

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.

	Ruby Red	Super Pink	Tuf Guy Green	Turquoise	Aqua Green	Flexible Blue	Carvable Purple	Filigree Pink
All-Purpose/Versatility	X			X	X			
Fine Detail & Filigree								X
Stone-in-Place Casting			X			X		
Large Models			X					
Bezels/Clasps/Claws		X						
Carving/Rework							X	
Metal Molds			X			X		

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 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

TURQUOISE

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

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

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 dlogging 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



Freeman Manufacturing & Supply Co.
1101 Moore Road Avon, OH 44011
(800) 321-8511 www.FreemanWax.com

Additional Information ►►