

965 INVESTMENT

Ideal for Aluminum and Copper Based Alloys

965 investment is a calcium sulphate bonded investment which contains silica as well as specially selected and graded refractory materials that provide 965 investment with good core strength and excellent thermal shock properties. 965 investment is a good general use investment for both large and small casting applications. It can be used with vacuum assist or vacuum chamber casting.

Typical Material Properties*

Consistency (Water/Powder Ratio)	Working Time at 72-74 °F (22-23 °C)	Setting Time at 72-74 °F (22-23 °C)	Volume of Mixed Investment
28/100 by weight	8-9 minutes	12-14 minutes	17.75 in ³ per pound of powder

*These results are based on the testing methods, frequency and procedures of Ransom & Randolph or its approved suppliers. The levels referenced herein are only for general guidance and do not constitute a firm specification.

Application Instructions

Mix 100 parts 965 investment powder to 28 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 down the side of the flask, or mold frame, until the patterns are covered to a depth of approximately 1" (2.5 cm). Vibrate or vacuum the mold to remove air bubbles, which may tend to adhere to the patterns. This operation normally takes 1 to 1½ minutes. Top off the flask with investment and allow to set for 2 hours before starting wax removal and burnout.

Re-usable Patterns

After waiting a minimum of 1 hour, re-usable patterns can be physically removed from the mold.

Wax Patterns

Two methods of wax removal are commonly used: dry dewax and steam dewax. For dry dewaxing, place the mold into a kiln or furnace at a temperature of 300-350 °F (149-177 °C) and hold for 3-4 hours. For steam dewaxing, place the mold into the steam dewaxer. Steam dewax only for the time required to remove the wax and no longer. The amount of time required to dewax the molds will vary depending on the size of the mold. After steam dewaxing, immediately place the mold into a furnace at a temperature of 300-350 °F (149-177 °C) and hold for 3-4 hours.

After the mold is dewaxed, raise the temperature to 1300-1350 °F (704-732 °C) at a rate of 150-200 °F (66-93 °C) per hour. Hold the molds at this temperature until the pattern material is completely eliminated. Burnout will take approximately 5 hours at this temperature, although the time will vary depending upon furnace loading and flask size.

After burnout, the molds should be cooled in the furnace to the desired casting temperature. This is normally 400-550 °F (204-288 °C) for aluminum and 800-1000 °F (427-538 °C) for copper based alloys.

Safety

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

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



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com



Made in the USA

Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

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Ransom & Randolph GmbH
Leipziger Straße 40 | 04571 Rötha Germany
+49 342 06373999

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