

GRS PREMIUM INJECTION WAXES



GRS Premium® speciality injection waxes are manufactured in Stoke-on-Trent, England using high quality raw materials to produce a consistent high performance product.

Within the GRS Premium® range you will find a wax with the optimum flow, solidification point, hardness, flexibility, memory and shrinkage to meet all of your requirements.

Choose from the range below to determine which of these top quality waxes best suits your needs



Finest Filigree - R36WF



Injection Temp: 68°C / 155°F

Finest Filigree is specifically designed for injecting detailed patterns and providing a wax that is flexible and strong enough to enable removal from the mould without damage. Finest filigree is also recommended for stone in place setting.

Flexi Blue - R34WF



Injection Temp: 68°C / 155°F

Flexi Blue is the most flexible wax in the GRS Premium® range. This wax has high plasticity giving the wax exceptional memory and durability. Flexi Blue is a very durable wax widely used for stone in place and will withstand rough handling and removal from very complex moulds.

Sturdy Green - R35WF



Injection Temp: 72°C / 160°F

Sturdy Green is the hardest and most durable wax in the range. This wax is perfect for use in metal moulds or where the patterns have sharp detail or where a high degree of accuracy is needed. It has a high flexibility and low shrinkage and is therefore easy to remove and easy to read.

General Purpose - R37WF



Injection Temp: 65°C / 150°F

General Purpose wax is a formulation which is suitable for most jewellery designs. This product has a balanced set of characteristics for the most demanding wax applications, with good flow, low shrinkage and easy to read. This wax is available in aqua, burgundy and turquoise.

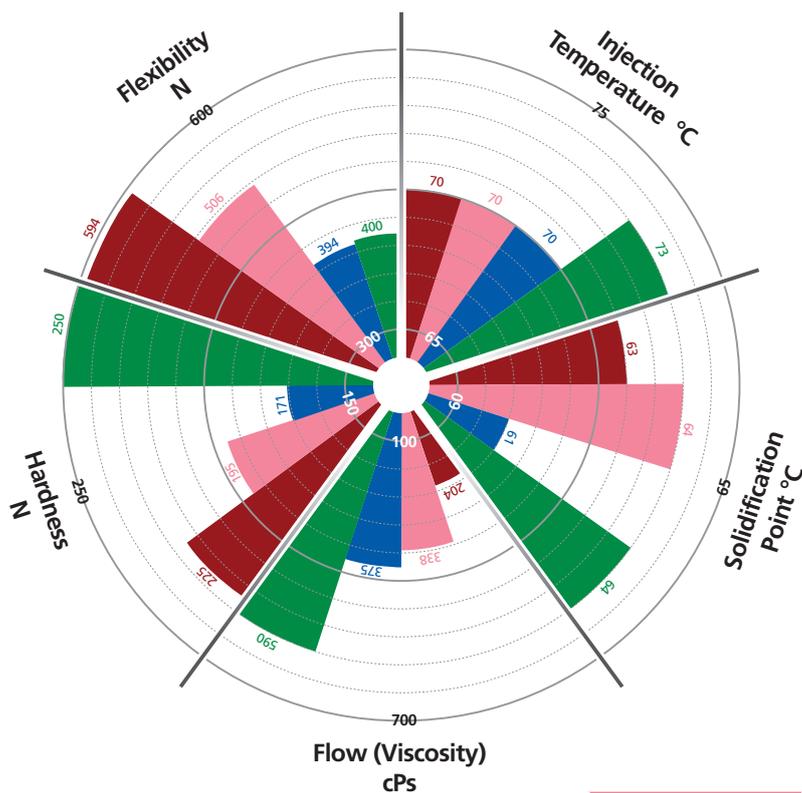
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WAX TECHNICAL DATA



	R36WF	R34WF	R35WF	R37WF
Flow (cPs)	338	375	590	204
Hardness (N)	195	171	250	225
Flexibility (N)	506	394	400	594
Solidification Point (°C)	64	61	64	63
Linear Shrinkage (%)	2.0	1.7	1.7	2.1
Injection Temp (°C)	70	70	73	70

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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