

SC20 BANDUST™ INVESTMENT



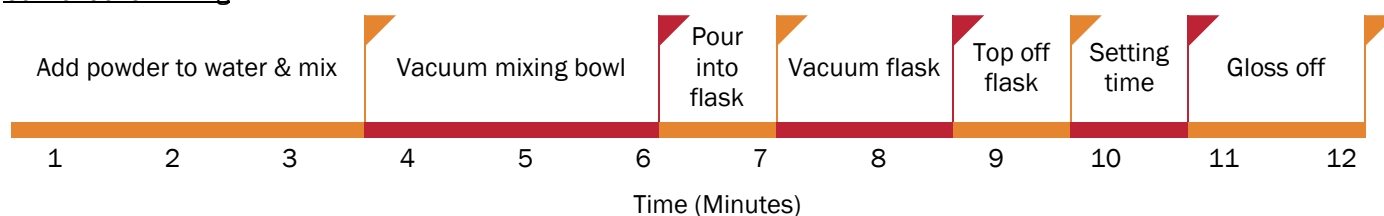
Mixing Instructions

1. Weigh investment.
 2. Measure water.
 3. Add investment to water.
 4. Mix 3-3.5 minutes.
 5. Vacuum 20 seconds after boil.
 6. Pour into flask.
 7. Vacuum up to 90 seconds.
 8. Let flask sit still for 2 hours.
 9. Preheat furnace 300° F (149° C).
- Note:** do not preheat for multiple flasks.

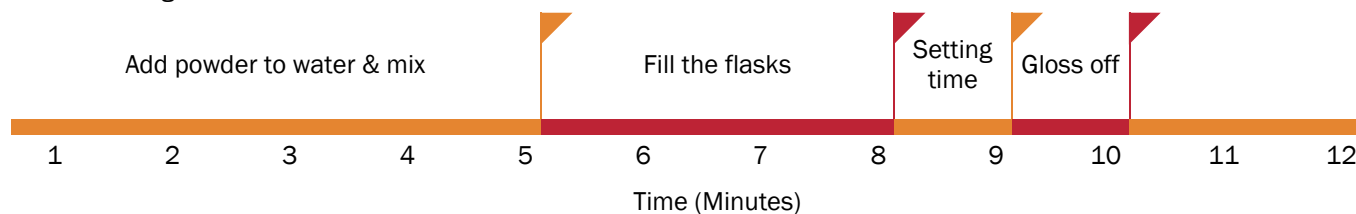
10. Remove sprue base.
11. Load into furnace.
12. Follow appropriate burnout cycle.

Recommended Working Time

Conventional Mixing



Vacuum Mixing



Work time: elapsed time between adding powder to the water and thickening of investment.

Water temperature: water should be 70-75° F (21-24° C). Colder water = extends work time; Warmer water = shortens work time.

Water quality: deionized (DI) or distilled.



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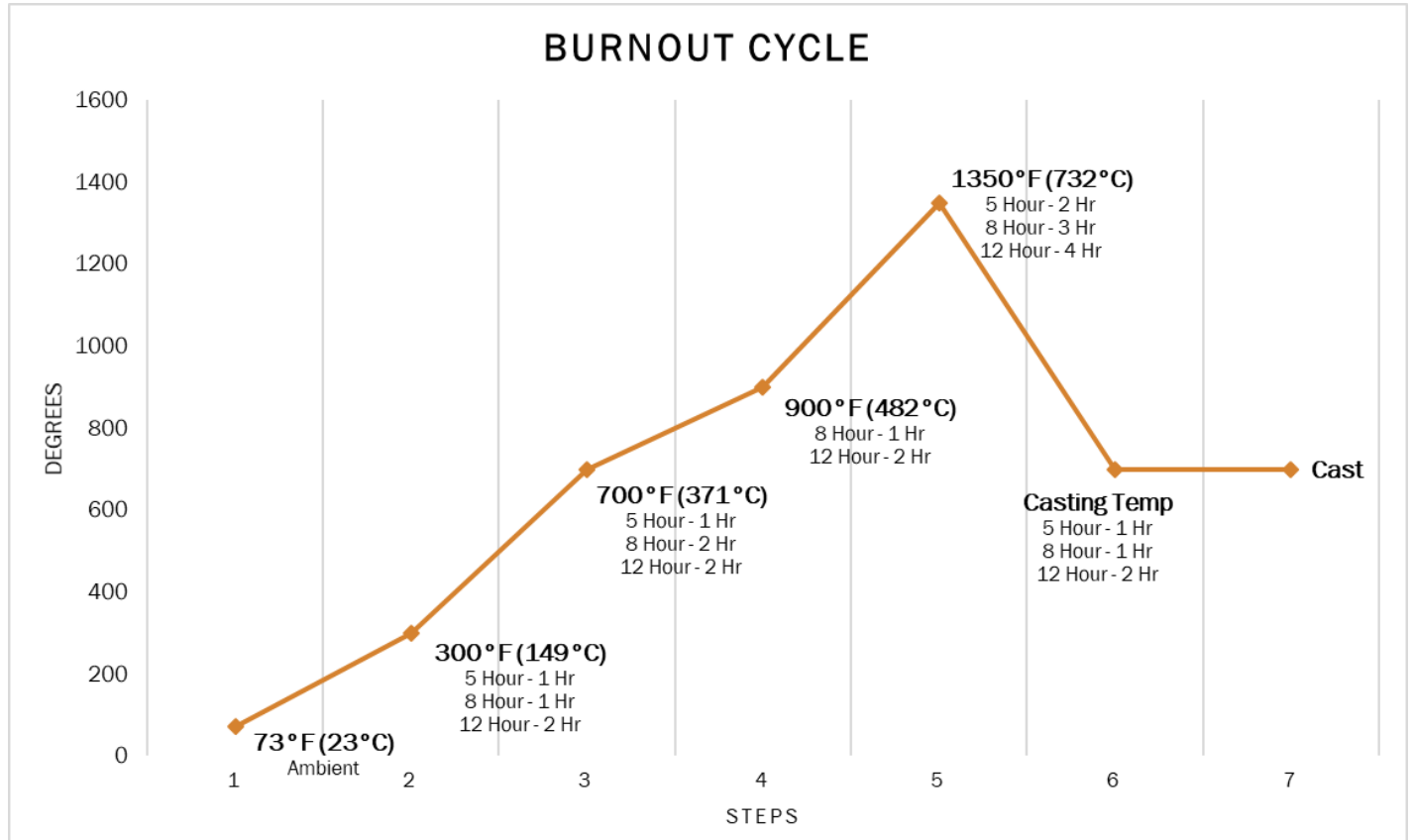
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Burnout Cycle



Casting Temperatures

Type of Ring	Temperature Range
Women's rings (intricate designs)	900-1000 °F (482-538 °C)
Men's rings (heavier designs)	700-900 °F (371-482 °C)

Note: During final 1-2 hours of burnout, adjust temperature so flasks are at correct casting temperature.

Hold Time

Cycle Length	Size
5 hour	2.5 in x 2.5 in (63 mm x 66 mm)
8 hour	3.5 in x 4 in (89 mm x 100 mm)
12 hour	4 in x 8 in (100 mm x 200 mm)

Note: Graph is meant as a guide only. Adjustments should be made as necessary. 5, 8, and 12 Hour Cycles represent hold times only and do not include ramp time. Recommended ramp time of approximately 9 °F (5 °C) per minute.

Typical Material Properties*

Silica (SiO ₂) (Quartz & Cristobalite)	Calcium Sulfate (Gypsum)
60-80%	20-40%

*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.



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Frequently Asked Questions – BANDUST™ Technology Jewelry Investments

Do I need to wear a respirator?

Due to variations from one casting facility to another (batch size, mixing and casting procedures, site specific administrative rules, good work practices and engineering controls), Ransom & Randolph cannot advise against wearing a respirator. We recommend contacting an industrial hygienist, or appropriate authorities, in your area to determine if BANDUST technology respirable dust levels in your facility are below the level requiring respirators.

Why is there a warning on the label?

Labeling laws in the United States require that any product which contains a certain volume of crystalline silica or quartz be labeled with the potential hazard. Because this product contains these raw materials, we are complying with US law by applying the appropriate warning (reference OSHA Hazard Communication Standard 29 CFR 1910.1200). In the United States, labeling is not based on testing of respirable dust.

Is there respirable silica exposure during devesting?

If you are DRY devesting, there is an exposure risk and appropriate safety equipment should be used. During QUENCH devesting, industrial hygienist testing did not detect measurable respirable dust. Before changing your safety procedures during quenching, appropriate on-site testing must be completed to verify the same is true of your facility.

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.

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.



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