

# Plasticast® PT Investment & Binder

1. Dilute PLASTICAST PT binder prior to use for investing. The water to binder dilution ratio is 60:40 W:B by weight or 70:30 W:B by volume. Example: for 1 gallon (3.8 liter) of diluted binder, mix 5.8 pounds (2.6 kg) water with 3.9 pounds (1.8 kg) binder.
2. Weigh the required amount of PLASTICAST PT investment. To determine the proper amount of diluted binder and powder to use per flask, use the online flask calculator located at [www.ransom-randolph.com/resources.html](http://www.ransom-randolph.com/resources.html) or calculate the volume of your flask ( $V = \pi r^2 h$ ) and multiply by the appropriate factor in the chart below.

|                       |                 | Diluted Binder:Powder<br>28/100 |                            |
|-----------------------|-----------------|---------------------------------|----------------------------|
|                       |                 | Per in <sup>3</sup> volume      | Per cm <sup>3</sup> volume |
| Investment Needed     | Grams           | 25.4                            | 1.56                       |
|                       | Pounds          | 0.056                           |                            |
|                       | Ounces (Weight) | 0.90                            |                            |
|                       |                 |                                 |                            |
| Diluted Binder Needed | Grams           | 7.12                            | 0.44                       |
|                       | Pounds          | 0.0157                          |                            |
|                       | Fluid Ounces    | 0.21                            |                            |
|                       |                 |                                 |                            |

2. Measure or weigh the required amount of diluted binder (1 g = 1 ml, 1 fluid oz = 29.6 ml) and place in mixing bowl.  
**Note:** changes in temperature affect working time, to reduce variations, binder and powder temperatures should be held to 72°F-85°F (22°C-29°C). R&R recommends 72°F-75°F (22°C-24°C), warmer temperatures will significantly reduce working time. Working time is defined as the time the powder is added to the binder to the time the investment becomes thick.
3. Always add the preweighed quantity of investment to binder. Adding the binder to the powder will make it difficult to mix and will affect the working time.
4. Wet out the powder with a mixing paddle or a wire whip. This should take no more than 30 seconds.  
**Note:** if using a vacuum investment mixing unit, mix for 30 seconds with no vacuum on slow speed until the powder is completely wetted, engage mechanical mixing under vacuum for an additional 1 minute.  
**Note:** Monitor mixing speed as aggressive mixing reduces working time. Suggested mixing speed is 360–500 rpm.
5. Mix with mechanical mixer for 1 minute. Good mixing is important to activate essential ingredients that make the investment perform to its fullest potential.  
**Note:** if using a vacuum investment mixing unit, start vacuum, increase mixing speed and mix for an additional 1½ minutes.
6. Place the mixed investment in a vacuum chamber and apply enough vacuum to cause a rapid boil. The investment should be vacuumed until it rises and breaks. Monitor this process closely as the material is high rising.



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7. Pour the vacuumed investment into and down the side of the flask. Avoid pouring it directly over the patterns to prevent wax pattern breakage. Fill flask at least 1" (2.54 cm) over pattern.  
**Note:** if using a vacuum investment mixing unit, pour the investment down along the inside of the flask allowing it to flow up, around, through and over the top row of patterns.
8. Vacuum the invested flask about 3½ minutes. Vibrating or tapping the flask during this operation will assist in releasing air bubbles from the pattern/investment interface. Release vacuum and fill the flask to the top of the metal edge. Do not overfill.  
**Note:** if using a vacuum investment mixing unit, after flasks are filled, continue to vacuum for 2 minutes. Vibration may be applied, if available.
9. Immediately transfer the invested flask to a vibration free storage area. It is extremely important not to disturb the flask during the gloss-off phase as well as during the initial hardening process.
10. To achieve appropriate green strength, allow the investment to sit undisturbed (bench cure) for 1 hour. Molds should be placed in a well-ventilated area as they will emit a slight ammonia smell. This system is exothermic and molds will be hot to the touch.  
After bench curing for 1 hour, remove the sprue base and investing collar.
11. Ideally, flasks should be loaded into a burnout oven, preheated to 200°F (93°C), button side down. Flasks should be elevated at least 1" (2.54 cm) above oven floor to allow proper air circulation and wax drainage. Do not place flasks too close to the heat source or to each other.  
**Note:** if loading into a cold oven, 200°F (93°C) temperature must be reached as fast as possible.
12. If steam dewax is used, transfer the flasks immediately from dewax into an oven preheated to 200°F (93°C). Do not allow flasks to stand at room temperature for more than 10 minutes.
13. Follow the wax burnout schedule suitable for your application.  
**Note:** wax burnout schedules described are recommendations. Adjustments may be required for various furnace types, flask sizes and oven loading.

| Wax Burnout Schedule                                           |                                         |                                      |                                    |
|----------------------------------------------------------------|-----------------------------------------|--------------------------------------|------------------------------------|
|                                                                | Flash Burnout                           | Same Day Burnout                     | Overnight Burnout                  |
| Ambient to 200°F (93°C) as fast as possible (can be preheated) | Not applicable                          | Hold 1 hour                          | Hold 2 hours                       |
| Raise to 350°F (175°C)                                         | Not applicable                          | Raise over 1 hour<br>Hold 30 minutes | Raise over 1 hour<br>Hold 1 hour   |
| Raise to 1600°F (871°C)                                        | Start at 1600°F (871°C)<br>Hold 2 hours | Raise over 2½ hours<br>Hold 2 hours  | Raise over 5 hours<br>Hold 3 hours |
| Reduce to casting temperature and allow for stabilization      | Hold 1 hour                             | Hold 2 hours                         | Hold 2 hours                       |

**Note:** refer to the mold casting temperatures recommended by your alloy supplier.



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Issue Date: 041116 / Replaces: 031716

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## Important Tips

- Only for use with supplied binder.
- Binder must be protected from freezing or it will not be effective.
- Product designed for mixes using less than 6 pounds of investment.
- Keep separated from gypsum investments and use only dedicated equipment that has NOT come into contact with gypsum investments.
- Investment should always be added to the binder.
- Equipment must be kept clean and free of set investment.
- Close the protective bag tightly in the container of unused investment powder and close the container when not in use.
- Always store investment in a dry area.
- Leave a minimum clearance from the patterns of ¼" (.05 cm) at the sides and 1" (2.54 cm) at the top and bottom.

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

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

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