

Technique Tips from **Kerr**

Wax Molds

CONDITION	CAUSE	CORRECTION
Mold Overfills	Air pressure too high Wax too hot Plates held with uneven pressure/ not covering mold Mold held too long at nozzle	Reduce air pressure Adjust temperature Hold plates firmly, distributing pressure evenly over entire mold surface Hold for less time
Mold Not Filling	Air pressure too low Wax not hot enough Nozzle plugged Mold held too tightly Uneven pressure caused by dirty plates Air trapped in mold Mold too cold	Adjust air pressure Adjust temperature Remove and clean Hold without squeezing Clean plates so surfaces are flat Make air release cuts (vents) in mold Be sure wax pot is more than half full Warm mold
Air Bubbles in Pattern	Air pressure too high Wax pot low on wax Wax too hot or too cold Mold held at wrong angle to nozzle	Adjust air pressure Add wax. Be sure wax pot is more than half full Adjust temperature and stir wax to release trapped air Hold mold on same plane as nozzle
Wax Brittle	Wax too hot Wax has been reused Molds cooling too long before opening Using inferior wax	Adjust temperature Use new wax. Use no less than 30% new wax with reused. Try avoiding old wax Inject fewer molds during production cycle Use a Kerr injection wax
Wax discolored (brownish)	Wax too hot	Clean wax pot; add new wax
Patterns bend easily, wax sticks to mold	Wax too hot Opening mold too soon or mold too hot	Adjust temperature Prolong cooling period by working more molds
Wax keeps flowing after mold is removed	Dirt inside the nozzle	Remove and clean nozzle

*CLEANING: Use steam, or soak in Para Chloro Ethylene or **Kerr Solitine**.

(OVER)

Kerr

Kerr Division of Sybron Corporation/28200 Wick Road/P.O. Box 455/Romulus, MI 48174

SYBRON