

# R&R® AquaSphere™ Injection Wax

## Preparing the Wax Pot

1. Begin with a clean wax pot. Fill the pot with R&R AQUASPHERE injection wax beads and set temperature for 200°F (93°C).  
**Note:** for accurate temperature measurement and equipment calibration, use a submersible thermometer to check wax temperature.
2. 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.
3. Reduce pot's temperature setting to desired injection temperature (155°F-160°F [68°C-71°C]) 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

1. To obtain optimum pattern quality from your wax, increase or decrease temperature 1 degree at a time. With each change in temperature, allow 30-60 minutes for the pot temperature to stabilize.
2. 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

1. 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.

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