



Injection Wax Trouble Shooting Guide.

Problem:	Remedy:	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	—	
		Reduce wax temperature	Increase wax temperature	Increase injection air pressure	Reduce injection air pressure	Increase sprue size	Reduce clamping pressure	Ensure wax is properly conditioned	Ensure wax pot is full	Ensure no moisture in air lines	Use a lower viscosity wax	Use a more ductile/flexible wax	Use a low shrink wax	Clean injection nozzle	Ensure clamp pressure is even	increase/clean mould vents	Increase dwell time	Reduce amount of release spray/Talc
Parts not filled		X	X		X	X					X			X		X		X
Poor wax surface																		X
Air bubbles in wax	X	X		X				X	X	X					X			
Flashing-overfilled molds	X			X										X				
Shrinkage	X			X	X								X				X	
Cavitation/sink areas	X		X		X								X				X	
Brittle/cracked wax												X						
Rough wax surface																		X
Wax breaks while removing from mold	X																X	

The information in the above table is intended to help guide you through any problems you may encounter, should your problem persist please contact our technical team on +1 330 342 0407 or email info@precizioned.com for help.