



## The Six Basic Steps In Lost Wax Casting Are:

### 1. Make the Pattern

Wax patterns can be carved, formed on a mandrel, shaped out of wax wires or waxes can be injected from moulds made previously.

### 2. Sprue & Mount the Wax

Sprues are attached to the wax pattern to form feed lines for the molten metal.

### 3. Invest the Wax

Investment powder is mixed with water to form a mould around the pattern. A vibrator or a vacuum unit helps to remove bubbles from the investment.

### 4. Burn Out the Pattern

The invested flask is placed in a preheated furnace. The wax is burned out to create the mould in preparation for

### 5. Cast

a. Metal is melted in the casting crucible of the centrifugal casting machine. With the burned out flask in place, the casting machine arm can be released when the metal is ready to cast.

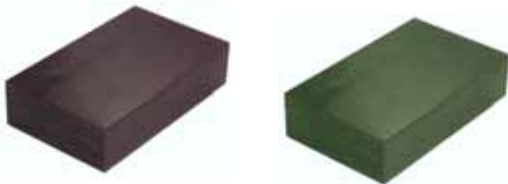
b. Metal is melted in an electric metal melting furnace. With the burned out perforated flask placed in the vacuum chamber casting unit, the molten metal is cast by being poured into the flask.

### 6. Finish & Polish the Casting

Polishing the casting is the final step in completing a piece of jewelry. Files, burs and polishing lathe may be used.

## Master Pattern Wax Blocks

### Ferris File-a-wax



**Solid** - 454gram (1 lb) blocks 35 x 89 x 146mm  
 Purple (Medium) Ref: 41-414-101  
 Green (Hard) Ref: 41-414-100



**Solid** - 227gram (½ lb) blocks 35 x 89 x 89mm  
 Purple (Medium) Ref: 41-414-201  
 Green (Hard) Ref: 41-414-200

**Sliced** - 454gram (1 lb) and 227gram (½ lb) packs  
 38mm wide x 92mm deep in assorted thickness from 2.4mm to 6mm are available by special order if required.

## Master Pattern Wax Blocks

### Matt Wax



**Solid** 454gram (1 lb) blocks 37 x 79 x 165mm  
 Blue (Flexible) Ref: 41-414-002  
 Purple (Medium) Ref: 41-414-001  
 Green (Hard) Ref: 41-414-000

**Sliced** 454gram (1 lb) 37mm wide x 79mm deep  
 Assorted thickness from 3.2mm to 25mm  
 Blue (Flexible) Ref: 41-415-002  
 Purple (Medium) Ref: 41-415-001  
 Green (Hard) Ref: 41-415-000

**Sliced** 225gram (½ lb) 75mm wide, 37mm deep.  
 Assorted slices from 3.2mm to 25mm  
 Purple (Medium) Ref: 41-415-501  
 Green (Hard) Ref: 41-415-500

Approximate Matt Wax Melting Temperatures

Blue (Flexible)	93°C	Matt Blue Flexible
Purple (Medium)	105°C	3mm slices can be bent
Green (Hard)	110°C	to 90° without cracking

## Master Pattern Wax Bracelet Blanks

Ref: 41-409-002



Medium (Purple) Master Pattern Carving Wax shaped for easy design of bracelets. Block Size 167mm x 82mm x 43mm high (18mm thick) Weight 335g

## Laboratory Solitine

Ref: 41-160-000



Solitine is a wax solvent and excellent cleaner for removing sticky substances. Dampening a cloth with Solitine and lightly rubbing the surface of a wax pattern produces a smooth, highly polished pattern surface. Smooth polished patterns help produce smoother surfaced castings. Supplied in: 8oz/250mL bottle.

Set 12 10-901-000  
Set 5 10-900-000



## Wax Carving Tools

Ref: 10-906-000



Ref: 10-910-000



Ref: 10-912-000



Ref: 10-914-000



Ref: 10-916-000



Double ended stainless wax carving tool, knurled middle section for comfortable handling, for use with spirit lamp.

## Facetted Alcohol/Spirit Lamp

Ref: 24-650-000

The faceted glass base allows the lamp to be set on an angle for easier access with carving tools. Adjustable height wick allows fine tuning of the flame. Use for melting waxes and setting cements or heating materials that require low temperatures.

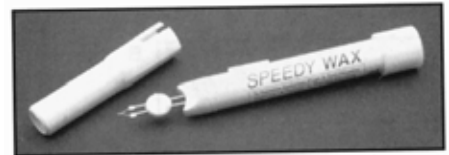


### Replacement Wick for Lamp

Ref: 24-650-001

## Speedy Wax- The Design Tool

Ref: 41-680-000



-Finger pressure control -Cordless wax tool -Instant heat  
-Convenient & portable -Battery operated -Light weight  
Speedy Wax is handy for design or everyday bench work, Microtip is designed to transfer wax to model. It forms beads and details, whisks away flares, repairs heaters and accidents. Convenient in right or left hand. Uses alkaline AA- 1.5V battery. Special cover protects tip and power switch.

### Replacement Tip

Ref: 41-680-001

## Wax Worker

Ref: 41-682-000

Used for joining high and low melting point waxes and for spruing, carving and shaping wax. This popular wax worker gives the operator precise temperature control from room temperature to 250°C. Complete with lightweight flexible handpiece and 4 tips. Dimensions: 124 x 64 x 102mm. Weight: 1Kg



### Spare Handle

Ref: 41-682-001

### Set of 4 Brass Tips

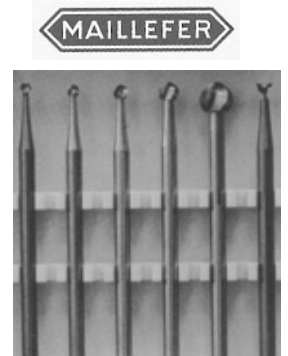
Ref: 41-682-002

NOTE: To clean the tip & burn off adhering wax just increase the heat.

## Wax Bur Set

Ref: 07-102-000

Set contains:  
4 x round burs  
1.8, 2.3, 3.1 & 5.0mm  
2 x flat twist burs  
1.2mm  
& 1.8mm These burs are designed for fast shaping and removal of wax without clogging.



## Wax File Half-Round

Ref: 10-081-000

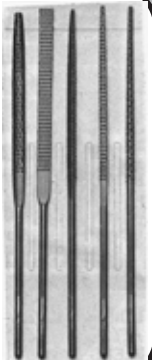


This European-made half round file is ideal for initial shaping of master pattern waxes. 200mm long with coarse cut teeth for fast shaping on one end and medium teeth for finer shaping and smoothing on the other end.

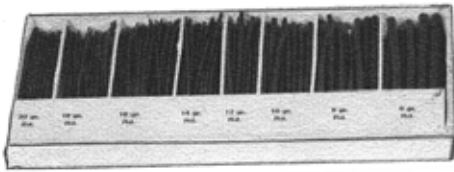
## Wax Needle Files

Ref: 10-090-000

Set of 5. Suitable for initial shaping of waxes & other soft materials Do not clog easily.



## Wax Wires



## Jewellers' Wax Wires

Wax Wires are available in round, half-round, square, rectangle, bezel, uncut bezel, triangle, 3 prong, 4 prong, and 6 prong shapes. Wax Wires are flexible but strong and may be twisted or bent to form the desired pattern. Melting Temperature 167°F/75°C.



### Special order:

Square/rectangular wax wire assortment as well as individual sizes of round and half-round wax wires can be ordered.

### Assortment #1:

#### Round/Half-round

Ref: 41-405-000 Supplied with -  
Round: 8, 10, 14 & 18 gauge  
Half-round: 6, 8, 12 & 14 gauge

### Assortment #2:

#### Bezel/Uncut Bezel

Ref: 41-407-000 Supplied with -  
Bezel: 6, 8 & 10 gauge  
Uncut Bezel 2, 4, 6, 8, & 10 gauge

Gauge	Actual Size									
	Round	Half-Round	Square	Rectangle	Bezel	Uncut Bezel	Triangle	3-prong	4-prong	6-prong
2										
4										
6	●	◐		▭	◌	▭				
8	●	◐		▭	◌	▭	▲			
10	●	◐	■	▭	◌	▭	▲			
12	●	◐	■	▭			▲			
14	●	◐	■					▲		
16	●							▲	■	
18	●							▲	■	●
20	●								■	●

## NeuSprue System from Neutec/USA



Button Sprue

NeuSprue

The NeuSprue funnel-shaped reservoir directs metal into the main sprue with a minimum of interference or turbulence, preserving heat and increases metal flow

NeuSprue's unique turbulence reducing head shape.



### NeuSprue

75mm (3") 41-441-075  
suits 100mm tall flask.  
120mm(5") 41-441-120  
suits 150mm tall flask  
175mm(7") 41-441-175  
suits 200mm tall flask



The screw on base eliminates any risk of damage to the main sprue or cracking of the investment when removing the r u b e r base.



### NeuSprue Bases

Diameter	Reference
63mm (2½")	41-381-063
76mm (3")	41-381-076
89mm (3½")	41-381-089
102mm (4")	41-381-102
127mm (5")	41-381-127



NeuSprues are 25mm shorter than the flask to allow correct spacing of patterns on the tree.



### NeuSprue Universal Tree Fixture

The NeuSprue Universal Tree Fixture is fully adjustable with tilt up and down and 360° rotation to provide the perfect working angle. Ref: 13-901-000

## Sprue Wax Rods



### 8oz Bulk Packs 4" long

Ref: 41-439-006 6 gauge  
Ref: 41-439-008 8 gauge  
Ref: 41-439-010 10 gauge

### Main Sprue Rods 600mm (24") long

41-570-000 ¼" (6mm) round  
41-572-000 ⅜" (10mm) round

## Jewellers' Sheet Waxes

### Casting Wax Sheets

Ref: 41-430-000

Smooth flexible translucent sheets supplied in a pack of assorted thickness.

Sheet size: 75mm x 137mm

Pack contains 1 x 8gauge, 1 x 12gauge, 2 x 14gauge, 2 x 18gauge, 3 x 20gauge and 3 x 22gauge sheets.

Melting temperature 77°C (170°F)



### Sculpt Wax Strips Ref: 41-443-000

900g pack with 8 strips 32mm x 6mm x 607mm.

This product has been designed for hand shaping and sculpting when warm. Melts at approximately 71°C Suitable for lost wax casting.

## Master Pattern Wax Ring Tubes

### Matt Wax - Blue (Kerr Red)

A softer wax which is easy to carve and yet is toolable.

- D - RC3 Ref: 41-422-002
- B - RO3 Ref: 41-423-002
- A - FS3 Ref: 41-425-002
- A - FS5 Ref: 41-426-002
- A - FS7 Ref: 41-427-002

### Matt Wax - Purple (Kerr Blue)

A medium-hard wax which is carvable, toolable and provides excellent pattern definition.

- RC3 Ref: 41-422-001
- RO3 Ref: 41-423-001
- FS3 Ref: 41-425-001
- FS5 Ref: 41-426-001
- FS7 Ref: 41-427-001



RC3 Purple



RO3 Green

### Matt Wax - Green (Kerr Green)

A harder wax which can be carved & offers maximum toolability.

- RC3 Ref: 41-422-000
- RO3 Ref: 41-423-000
- FS3 Ref: 41-425-000
- FS5 Ref: 41-426-000
- FS7 Ref: 41-427-000



### Sizes for all colours

- RC3 152 x 27mm diameter with 15.5mm centered hole
- RO3 152 x 27mm diameter with 15.5mm off-centre hole
- FS3 152 x 26mm x 29high with 15.5mm hole
- FS5 152 x 28.5 x 28.5mm high with 15.5mm hole
- FS7 152 x 31.75 x 31.75mm high with 15.5mm hole

**Kerr Waxes Note:** Kerr have advised they no longer sell Kerr brand Master Pattern Wax in either block, sliced block or ring tube form. Kerr now sell the MATT brand of master pattern waxes.

## Sticky Wax

Ref: 41-444-000

Sticky Wax is a hard, fast setting wax used for repairing patterns, welding two or more waxes together & joining sprues securely to the sprue base. Sticky Wax has a melting point of 136°F/58°C.

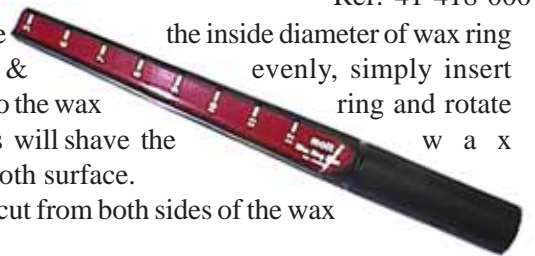
It is supplied in a 12 stick box.



## Wax Ring Tube Resizer

Ref: 41-418-000

To increase the inside diameter of wax ring tubes easily & evenly, simply insert the Resizer into the wax ring and rotate the blade. This will shave the wax leaving a smooth surface. Remember to cut from both sides of the wax ring.

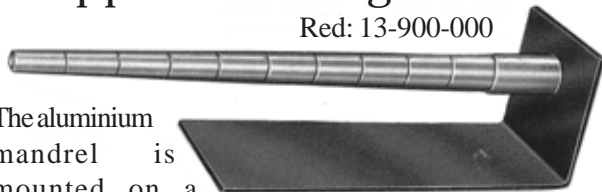


## Stepped Wax Ring Mandrel

Ref: 13-900-000

The aluminium mandrel is mounted on a

steel base with a close fitting internal rod that allows the mandrel to be smoothly and easily rotated while working on wax models. The mandrel is stepped (not tapered) with sizes from G to M in eleven steps. The mandrel can be easily removed from the stand and is especially useful when used in conjunction with the Matt-wax Gun. Coating the mandrel with lubricant before use will ensure your design is able to be removed without damage. Overall length: 330mm



## Matt Wax Reamer

Ref: 41-419-000

You can now bore the exact finger-size, with perfectly parallel, smooth sides in every wax ring blank. Not only is the Matt Wax Reamer is fast and easy to use with for rings but can also create bezels for stones and coins.



## Injection Wax Flakes

- Tuff Guy Green Ref: 41-470-000
- Turquoise Ref: 41-492-000
- Filligree Pink Ref: 41-495-000
- Flexible Blue Ref: 41-472-000
- Carvable Purple Ref: 41-491-000

Freeman Flake Wax and wax additive - see page 26 for details

## Utility Wax

Ref: 41-448-000

Sheet size: 76 x 152 x 3mm thick.

Sheet weight: 226g

Utility Wax is plastic at room temperature. It has adhesive qualities for build-up & when rubbed over a marred pattern surface, will readily fill small imperfections. Melting temperature 173°F/78°C



## Disclosing Wax

Ref: 41-446-000

Disclosing Wax is a soft, pliable wax used to repair defects & fill unwanted voids in wax patterns. This special wax has a very low melting temperature & is applied easily to the pattern with the tip of a finger or a wax carving tool. Weight 57g jar



## Matt-Wax Gun Starter Kit

Ref: 41-695-000

The Matt-Gun provides the jeweller with a new technique for modelling jewellery and mini-sculpture by the extrusion of wax-pellets. The kit contains Matt-Gun and all accessories, original designs and model making. The gun allows the operator to control individually the temperature and pressure of the extrusion process, thus creating wire shapes of constantly changing characteristics. Three different methods are used in the process - designing on objects, in the air and on water (for abstract effects). Also included is an illustrated 113 page book 'Wax Modelling for Jewellery and Sculpture' which provides full instructions on how to get the most out of your Matt-Gun.



**Replacement Box of 20 Wax Pellets** - Red 41-697-000    Blue 41-696-000    Green 41-697-100

## Jewellery Design Templates

Set of 7    Ref: 40-400-000



Set of 7 heavy gauge, plastic design templates for stone shapes; Round, Oval, Baguette, Emerald, Marquise and Pear are included along with ring shanks and setting designs.

### Heart, Baguette

Ref: 40-415-002



Heart Shape    3mm to 18mm  
Wide Heart    3mm to 18mm  
Wide Taper Baguette 1 - 15mm  
Wide Baguette 1mm to 14mm  
Taper Baguette 1mm to 13mm  
Baguette       1mm to 11mm  
Square         1mm to 8mm

### Marquise, Pear, Emerald

Ref: 40-415-001



Marquise Shape 3mm to 18mm  
Wide Marquise 3mm to 18mm  
Pear Shape       3mm to 18mm  
Emerald         4mm to 16mm

## Wax Wire Spools

Wax Wire Spools are where varying lengths of wire are required to complement pattern designs. Melting Temperature: 167°F / 75°C.

Gauge	Actual Size
3/8"	
6	
8	
10	
12	
14	



### Round Wax Wire

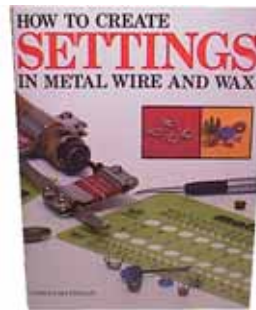
Reference	Gauge
41-412-008	8
41-412-010	10
41-412-012	12
41-412-014	14
41-412-016	16
41-412-018	18
41-412-020	20

### Half Round

41-412-000	6
41-412-001	8

## Template and Book Set

Ref: 46-040-000



**Setting Kit:** Includes two templates and Adolfo Mattiello's book "How to Create Settings in Metal Wire and Wax." The metal working section illustrates how to make settings with drawn metal wire in two styles and many shapes.

The round setting template contains over 80 setting and stone sizes. The oval, pear and marquise template contains over 75 stone and setting sizes.

## Sol-U-Carv Wax    Ref: 41-436-000

Sol-U-Carv Wax is both a carvable and soluble white wax. Designed for making hollow beads, hollow pendants, dome rings and other designs where a hollowed area in the finished pattern is desired. A core can be carved using conventional wax carving tools. Wax can be melted (170°F/77°C) and poured or injected into a prepared mould. Sol-U-Carv cores can be immersed in water and dissolved, leaving the desired pattern that was completed in non-soluble pattern wax.



450g Block    120 x 85 x 40mm

## Perfect Purple Wax Blocks



Perfect Purple Wax is a perfect build-up wax, designed to be melted at 156°F/74°C and used to build up the pattern

through successive additions. When built up, the wax can be carved easily to produce smooth pattern surfaces. Weight: 28g    Ref: 41-456-000