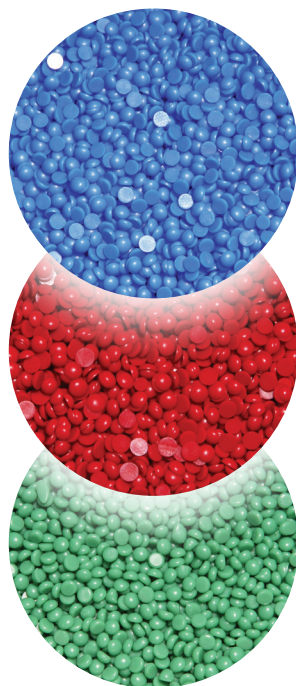


GRS PREMIUM INJECTION WAXES

R866



GRS Injection Waxes are manufactured in Stoke-on-Trent, England, using high quality raw materials to produce a consistent high performance product.

R866 wax is a Premium Grade injection wax, developed with high flexibility, easy flow and low hardness. R866 wax will hold sharp details and is an ideal wax for most wax patterns produced in the modern wax room. R866 is predominantly available in Blue, but is - also available in Red and Green up on request

<i>Viscosity (cPs)</i>	200
<i>Hardness at 35 °C / N</i>	130
<i>Flexibility at 35 °C / N</i>	270
<i>Solidification point</i>	65
<i>Linear shrinkage</i>	Less than 1%
<i>Injection temperature</i>	70-72 °C



INJECTION WAX TROUBLE SHOOTING

SHRINKAGE TOO HIGH

Wax too hot, sprue too narrow, injection pressure too low.

WAX DOES NOT FILL

Wax too cold, pressure too low, sprue too narrow.

MOULD OVERFLOW / FILL

Wax too hot.
Too much pressure.
Mould not clamped well enough during injection.

Poor cut mould.

Injection dwell time too long.
Lack of vents within the mould.

ROUGH WAX PATTERNS

Excess talc or release agent on the moulds.

DISTORTED WAX PATTERNS

Poor master pieces.
Caused by cleaning flash off with a knife.
Opening mould too soon.

AIR BUBBLES

Wax temperature incorrect (too hot/cold).
Not enough wax in the pot.
Too much injection pressure or pressure too low.
Moisture in the wax or airlines.

INCOMPLETE WAX PATTERNS

Wax temperature too low.
Injection pressure too low.
Overheating of the wax.
Low wax level in the wax pot.

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