

R&R® Rantyre™ Plus Tire Molding Plaster

Mix 100 parts R&R RANTYRE Plus tire molding plaster investment powder to 40 parts water (by weight). Mechanically mix for 2-3 minutes. Vacuum the mix until the investment rises and breaks to eliminate entrapped air.

Pour the investment into the framed pattern (silicon rubber); under vacuum, this operation normally takes 3-4 minutes. Then vibrate the molds, if possible, for 30 seconds to 1 minute to finish eliminating the last entrapped air bubbles.

Stop the vacuum. Take the molds out of the mixing machine and place them 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 30-35 minutes after the initial set.

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 Drying Cycle

- Raise the temperature from 68 °F-356 °F (20 °C-180 °C) in 2 hours.
- Raise the temperature from 356 °F-572 °F (180 °C-300 °C) in 5 hours.
- Hold at 572 °F (300 °C) for 5-7 hours.
- In 30 minutes, reduce the temperature to 500 °F (260 °C).
- Cast the metal.

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.

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