

## PLASTICS for FOUNDRY

### STANDARD PLASTICS

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
RAM MAX <sup>®</sup> 70 P	69.1	22.8	2.74 / 171.0	1760°C (3200°F)
RAM MAX <sup>®</sup> 75 P	72.3	19.7	2.74 / 171.0	1760°C (3200°F)
RAM MAX <sup>®</sup> 85 P	83.8	9.0	2.92 / 182.0	1760°C (3200°F)
RAM MAX <sup>®</sup> 90 P	87.4	7.1	3.09 / 193.0	1815°C (3300°F)
RAM MAX <sup>®</sup> BR 70 P BLUE	69.8	23.4	2.56 / 164.0	1760°C (3200°F)

### EXTENDED SHELF-LIFE PLASTICS

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
RAM MAX <sup>®</sup> 70 P EXT	72.5	19.9	2.63 / 164.0	1760°C (3200°F)
RAM MAX <sup>®</sup> 85 P EXT	81.8	10.4	2.79 / 178.0	1760°C (3200°F)
RAM MAX <sup>®</sup> 90 P EXT	91.7	3.8	2.96 / 185.0	1870°C (3400°F)

### CONSTRUCTION GRADE PLASTICS

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
RAM MAX <sup>®</sup> 85 P FIRM	81.7	11.2	2.88 / 180.0	1760°C (3200°F)
RAM MAX <sup>®</sup> 388 P	90.8	5.2	3.09 / 193.0	1760°C (3200°F)

### FINE GRAINED PLASTICS

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
RAM MAX <sup>®</sup> 70 P FINE	67.8	26.6	2.69 / 168.0	1650°C (3000°F)
RAM MAX <sup>®</sup> 75 P FINE	73.2	19.9	2.40 / 150.0	1760°C (3200°F)
RAM MAX <sup>®</sup> 85 P FINE	81.9	11.1	2.82 / 176.0	1760°C (3200°F)
RAM MAX <sup>®</sup> 90 P FINE	88.4	6.9	2.88 / 180.0	1760°C (3200°F)



## ENHANCED CHEMICAL RESISTANCE

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Cr <sub>2</sub> O <sub>3</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
STEEL-PAK 86CR	75.5	11.9	4.2	2.92 / 182.0	1760°C (3200°F)
STEEL-PAK 90CR	73.1	12.3	7.3	2.93 / 183.0	1760°C (3200°F)
RAM MAX® 85 10CR P	82.6	3.7	10.2	3.17 / 198.0	1815°C (3300°F)

## AIR SET PLASTICS

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
RAM MAX® 45 AS	42.2	52.7	2.24 / 146.0	1650°C (3000°F)
RAM MAX® 60 AS	57.0	38.0	2.56 / 160.0	1650°C (3000°F)
RAM MAX® 65 AS	62.5	32.8	2.79 / 174.0	1815°C (3300°F)
RAM MAX® 80 AS	78.0	16.4	2.72 / 170.0	1760°C (3200°F)
RAM MAX® 90 AS	91.8	7.2	2.79 / 174.0	1815°C (3300°F)

## VIBRATABLE PLASTICS - PHOS BONDED

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
VIB-RAM 55P	50.5	42.4	2.18 / 140.0	1650°C (3000°F)
VIB-RAM 60P	57.5	35.6	2.31 / 150.0	1705°C (3100°F)
VIB-RAM 65P	64.4	28.9	2.37 / 155.0	1705°C (3100°F)
VIB-RAM 70P	67.7	26.5	2.71 / 169.0	1760°C (3200°F)
VIB-RAM 70-PCR	68.9	20.5	2.37 / 155.0	1760°C (3200°F)
VIB-RAM 80P	77.4	15.2	2.37 / 155.0	1705°C (3100°F)
VIB-RAM 85P	88.0	4.7	3.16 / 197.0	1760°C (3200°F)
VIB-RAM 88P	88.0	4.7	3.16 / 197.0	1815°C (3300°F)
VIB-RAM 90P	93.7	3.0	2.72 / 175.0	1870°C (3400°F)



**PLASTER CONSISTENCY**

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
RAM MAX® 60 P SEAL	56.4	36.7	2.39 / 149.0	1705°C (3100°F)
RAM MAX® 65 P SEAL	68.1	26.4	2.69 / 168.0	1650°C (3000°F)
RAM MAX® 70 P SEAL	71.5	21.7	2.24 / 140.0	1760°C (3200°F)
RAM MAX® 75 P SEAL	80.9	11.9	2.80 / 175.0	1760°C (3200°F)
RAM MAX® 80 P SEAL	81.7	11.6	2.36 / 147.0	1760°C (3200°F)
RAM MAX® 85 P SEAL	82.4	11.2	2.80 / 175.0	1760°C (3200°F)
RAM MAX® 90 P SEAL	89.8	6.4	3.04 / 190.0	1705°C (3100°F)
RAM MAX® 91 P SEAL	90.5	5.8	2.85 / 178.0	1815°C (3300°F)

**PUTTY CONSISTENCY**

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
RAM MAX® 60 P PC	56.1	37.0	2.39 / 149.0	1705°C (3100°F)
RAM MAX® 70 P PC	72.8	19.7	2.60 / 164.0	1760°C (3200°F)
RAM MAX® 85 P PC	81.4	11.2	2.82 / 180.0	1760°C (3200°F)
RAM MAX® 90 P PC EXT	92.2	3.6	3.00 / 190.0	1870°C (3400°F)

**TROWELABLE CONSISTENCY**

Product	Al <sub>2</sub> O <sub>3</sub> %	SiO <sub>2</sub> %	Density (g/cm <sup>3</sup> / lb/ft <sup>3</sup> )	Temperature Limit
RAM MAX® 70 P TR	67.8	26.6	2.69 / 168.0	1650°C (3000°F)
RAM MAX® 80 P TR	81.5	10.6	2.72 / 180.0	1760°C (3200°F)
RAM MAX® 90 P TR	87.2	7.7	2.96 / 185.0	1870°C (3400°F)
RAM MAX® 90 5CR P TR	88.1	5.1	3.20 / 200.0	1870°C (3400°F)

