



*Ransom & Randolph  
proudly offers  
the following products  
for your casting needs:*

Ultra-Vest®  
investment

R&R® ADVANTAGE™  
investment

R&R® Solitaire  
investment

Astro-Vest™  
investment

R&R® platinum  
investment & binder

PreVest™ Americast®  
investment

PreVest™ Stone-Brite®  
investment

PreVest™ Econovest®  
investment

PreVest™ Platinum Plus™  
investment & binder

Debubblizer concentrate  
HP Injection Wax

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# Application Instructions

## Ultra-Vest® Jewelry Investment

UPDATED: SEPTEMBER 2003

1. Referring to page 3, weigh the required amount of ULTRA-VEST investment.
2. Measure or weigh the required amount of water (1 g = 1 ml, 1 fluid oz = 29.6 ml) and place in mixing bowl.

**NOTE:** To reduce variations in working time, water and powder temperatures should be held to 72-85°F (22-29°C).

Working time is defined as the time the powder is added to the water to the time the investment becomes thick.

**NOTE:** Deionized water is recommended to maintain consistency of the working time.

3. Always add the preweighed quantity of investment to water. Adding the water 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.
5. Mix with mechanical mixer for 3 minutes. Good mixing is important to activate essential ingredients that make the investment perform to its fullest potential.
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. Do not exceed 2 minutes. If a longer time is required, the vacuum pump is undersized, is in need of repair, or there is an air leak in the vacuum system.
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.
8. Vacuum the invested flask about 1.5 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.
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.  
  
ULTRA-VEST investment does not cause water marking; therefore, steps 3 through 9 may be completed in any time up to the maximum of 8.5 minutes.
10. Allow the investment to sit undisturbed for 2 hours. The mold will achieve its maximum green strength after 2 hours.
11. After hardening for 2 hours, remove the sprue base and investing collar.
12. Load invested flasks into a preheated burnout oven, button side down. Flasks should be elevated at least 1 inch 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.
13. If a steam dewax is used, transfer the flasks immediately from dewax into an oven preheated to 300°F (150°C). Do not allow flasks to stand at room temperature for more than 10 minutes.

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14. Refer to page 3 and follow the wax burnout cycle suitable for your application.

**NOTE:** Burnout cycles described are recommendations. Adjustments may be required for various furnace types, flask sizes and oven loading.

#### **Important Tips**

1. Investment should always be added to the water.
2. Equipment must be kept clean and free of set investment.
3. Close the protective bag tightly in the container and close the container when not in use.
4. Always store investment in a dry area.

#### **WARNING!**

**ULTRA-VEST investment contains respirable crystalline silica (RCS). Do not breathe dust. May cause delayed lung injury (silicosis, pneumoconiosis). Follow OSHA Safety and Health Standards for crystalline silica. See Material Safety Data Sheet (MSDS) for detailed information.**

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1. To determine the proper amount of water and powder to use per flask, locate the volume of the flask size you are using on the chart below.

CUBIC VOLUME BY FLASK SIZE								
Height — Diameter	2.5 inches (6.4 cm)	3.0 inches (7.6 cm)	3.5 inches (8.9 cm)	4.0 inches (10.2 cm)	5.0 inches (12.7 cm)	6.0 inches (15.2 cm)	7.0 inches (17.8 cm)	8.0 inches (20.3 cm)
2.5 inches (6.4 cm)	12.3 in <sup>3</sup> (201 cm <sup>3</sup> )	14.7 in <sup>3</sup> (241 cm <sup>3</sup> )	17.2 in <sup>3</sup> (281 cm <sup>3</sup> )	19.6 in <sup>3</sup> (321 cm <sup>3</sup> )	24.5 in <sup>3</sup> (400 cm <sup>3</sup> )	29.5 in <sup>3</sup> (481 cm <sup>3</sup> )	34.4 in <sup>3</sup> (561 cm <sup>3</sup> )	39.3 in <sup>3</sup> (642 cm <sup>3</sup> )
3.0 inches (7.6 cm)	17.7 in <sup>3</sup> (290 cm <sup>3</sup> )	21.2 in <sup>3</sup> (348 cm <sup>3</sup> )	24.7 in <sup>3</sup> (405 cm <sup>3</sup> )	28.3 in <sup>3</sup> (463 cm <sup>3</sup> )	35.3 in <sup>3</sup> (579 cm <sup>3</sup> )	42.4 in <sup>3</sup> (695 cm <sup>3</sup> )	49.5 in <sup>3</sup> (811 cm <sup>3</sup> )	56.5 in <sup>3</sup> (927 cm <sup>3</sup> )
3.5 inches (8.9 cm)	24.1 in <sup>3</sup> (395 cm <sup>3</sup> )	28.9 in <sup>3</sup> (474 cm <sup>3</sup> )	33.7 in <sup>3</sup> (553 cm <sup>3</sup> )	38.5 in <sup>3</sup> (632 cm <sup>3</sup> )	48.1 in <sup>3</sup> (790 cm <sup>3</sup> )	57.7 in <sup>3</sup> (948 cm <sup>3</sup> )	67.4 in <sup>3</sup> (1106 cm <sup>3</sup> )	76.9 in <sup>3</sup> (1261 cm <sup>3</sup> )
4.0 inches (10.2 cm)	31.4 in <sup>3</sup> (514 cm <sup>3</sup> )	37.7 in <sup>3</sup> (618 cm <sup>3</sup> )	44.0 in <sup>3</sup> (721 cm <sup>3</sup> )	50.3 in <sup>3</sup> (824 cm <sup>3</sup> )	62.8 in <sup>3</sup> (1030 cm <sup>3</sup> )	75.4 in <sup>3</sup> (1236 cm <sup>3</sup> )	88.0 in <sup>3</sup> (1441 cm <sup>3</sup> )	100.5 in <sup>3</sup> (1647 cm <sup>3</sup> )
5.0 inches (12.7 cm)	49.1 in <sup>3</sup> (810 cm <sup>3</sup> )	58.9 in <sup>3</sup> (965 cm <sup>3</sup> )	68.7 in <sup>3</sup> (1126 cm <sup>3</sup> )	78.5 in <sup>3</sup> (1287 cm <sup>3</sup> )	98.2 in <sup>3</sup> (1609 cm <sup>3</sup> )	117.8 in <sup>3</sup> (1931 cm <sup>3</sup> )	137.4 in <sup>3</sup> (2252 cm <sup>3</sup> )	157.1 in <sup>3</sup> (2574 cm <sup>3</sup> )
6.0 inches (15.2 cm)	70.7 in <sup>3</sup> (1158 cm <sup>3</sup> )	84.8 in <sup>3</sup> (1390 cm <sup>3</sup> )	99.0 in <sup>3</sup> (1622 cm <sup>3</sup> )	113.1 in <sup>3</sup> (1853 cm <sup>3</sup> )	141.4 in <sup>3</sup> (2317 cm <sup>3</sup> )	169.6 in <sup>3</sup> (2780 cm <sup>3</sup> )	197.9 in <sup>3</sup> (3243 cm <sup>3</sup> )	226.2 in <sup>3</sup> (3707 cm <sup>3</sup> )

2. Using the volume located in the previous step, calculate the weight of powder and the volume of water for your flask size using the following equations:

**HEAVY CASTINGS = 39/100 WP (Men's rings or pieces with thick sections)**

English measure:

Volume (in<sup>3</sup>) x .0455 lbs = \_\_\_\_\_ lbs powder

Volume x .272 fl oz = \_\_\_\_\_ fl oz water

Metric measure:

[Volume (cm<sup>3</sup>) x 1.25 g]/1000 = \_\_\_\_\_ kg powder

Volume x .488 ml = \_\_\_\_\_ ml water

**NORMAL CASTINGS = 40/100 WP (Ladies' rings)**

English measure:

Volume (in<sup>3</sup>) x .0448 lbs = \_\_\_\_\_ lbs powder

Volume x .275 fl oz = \_\_\_\_\_ fl oz water

Metric measure:

[Volume (cm<sup>3</sup>) x 1.23 g]/1000 = \_\_\_\_\_ kg powder

Volume x .494 ml = \_\_\_\_\_ ml water

**DELICATE CASTINGS = 42/100 WP (Filigree and small pieces)**

English measure:

Volume (in<sup>3</sup>) x .0435 lbs = \_\_\_\_\_ lbs powder

Volume x .280 fl oz = \_\_\_\_\_ fl oz water

Metric measure:

[Volume (cm<sup>3</sup>) x 1.20 g]/1000 = \_\_\_\_\_ kg powder

Volume x .506 ml = \_\_\_\_\_ ml water

**Wax Burnout Schedule**

Flask size: up to 2.5 x 5.0 in. (6.3 cm x 12.7 cm)	Flask size: up to 4.0 x 6.0 in. (10.2 cm x 15.2 cm)	Flask size: up to 6.0 x 12.0 in. (15.2 cm x 30.5 cm)
Hold at 300F (150C) for 2 hours	Hold @ 300F (150C) for 3 hours	Hold @ 300F (150C) for 4 hours
Elevate to 700F (370C) over the next 2.5 hours	Elevate to 700F (370C) over the next 2.5 hours	Elevate to 700F (370C) over the next 2.5 hours
Hold at 700F (370C) for 2 hours	Hold at 700F (370C) for 2 hours	Hold at 700F (370C) for 2 hours
Elevate to 1350F (730C) over the next 3.5 hours	Elevate to 1350F (730C) over the next 3.5 hours	Elevate to 1350F (730C) over the next 3.5 hours
Hold at 1350F (730C) for 3 hours	Hold at 1350F (730C) for 3 hours	Hold at 1350F (730C) for 3 hours
Reduce to casting temperature & hold 1 hour before casting.	Reduce to casting temperature & hold for 2 hours before casting.	Reduce to casting temperature & hold for 3 hours before casting.

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