

GRS PREMIUM INJECTION WAXES

R863 PINK



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

R863 Pink wax is a Premium Grade injection wax, specifically designed for injecting detailed patterns and providing a wax that is flexible and strong enough to enable removal from the mould without damage. R863 is a good general purpose wax with high flexibility, low shrinkage and gives an extremely smooth surface finish.

<i>Viscosity (cPs)</i>	210
<i>Hardness at 35 °C / N</i>	130
<i>Flexibility at 35 °C / N</i>	270
<i>Solidification point</i>	66
<i>Linear shrinkage</i>	Less than 1%
<i>Injection temperature</i>	71-73 °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.

GOODWIN REFRACTORY SERVICES LTD

Spencroft Road, Newcastle-under-Lyme, England ST5 9JE

T: +44 (0)1782 663600 F: +44 (0)1782 663611 E: info@grs-products.com

WWW.GRSCASTINGPOWDERS.COM