Metal casting workshop
Lost wax technique

Owner : Mr. Douch Sonn and his family
Location : Prei Sor village, Sangkat Prei Sor, Khan DangKor,
Southern part of Phnom Penh
Lost wax casting technique

• preparing the wax model (core material can be seen as hollow cast)
• applying fine-grain clay over the wax surface
• applying outer clay and attachment of the crucible
• firing, and
• finishing the work
Preparation of the wax model
Applying fine-grain clay to the wax surface
After applying the clay

- Fine sand
- Fine termite clay
- Cow dung
Attaching the crucible to the mould with a mixture of clay and rice husk
Firing the mould
Removing the mould from the kiln and turning it upside down
Finishing the objects
Lost-wax casting procedure

Wax model

direct

indirect
Indirect technique

Coating the inside of the cast with a thin layer of wax
The **wax model** is covered with a thin layer of **fine-grain clay**.
The layer of fine-grain clay is covered with a thick layer of coarse-grain clay.
The mould and the crucible, filled with metal, are joined and sealed with coarse-grain clay.
More in detail:

Samnang Huot
Marco Ferretti
The mould-crucible system is fired. The wax is burnt and leaves a hollow space. The metal melts.
Charging the kiln:
When the metal is molten, the mould-crucible system is removed from the kiln and capsized. The molten metal fills the hollow space.
After opening the mould:

As cast object

Removing the blurr

Soldering

Finishing

Patinating