



# WILLIAM Piller Studio

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## The Lost Wax Bronze Process

1. Rubber Mold - A flexible rubber mold is made from the original sculpture. The mold captures all the detail of the original sculpture.
2. Wax Casting - Molten wax is poured into the mold to form an exact duplicate of the original sculpture.
3. Wax Chasing - The wax is removed from the mold and chased (re-detailed).
4. Spruing - Wax rods (gates) and a pouring cup are attached to the wax casting to allow the even flow of molten bronze.
5. Investing - The wax is then coated with a liquid ceramic (investment). Several layers are needed.
6. Burn Out - The piece now in a ceramic shell, is fired in a kiln. The wax melts out leaving a hollow ceramic shell. Thus the term "Lost Wax".
7. The ceramic shell is removed from the kiln and molten bronze is poured into it. The bronze is poured at a temperature of 2100 degrees Fahrenheit.
8. Break out - After cooling the shell is broken away leaving the unfinished bronze.
9. Sandblasting - The piece is sandblasted to remove any fragments of ceramic shell.
10. Assembly - All the pieces of the sculpture are now welded together.
11. Chasing - The weld marks are blended and detailed like the original sculpture.
12. Sandblasting - The bronze is sandblasted once more.
13. Patina - After the bronze is heated, chemicals are applied to give it the wanted coloration.
14. Waxing - Wax is applied to seal the patina and provide a lustrous finish.