

SuspendaSlurry® Materials

Application Recommendations

1. Remix the SUSPENDASLURRY material prior to use to ensure a homogeneous blend of material. Remixing time will vary with the size of the slurry, but should take minutes. Small slurries may be remixed by hand, larger slurries may require a propeller mixer. Remix until the liquid at the top of the slurry is blended and the mixture is creamy in appearance.
2. Remove the propeller mixer from the tank after initial remixing.
3. Patterns must be clean and free from silicones or other contaminants before dipping.
4. It is not usually necessary to use a prewet between coats. If a prewet is needed, use deionized water only. Drain the pattern before dipping into the slurry.
5. **Once finished dipping shells, replace slurry tank lid to prevent evaporation.**
6. When using SUSPENDASLURRY material again, remix to a creamy consistency prior to dipping if there is a visual separation of liquid at the top of the tank. If there is no separation visible, dip without remixing.

Slurry Control Procedures

1. SUSPENDASLURRY material requires simple viscosity control. Target viscosity ranges for SUSPENDASLURRY material:

	#4 Signature Series Zahn Cup	#5 Signature Series Zahn Cup
Fused Silica (FS)	19-21 seconds	12-13 seconds
Zircon (ZR)	14-16 seconds	8-10 seconds

2. Control viscosity with water adjustments only. As the viscosity increases, add water to bring the slurry back into target viscosity range. Use distilled or deionized water as opposed to tap water; which can contain contaminants that can negatively affect slurry life.
3. Antifoam, wetting and bactericide agents are already formulated into SUSPENDASLURRY material and other additions may not be compatible. Contact R&R's technical team before making additions to the slurry.

Slurry Testing Frequency

R&R recommends running the following tests accordingly.

Slurry Test	Recommended Testing Frequency
Total Solids	Weekly
Slurry Viscosity	Start of each shift

Target Total Solids Range

- SUSPENDASLURRY FS material: 70%-72%
- SUSPENDASLURRY ZR material: 79%-81%



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Refractory Loading

SUSPENDASLURRY FS material is provided at 60% fused silica. SUSPENDASLURRY ZR material is provided at 72% zircon. It is not recommended to use a different refractory load level.

Safety

OSHA-approved respiratory protection should always be worn to avoid inhalation of respirable silica dust, which can result in an irreversible lung disease, silicosis. Such exposure includes slurry makeup, casting, knockout and cleanup. Refer to SDS for specific details.

Storage & Handling

Always keep SUSPENDASLURRY material sealed tightly when not in use to prevent evaporation. Keep from freezing. SUSPENDASLURRY material must be maintained above 35 °F (2 °C) to prevent the material from precipitating irreversibly and making the product unsuitable for use. Shelf life is 1 year from date (MMDDYY) in batch lot number on label. Rotate stock to maximize shelf life.

Once per month, whether dipping parts or not, open the container of SUSPENDASLURRY material, gently remix and reseal container lid.

Settling will occur over time; if left for too long and unused, the settling process may be too difficult to reverse.

Technical Tips

For additional information and recommendations, refer to the Shell Building, Autoclaving and FlashFire Dewax Method Technical Tips available for download at www.ransom-randolph.com under resources.

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