

SuperCera Jewelry Injection Wax

Instructional Datasheet

Superior quality waxes for a full range of applications in a unique new form that provides extra convenience with easy identification.

Made from 100% natural ingredients and filtered three times to assure problem-free use. Will not clog injector nozzle.

- Safe -- non toxic -- Non hazardous.
- 100% complete burnout -- 0% ash.
- Built in release agents mean easy removal from molds.

A complete range of waxes for every need:

Aqua	Extremely flexible. Excellent for intricate filigree and difficult pieces. Inject at 165°F/74°C.
Orange	Very flexible and easy flowing with excellent memory and minimal sink. Good all purpose wax; also recommended for pieces with thin areas. Inject at 155°F/68°C.
Red	An all purpose wax; for a wide variety of pieces. Cools quickly. Medium flexibility. Inject at 165°F/74°C.
Gold	Hard with very little flexibility. Flows easily. Will hold sharp detail. Almost no shrinkage or sink. Can be carved. Recommended for large patterns with fine detail. Also good for metal molds. Inject at 170°F/76°C.
Green	Flexible with a slow cooling time. Minimal shrinkage. Very little sink. Excellent for large flat pieces or as a general purpose wax. Inject at 150°F/65°C.

Available in 50-lb. (22.7 kg) cartons. Also available: 5 lb. (2.27 kg) convenience packages. Shipped in a carton containing 10 5-lb. boxes. Total net weight 50 lbs. (22.7 kg).

Choosing the right Castaldo SuperCera Jewelry Injection Wax

	Flexibility	Fill	Minimal Shrinkage	Minimal Sink	Use For: Large Flat Pieces	Use For: Intricate Thin or Difficult Pieces	Use For: All Purpose	Can Be Carved
Aqua	xxx	xxx				xxx		
Orange	xx	xx	x			xx	x	
Red		x	xx	x	x		xx	x
Gold			xxx	xxx	xxx	x		xx
Green	x	xx	xxx	xx	xxx	xx	x	x

Wax Injection Problems and Solutions

Air Bubbles In Pattern

Not enough wax in pot	Refill pot
Wax too hot or too cold	Adjust wax temperature
Poor contact between mold and injection nozzle	Hold mold properly
Too much air pressure	Reduce air pressure

Mold does not fill

Air pressure too low	Increase air pressure
Wax too cold	Increase wax temperature*
Cold mold	Warm up mold by repeated use

Sprue too narrow	Widen sprue
Insufficient mold venting (Air trapped in mold)	Improve mold vents
Mold vents sealed, dirty or clogged with wax	Clean mold vents and keep mold vents open with powder
Injector clogged	Clean injector and injector nozzle

Mold over-fills

Air pressure high	Reduce air pressure
Mold not closed properly	Hold mold with even pressure Recut mold with improved mold locks
Wax too hot	Adjust wax temperature*
Injection time too long	Reduce injection time

Wax sticky, bends easily

Mold open too soon	Lengthen mold holding time
Wax too hot	Reduce wax temperature*

Excessive shrinkage

Wax temperature too high	Reduce wax temperature*
Air pressure too low	Increase air pressure
Mold holding time too short	Lengthen mold holding time
Sprue too narrow	Widen sprue
Cold mold	Warm mold through repeated use
Low shrinkage wax not selected	Choose low shrinkage

NOTE: Each mold and each wax is different in its pressure, temperature and mold holding time requirements. The correct combination of factors can be achieved only through experience with each mold and each wax. For easy future reference these factors should be noted on the mold itself.

In addition, a mold's characteristics change as hot wax is repeatedly injected into it. The correct combination of factors for a cold mold may not be the correct combination of factors for the same mold after it has become warm through repeated use. The cooling time between injections - too much or too little - is thus also a factor.

For best results select the right Castaldo SuperCera wax for the requirements of the mold and to meet production needs. (See wax selection chart).

CAUTION: Molten injection waxes are **FLAMMABLE** at temperatures in excess of 350°F/177°C.

CAUTION: Hot injection waxes can cause skin burns. Avoid contact with skin. Adequate eye protection and protective clothing is strongly recommended.

All Castaldo SuperCera waxes are non-hazardous, non-toxic and non-carcinogenic.

All Castaldo SuperCera waxes are intended for professional use and only by persons familiar with jewelry casting techniques.

We are not responsible for misuse of our products or their use in conjunction with unsafe or improperly maintained equipment.

IMPORTANT NOTICE: CASTALDO® SuperCera® Jewelry Injection Waxes are warranted to be free from defects in material and workmanship. THE FOREGOING WARRANTY'S IN LIEU OF AND EXCLUDES ALL OTHER WARRANTY'S NOT EXPRESSLY SET FORTH HEREIN, WHETHER EXPRESSED OR IMPLIED BY OPERATION OF LAW OR OTHERWISE, INCLUDING BUT NOT LIMITED TO ANY IMPLIED WARRANTY'S OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. The seller shall not be liable for incidental or consequential losses, damages or expenses, directly or indirectly arising from the sale, handling or use of the goods, or from any other cause relating thereto, and Seller's liability hereunder in any case is expressly limited to the replacement (in the form originally shipped) of goods not complying with this agreement or at Seller's election, to the repayment of, or crediting Buyer with, an amount equal to the purchase price of such goods, whether such claims are for breach of warranty or negligence. Any claim by Buyer with reference to the goods sold hereunder for any cause shall be deemed waived by the buyer unless submitted to Seller in writing within (30) days from the date Buyer discovered, or should have discovered, any claimed breach.