at www.ransom-randolph.com.

Economy

The use of an aqueous wax pattern cleaner, such as R&R RANCLENE pattern cleaner, provides significant cost savings due to its low volatility compared to those of the solvents generally used to clean wax trees. In addition, the silicone particles can be skimmed off the wash tank. With this type of maintenance, R&R RANCLENE pattern cleaner can be kept for long periods of time.

As the conditions or methods of use are beyond our control, we do not assume any responsibility and expressly disclaim any liability for any use of this product. Information contained herein is believed to be true and accurate but all statements or suggestions are made without warranty, expressed or implied, regarding accuracy of the information, the hazards connected with the use of the material or the results to be obtained from the use thereof. Compliance with all applicable federal, state, and local regulations remains the responsibility of the user. All potential liability related to the sale and use of this product is limited to the cost of the particular goods sold in their respective transactions.



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