



PROBLEM SOLVING: Water Marks

causes:

1. Not using all the work time
2. Too much water



Water marks are irregular traces on the surface of the casting which runs vertically from top to bottom (viewed from how the flask is filled with investment). Water marks are generally more pronounced on flat items.

Not using all the work time

Solution - See manufactures instructions. If the work time is not fully used then particle segregation will occur, leaving a water rich investment which will be attracted to the surface of the waxes. This results in erosion. As a general guide the time between final vacuum and the gloss off should be 2.5 to 3 minutes

Too much water

Solution - Follow recommended **powder water ratio**