

R&R[®] AquaSphere[™]

jewelry injection wax

Tested in production environments, R&R AquaSphere jewelry injection wax's unique formulation provides casters with:

Versatility

R&R AquaSphere wax works well on fine filigree and thick, heavy pieces - minimizing the number of waxes needed in your operation.

Dependability

R&R AquaSphere wax is easy to remove from the mold, has low shrink in thick areas & cross-sections and a superior memory for shape - resulting in consistent pattern reproduction.

Production Efficiency

R&R AquaSphere wax is very fluid, excellent for difficult angles or draws, resulting in reduced occurrence of air bubbles and scrapped patterns.

R&R AquaSphere wax's low ash content results in clean burnout.

Pattern Excellence

R&R AquaSphere wax produces patterns with above average surface smoothness, resulting in extra smooth casting surfaces & superior reproduction of fine detail.

Packaged in 50 pound cartons.

Standard color is aqua for easy inspection.

Special colors are available upon request - minimum order quantities apply.



R&R
DENSPLY

Ransom & Randolph

3535 Briarfield Blvd.
Maumee, OH 43537 USA
USA Phone: (800)800-7496
Phone: (419)865-9497
FAX: (419)865-9997
www.ransom-randolph.com

R&R[®] AquaSphere[™] jewelry injection wax

Specifications

<u>TEST</u>	<u>RESULTS</u>
Ring & Ball Softening Point (ICI 3.0) (4°F/minute)	156 +/- 6°F
Specific Gravity (ICI 7.0)	0.960
Ash Content (ICI 1.0)	< 0.015%
Flow Test (ICI 2.0)	>50% @ 54°C
Viscosity @170°F	CPS 226 RPM 100
Brookfield Thermosel @160°F	275 100
Spindle #21 @150°F	326 100
Injection Temperature	68-71°C (155-160°F)
Injection Pressure Required	0.14 - 0.70 kg/cm ² (2-10 psi)



R&R
DENSPLY

Ransom & Randolph

3535 Briarfield Blvd.
Maumee, OH 43537 USA
USA Phone: (800)800-7496
Phone: (419)865-9497
FAX: (419)865-9997
www.ransom-randolph.com

R&R[®] AquaSphere[™]

jewelry injection wax

Instructions

Preparing the Wax Pot

Begin with a clean wax pot. Fill the pot with AquaSphere wax beads and set temperature for 93°C (200°F).

NOTE: For accurate temperature measurement and equipment calibration, use a submersible thermometer to check wax temperature.

Allow the wax to melt completely, adding wax as needed to fill the pot to at least 80% of its total capacity. Once wax is completely fluid and pot is sufficiently full, gently stir the wax to release any air bubbles.

Reduce pot's temperature setting to desired injection temperature (68-71°C or 155-60°F) before securing the lid and pressurizing the pot.

NOTE: For best results, fill pot in the evening to allow ample time for wax temperature to stabilize.

Wax Injection

To obtain optimum pattern quality from your wax, increase or decrease temperature one degree at a time. With each change in temperature, allow 30- 60 minutes for the pot temperature to stabilize.

Injection pressure typically ranges from 2-10 psi. Use the lowest pressure setting possible that allows for a complete fill and smooth pattern surface.

Shutting Down the Wax Pot

When finished using the injection pot, release the pressure, fill the pot with fresh wax and leave the pot on. Raising and lowering the temperature is time consuming and can deplete the properties of the wax.



R&R
DENSPLY

Ransom & Randolph

3535 Briarfield Blvd.
Maumee, OH 43537 USA
USA Phone: (800)800-7496
Phone: (419)865-9497
FAX: (419)865-9997
www.ransom-randolph.com