



Machinable Media

Mix It. Cast It. Machine It.

Rayite™ 100 Machinable Media is a high performance mineral-based material developed for prototyping, mold-making, tape proofing, models and tooling aids. Ideal for use with all machining processes, this super-tough material machines smooth and produces outstanding edge definition. Finish machined parts feature sharp, precise cuts with minimal loading on milling machines and cutting tools.

Rayite 100 Machinable Media simplifies preparation time of prototypes and models by eliminating labor-intensive gluing and clamping of board-type machinable products. Just mix it, cast it and machine it.

Volume and Mix Calculations

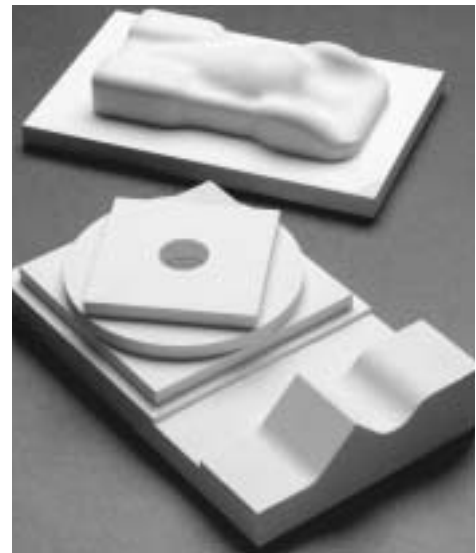
This information is useful in calculating the amount of Machinable Media to be used in a mold of known dimensions.

Simply fill in the missing information and calculate where instructed. This format provides both the amount of water and the amount of Machinable Media powder required.

- Step 1: Calculate volume of mold, V:
 If volume is calculated in in.³, convert in.³ to ft.³ $V \div 1728 =$ _____
 If volume is calculated in ft.³, proceed to Step 2 $V =$ _____
- Step 2: Calculate slurry requirement of mold, SW: $V \times 109 =$ _____
- Step 3: Calculate powder weight, PW: $SW \div 1.3 =$ _____
- Step 4: Calculate water weight, WW: $PW \times 0.3 =$ _____

Example: *Mold measured 18" long x 12" wide x 6" deep.*

- Step 1: Mold volume, $V = (18" \times 12" \times 6") = 1296 \text{ in.}^3$
 $1296 \text{ in.}^3 \div 1728 \text{ in.}^3/\text{ft.}^3 = 0.75 \text{ ft.}^3$
- Step 2: Slurry weight, $SW = V \times 109 = .75 \times 109 = 81.75$ pounds of slurry
- Step 3: Powder weight, $PW = SW \div 1.3 = 81.75 \div 1.3 = 62.88$ pounds powder
- Step 4: Water weight, $WW = PW \times 0.3 = 62.88 \times 0.3 = 18.87$ pounds water



Machined pieces of Rayite 100 media show outstanding edge definition.



Rayite 100 media being machined on CNC-type milling equipment.