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Lost wax method india

Former FUNDition PATENT YOUR MECHANICAL INVENTION, Consumer Product, Instrumentation, Biotech? Work with me to patent your inventions from anywhere in the world. See the details on: My IP Services page ALSO see MODERN CASTING TECHNIQUES BioPatent ServiceSm Intellectual Property Protection Ancient South Asian Lost Wax Casting Techniques by Gary Baker, Esq. - Patent Attorney During our trip to southern India, I had the great pleasure of visiting a family that has made traditional Hindu religious statues on their property for at least 5 generations. The shape and proportions of the statues are based on ancient Sanskrit formulas. Briefly, this lost wax process comprises: preparation of original wax figures, enclosing the figures in fine mud of river slime, drying mud, melting the wax to form a hollow mold, melting a combination of metals with a charcoal fire, pouring the molten metal to fill the mold, detailing hand tools in the raw casting , and laboriously hand-finished details on solid metal statues. I. WAX FIGURE - The artist, using the particular Sanskrit formulas of the subject god or goddess, first creates a stick figure in the intended pose from beeswax. The body parts are filled, again according to the old prohibited dimensions, by applying additional heated wax layers to the figure of the stick. Surface details are locked without a high degree of detail. II. INVERT FIGURE - The statue's original wax is sealed in a mud cocoon (from the nearby river) by careful hand packing. Two wax spruce sticks are left that extend between the wax figure and the outside of the mud casing to provide channels to receive molten metal during the subsequent pouring step. The mud cover is supported by some metal wire wrappers to reduce cracking during drying step and to strengthen the mold. The enclosed wax figure dries in the sun for 20 days. III. MELT OUT - An oven is made of a hand-operated rotary fan blowing through a ventilation tube in a burnt carbon brick-lined chamber. The oven is used to melt the wax out of the pan, bake and harden the pan, and to melt the metals to pour into the pan. The sun-dried mold is placed in the oven hole with the fir trees facing down. As the oven heats the pan, the wax figure melts and pours the remaining holes when the fir trees melt. Mold heats up for several hours until all wax residue is vaporized or burned. IV. MOLTEN METAL - The metal combination is weighed and placed together in a crucible to melt into the coal oven. statues were supposed to be poured from a combination of 5 metals of parts of equal weight gold, silver, tin, copper and zinc. Because gold is expensive, only a symbolic sprinkle is added to a combination essentially of 4 metals, a little rich in and the light on the silver. However, if very little silver is added, the metal is released is a revealing dark patina and will clump together when hit, rather than producing a sweet bell. V. POURING - The preheated mold is placed in a hole in the ground and is surrounded by loose dirt with spruce holes facing up. Cherry-red molten metals are poured into a spruce hole until it flows through the other hole. The plaster statue is left alone on the ground for a couple of hours to cool slowly. The raw statue is released by hitting the mold with a hammer. VI. FINISHING - Now the hard part. The big surprise for me was to see that much of the fine detail is not present in the wax figures. Mud casting media (inversion) are non-fine grain and do not provide high-resolution details. The feet of the figures were simply box feet; the faces were blank. The finish is done with an increasingly fine work - 1) cutting the fir trees; 2) chisell and engrave face, fingers fingers, fingers, clothing patterns, crowns, etc.. 3) assembly of molten components separately; 4) if there is an error defect in the casting, the new material is welded over the defect and the correct contours are carved into the overlay; 5) grinding and presentation of courses; 6) course sanding to fine sanding, by hand; and, 7) course polishing for fine polishing. This requires an incredible amount of work and art. Artists can be proud of their work. Each piece is a unique and unique work of art. Above are the master artist and his two sons with a statue of Ardhanarishwara. Shiva's wife Parvati felt bad when she thought Shiva had won a dance contest between them. So Shiva took a half-man, half-female form to show that the division in nature between man and woman is nothing more than an illusion. SEE MODERN CASTING TECHNICALS Your artworks are your property. Creative people have unique ideas. No matter where you live - contact Baker@BioPatent.com to protect your intellectual property with patents, trade secrets, copyrights and trademarks. Return to BioPatent Home:Return ? Protein Purification : 240Z Renewal Page (Protein Purification) Brand name or trade mark Air Conditioning Repair 240Z Performance Mods ? Company patent and trade secret page 240Z Reconstruction of the company's patent and trade engine. Lost Wax CastingsRs 286/ KilogramGet Latest PriceApplication: IndustryMaterial: SteelStandard: TUV, ISOWith the valuable assistance of a qualified team of professionals, we are committed to offering a wide range of reading more... 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