



## Ferris® 2364 Injection Wax Beads

*New and Improved!*

### Description

Freeman Manufacturing & Supply Co. is now ISO 9001:2008 certified! Ferris® 2364 was originally designed for a longer shelf life and excellent release properties. ISO 9001 guidelines, along with Freeman's tightening of raw material specifications, has allowed us to maintain these desirable properties while also lowering the recommended injection temperature and reducing pattern shrinkage! See below for updated usage guidelines.

### Physical Properties

Color	Blue, Pink, Green
Ring & Ball Softening Point (°F)	159
Injection Temperature	155-160
Flash Point (°F)	392
Hardness (Shore D)	34
Specific Gravity	0.96
Ash Content	0.003%
Viscosity (cps)	
@ 170°F	258
@ 160°F	302
@ 150°F	423

### Ordering Information

SKU	Description	Net Weight (lb.)
118220	Ferris Beads 2364 Pink	1
118221	Ferris Beads 2364 Blue	1
118222	Ferris Beads 2364 Green	1

### Troubleshooting

AIR BUBBLES IN PATTERN		FLASHING/FINS	
Probable Cause	Corrective Action	Probable Cause	Corrective Action
Wax pot is not full enough	Add wax to pot	Mold plates are held unevenly	Evenly distribute pressure on mold plates
Air pressure is too high	Reduce air pressure	Air pressure is too high	Reduce air pressure
Wax is too hot	Reduce wax temperature	Wax is too hot	Reduce wax temperature