

# LOST WAX CASTING

**1.** Wax is first painted then poured into the mold, so that every crevice is filled, allowing for maximum detail.



**2.** After the wax statue is removed from the mold, all the details are perfected by hand.



**3.** The wax impression is surrounded by wax sprues. The sprues allow air to escape during the brass pouring, preventing air bubbles in the finished piece.



**4.** The wax impression then encased inside and out with refined clay.



The exceptional detail inherent in our sculptures is created as each piece is cast by the "cire perdue," or "lost wax" method, dating back to ancient Egypt and refined in Rome and later Paris.

After a mold is created from an original sculpture, wax is poured into the mold (1), and after hardening and removing the mold, all the details are perfected (2).

The wax impression is encased inside and out with refined clay (3) and (4). Once the clay sets, the wax impression is fired in a kiln; the wax melts out of the clay mold, and is "lost" (5). The void created by the melted wax in the clay mold is then filled with molten brass, which is identical to the wax impression it replaced (6).

The clay mold surrounding and inside the sculpture is delicately removed, revealing the cast sculpture, which is subsequently finished by buffing, polishing and patinizing to give the piece its final verdigris (green-grey) or bronze lustre (7), (8), and (9).

This labor intensive method of lost wax casting produces unique sculptures with exceptionally fine detail of lasting durability, and which are aesthetically warm and ruggedly handsome. Each piece is cast and assembled by our artists one at a time, just as the originals were. Variations in color, finish, size and shape will occur due to the individual craftsmanship inherent in the process.

**5.** Molds after the wax has been "lost."



**6.** The clay mold is then filled with molten brass.

**7.** Larger pieces sometimes require welding as they are cast from smaller pieces.



**8.** The pieces are polished and then an oxidation formula is applied to give them their verdigris patina.

**9.** Finally a coat of wax is applied to the oxidize piece to protect the finish.



Artisan  
DESIGNS

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