

Injection Wax Troubleshooting Guide

Problem	Solution
Wax Pattern Sticky-Pattern Distortion	<ul style="list-style-type: none"> • Reduce wax temperatures • Increase pattern dwell time
Pattern Flashing or 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 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 Patten	<ul style="list-style-type: none"> • Reduce wax temperature • Increase wax temperature • Reduce air pressure • Make sure wax pot is full • Minimze 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 spure size • Reduce mold release spray/do not use talc • Use a more fluid was to fill thin sections • Make sure injection nozzle is not clogged • Do not hold mold too tightly
Ripple on Pattern Surfaces	<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