

# JEWELRY INJECTION WAX TROUBLESHOOTING

## TECH TIPS



R&R recommends utilizing the following problems and remedies to guide you through any difficulties you may encounter with your jewelry injection waxes.

This information is intended to help you troubleshoot these problems. Should your issue persist, please contact our technical team at [Technical@ransom-randolph.com](mailto:Technical@ransom-randolph.com) for additional assistance.

### Parts Not Filled

#### Remedies:

- Increase wax temperature
- Increase injection air pressure
- Increase sprue size
- Reduce clamping pressure
- Use a lower viscosity wax
- Clean injection nozzle
- Increase/clean mold vents
- Reduce amount of release spray/Talc

### Poor Wax Surface

#### Remedies:

- Reduce amount of release spray/Talc

### Air Bubbles in Wax

#### Remedies:

- Reduce wax temperature
- Increase wax temperature
- Reduce injection air pressure
- Ensure wax is properly conditioned
- Ensure wax pot is full
- Ensure no moisture in air lines
- Ensure clamp pressure is even

### Flashing-Overfilled Molds

#### Remedies:

- Reduce wax temperature
- Reduce injection air pressure
- Ensure clamp pressure is even

### Shrinkage

#### Remedies:

- Reduce wax temperature
- Reduce injection air pressure
- Increase sprue size
- Use a low shrink wax
- Increase dwell time

### Cavitation/Sink Areas

#### Remedies:

- Reduce wax temperature
- Increase injection air pressure
- Increase sprue size
- Use a low shrink wax
- Increase dwell time

### Brittle/Cracked Wax

#### Remedies:

- Use a more ductile/flexible wax

### Rough Wax Surface

#### Remedies:

- Reduce amount of release spray/Talc

### Wax Breaks While Removing from Mold

#### Remedies:

- Reduce wax temperature
- Increase dwell time



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