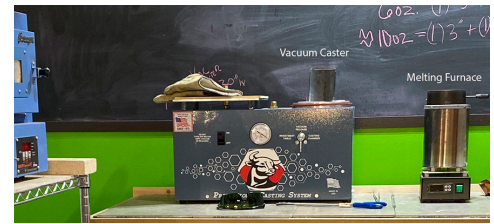
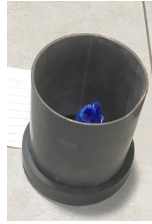
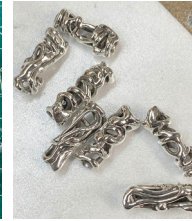


how it's made...



LOST WAX CASTING is an ancient process in which a custom designed wax is sprued and fused onto a rubber base, called a "sprue base". The waxes used are not your typical candle wax. Most have a higher melting point with the ability to hold fine detail.



The wax sprues (pink wax) are attached to the models and act as channels for the wax to flow out and the metal to flow in. A metal flask, which resembles a short length of steel pipe that ranges roughly from 1.5 to 6 inches tall and wide, is put over the sprue base and the wax model.

Investment (refractory plaster) is mixed and poured into the flask, filling it and hardens. The rubber sprue base is removed from the flask and the invested piece (still in the flask) is placed cup-down in a kiln and the wax burns out over the course of several hours. Now all that remains of the original design and sprues is the negative space inside the hardened shell.

Casting is done straight from the kiln by vacuum casting. Once the metal (sterling silver) is heated (approx. 1700°F) and poured into the flask, the vacuum pulls the metal throughout the negative space, filling the design. The metal cools and then the flask is quenched while still hot. The investment is then chiselled away, releasing the rough casting. The mold is completely broken (lost) revealing an original, one-of-a-kind piece. The sprues, which are also faithfully recreated in metal, are cut off and recycled into another casting. Rough edges are ground down, and the piece goes through the final process of polishing.

The lost-wax process can be used with any material that can burn, melt, or evaporate to leave a mold cavity.



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Designs
*one-of-a-kind,
handcrafted jewelry*