



How-To:

Injection Wax Trouble Shooting Guide

Problem	Remedies
Wax Pattern Sticky-Pattern Distortion	<ul style="list-style-type: none"> • Reduce Wax Temperature • Increase Pattern Dwell Time
Pattern Flashing/Fins Mild Overfills	<ul style="list-style-type: none"> • Reduce Wax Temperature • Clean Mold Vents, Increase Size & Quantity of Vents • Reduce Air Pressure • Hold Mold Firmly/Keep Locks Aligned • Allow Mold to Cool
Excessive Pattern Shrinkage	<ul style="list-style-type: none"> • Reduce Wax Temperature • Use a Low Shrink/Low Sink Wax • Use Warmer Mold • Increase Pattern Dwell Time • Increase Air Pressure • Increase Sprue Size
Sink Area on Large or Heavy Patterns	<ul style="list-style-type: none"> • Reduce Wax Temperature • Use a Low Shrink/Low Sink Wax • Increase Pattern Dwell Time • Increase Air Pressure • Increase Sprue Size
Air Bubbles in Pattern	<ul style="list-style-type: none"> • Reduce Wax Temperature • Increase Wax Temperature • Reduce Air Pressure • Make Sure Wax Pot is Full • Minimize Trapped Air in Wax • Fit Mold Properly & Securely Onto Injection Nozzle
No Mold Fill or Partial Mold Fill	<ul style="list-style-type: none"> • Increase Wax Temperature • Use Warmer Mold • Clean Mold Vents, Increase Size & Quantity of Vents • Increase Air Pressure • Increase Sprue Size • Reduce Mold Release Spray/Do Not Use Talc • Use More Fluid Wax to Fill Thin Sections • Make Sure Injection Nozzle is Not Clogged • Do Not Hold Mold too Tightly
Ripples on Pattern Surface	<ul style="list-style-type: none"> • Increase Wax Temperature • Use Warmer Mold
Cracking/Brittle Wax Patterns	<ul style="list-style-type: none"> • Use a More Flexible/Ductile Wax • Reduce Pattern Dwell Time
Roughness on Pattern Surface	<ul style="list-style-type: none"> • Use a Smoother, More Polished Master • Reduce Mold Release Spray/Do Not Use Talc