

R&R® RANCLENE 2 PATTERN CLEANER

Specialty Formulated Aqueous Wax Pattern Cleaner

R&R Ranclene 2 pattern cleaner is a specially formulated aqueous wax pattern cleaner, designed to both etch the pattern and remove the silicone release agent. R&R Ranclene 2 pattern cleaner can also be used for removing flow lines on components prior to assembly.

Application Recommendations

Patterns cleaned in R&R Ranclene 2 pattern cleaner can be dipped in water based primary slurries after they have dried.

After the wax patterns are cleaned and rinsed with water, an acclimation period of at least 1 hour is recommended in the primary slurry area of the shell room to ensure wax patterns are not expanding or contracting from changes in temperature.

R&R Ranclene 2 pattern cleaner can be used full strength, as packaged, for difficult to release patterns that require a heavy coat of release agent. It may also be used full strength for patterns that have difficult part geometry.

R&R Ranclene 2 pattern cleaner can be diluted with water to 75% concentration for normal use, making it more economical to use.

Note: at greater than 10% water dilution, material needs to be remixed before pattern immersion.

Typical Process Recommendation

1. If diluted with greater than 10% water, mix tank prior to immersing patterns.
2. Agitated immersion in R&R Ranclene 2 pattern cleaner for 30 seconds.
Note: this may vary depending on part geometry or amount of silicone to be removed.
3. Agitated immersion in room temperature water for 15 seconds in an overflow tank.
4. Agitated immersion in room temperature water for 15 seconds in a second overflow tank.

Overflow water rinse tanks may be arranged so that the second tank overflows into the first and the first overflows into a drain (consult your local authorities before pouring liquids down the drain).

Perforated tubing or piping may be added to the bottom of the water rinse tanks. By pumping air through these lines during the rinse process, agitation will be enhanced.

Recommended Testing Method

The following Wetting Test can assist with monitoring the effectiveness of the cleaning material:

1. Dip a clean wax bar or pattern into primary binder prewet to its midpoint.
2. Remove from binder and observe the surface.
Good wetting indicators: uniform coat, no binder breaks.
Poor wetting indicators: wax peeks through the binder coat, binder breaks and forms holes.

Economy

The use of an aqueous wax pattern cleaner, such as R&R Ranclene 2 pattern cleaner, provides significant cost savings due to its low volatility compared to those of the solvents generally used to clean wax trees. In addition, the silicone particles can be skimmed off the wash tank. With this type of maintenance, R&R Ranclene 2 pattern cleaner can be kept for long periods of time.

Safety

R&R Ranclene 2 pattern cleaner contains no hazardous components as defined by the Chemical Hazard Information and Packaging Regulations 1993 (CHIP) and has low Inhalation Index. **R&R Ranclene 2 pattern cleaner does not contain chlorinated or aromatic hydrocarbon solvents.** See SDS for more information.



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