

MCP™ 15 Metal Casting Plaster

Mix 100 parts MCP 15 metal casting plaster powder to 122 parts water by weight. Mechanically mix for 1-2 minutes. Vacuum the mix until the plaster rises and breaks to eliminate entrapped air.

Pour the plaster into the framed pattern (silicone rubber) under vacuum. If this is not possible, it is recommended that a vacuum is pulled on the plaster mold or that the mold is vibrated to eliminate entrapped air.

Stop the vacuum and place mold on a table. It is important that they do not receive mechanical shocks as this may cause cracking.

The molds can be stripped from the rubber pattern after 30 minutes.

After separating the mold from the pattern, the mold can begin the curing cycle. If there is a need to store the molds for more than 2 hours prior to curing, then attempts should be made to prevent the mold from partially drying.

Recommended Curing Cycle

- Raise the temperature from 68°F (20°C) to 356°F (180°C) in 2 hours.
- Raise the temperature from 356°F (180°C) to 536°F (280°C) in 5 hours.
- Hold at 536°F (280°C) for 5-7 hours.
- In 30 minutes, go down to desired casting temperature.
- Cast the metal

Note: curing cycles vary due to mold size, oven loading, and oven efficiency.

US: Danger. May cause cancer by inhalation. Causes damage to lungs through prolonged or repeated exposure by inhalation. Contains crystalline silica. See SDS for more information.

EU: Danger. Causes damage to lungs through prolonged or repeated exposure. Contains respirable crystalline silica. See SDS for more information.

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.



RANSOM & RANDOLPH

Maumee, OH 43537 USA

Toll Free: 800.800.7496

Phone: 419.865.9497

Fax: 419.865.9997

www.ransom-randolph.com

Issue Date: 030717 / Replaces: 093016