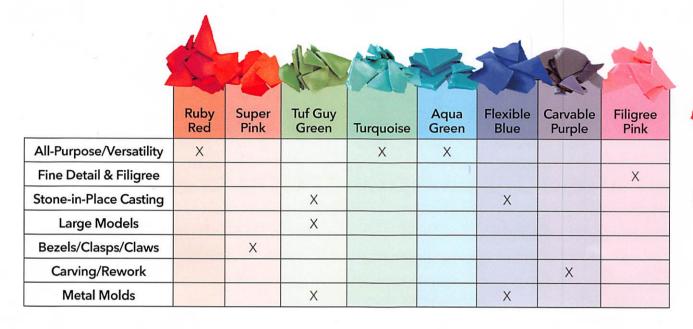
## APPLICATION GUIDE

The following application recommendations are only suggestions and your specific project should be taken into consideration when selecting a wax. Contact our technical staff with questions about your project at (800) 321-8511 option 5.



# TROUBLESHOOTING GUIDE

Review the following common problems with wax projects for possible solutions. As always, we have technical staff on hand ready to support you in any application at (800) 321-8511 option 5.

| Air Bubbles in Pattern        |                        |  |
|-------------------------------|------------------------|--|
| Probable Cause                | Corrective Action      |  |
| Wax pot is not<br>full enough | Add wax to pot         |  |
| Air pressure is too high      | Reduce air pressure    |  |
| Wax is too hot                | Reduce wax temperature |  |

| FLOW LINES              |                          |  |
|-------------------------|--------------------------|--|
| Probable Cause          | Corrective Action        |  |
| Air pressure is too low | Increase air pressure    |  |
| Wax is too cold         | Increase wax temperature |  |

| Incomplete Castings     |                          |
|-------------------------|--------------------------|
| Probable Cause          | Corrective Action        |
| Air pressure is too low | Increase air pressure    |
| Wax is too cold         | Increase wax temperature |
| Nozzle is clogged       | Clean nozzle             |

| FLASHING/FINS                 |   |  |
|-------------------------------|---|--|
| Probable Cause                | Corrective Action                         |  |
| Air pressure is too high      | Reduce air pressure                       |  |
| Wax is too hot                | Reduce wax temperature                    |  |
| Mold plates are held unevenly | Evenly distribute pressure on mold plates |  |

| Brittle Wax Patterns       |                        |
|----------------------------|------------------------|
| Probable Cause             | Corrective Action      |
| Wax is remelted and reused | Use virgin wax         |
| Wax is too hot             | Reduce wax temperature |

# FREEMAN FLAKE WAX

## **Product & Application Guide**

### **AQUA GREEN**

General Purpose Ash Content: 0.009% Inject at: 160 °F

#### **TUF GUY GREEN**

Toughest wax, yet accurate Durable, yet flexible; ideal for large pieces Ash Content: 0.004% Inject at: 170 °F

#### SUPER PINK

Quickest solidification Ideal for clasps, claws & bezel settings Ash Content: 0.034% Inject at: 160-165 °F

#### FLEXIBLE BLUE

**TURQUOISE** 

General Purpose

Ash Content: 0.009%

Inject at: 160 °F

Longest shelf-life & highest flexibility Well-suited for metal molds & stone-in-place casting Ash Content: 0.007% Inject at: 170-175 °F

#### CARVABLE PURPLE

Developed for reworking patterns Superior carvability with minimal filling or clogging of tools Ash Content: 0.005% Inject at: 170-175 °F

#### FILIGREE PINK

Combines flexibility with excellent flow & fine detail reproduction High detail & easy pattern removal

Ash Content: 0.003% Inject at: 160-165 °F

## **RUBY RED**

General Purpose Ash Content: 0.009% Inject at: 160 °F

