

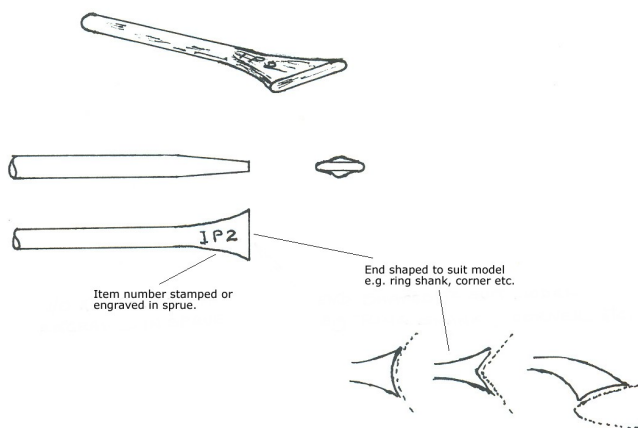
Niagara Falls Castings (UK) Ltd

A Quick Guide to Sprues

Flared Sprues

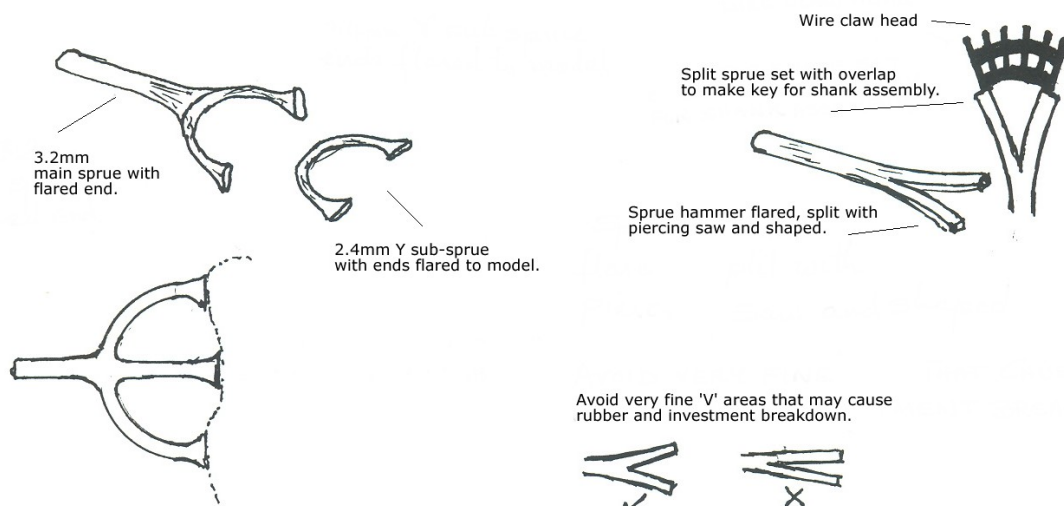
Flared sprues will help to create a better joint to a model, ensuring good wax and metal flow into a model and reducing the time spent cleaning up.

Sprues should be hammer flared NOT filed. Filing to shape reduces the cross sectional area of the sprue and reduces flow. Filing with fine files to remove hammer marks, if necessary is acceptable. The exception to hammer flaring is where a substantial sprue is required and the model is very fine.



'Y' Sprues

'Y' Sprues are useful for bridging open work or pierced areas to carry wax and metal from a substantial sprue to fine areas. 'Y' sprues can be made with any number of legs to create the required flow, sometimes creating a virtual ring around a difficult piece of work. It is important that joints in the system help the flow and do not create bottlenecks.



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Bridge Sprues

Bridge sprues are used where the surface of a band ring is fully engraved or pierced for example an open Celtic band or a full eternity ring. They are also used to bypass thin sections that might inhibit wax or metal flow.

1. Anneal and hammer flare the sprue end. Re-anneal, bend to 90° and trim flared end.



2. Solder length of flattened sprue to model, selecting area of pattern on model to give best feed of wax and metal.



3. Cut end and shape to fit other part of sprue. Underside of sprue should be 3 – 6mm above model.



4. Solder sprue across bar and item. Tip: drop solder pailon in hollow, run solder onto bent end of sprue, rest sprue across bar and model, press down gently, solder bent end first then other joint.

