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Bombay Dye-Chem Corporation

PRODUCT RANGE : NAPTHOLS, FAST BASES, DIRECT DYES, BASIC COLOURS, ACID DYES, FLOURESCENT, PIGMENTS, SOLVENT COLOURS, METALIC POWDERS, ZARI GLITTERS, PEARL POWDER, OPTICAL WHITNER, TEXTILE AUXILLARIES, INDUSTRIAL CHEMICALS ETC.

INSTRUCTION OF METAL MOULDS FOR CANDLE MAKING

PLEASE READ ALL THE INSTRUCTIONS BEFORE BEGINNING

Step One: WORK AREA

Before beginning the actual steps of making a candle, it is advisable to cover your work area with newspapers cardboard, wax paper etc., to protect the surface from wax spoilage. (It is also advisable to wear clothes that you do not mind getting wax on) Avoid, if possible the wax in or near your skin as the melted wax should not be poured into the drain.

Step Two: PREPARING THE MOULD

*First of all grease the inner part of the mould by using any oil or **BDC Mould Release Spray**. Insert the wick un cut from the underside of your mould (Fig 1) and pull it through the hole until you have about an inch to hold on to, secure the wick and tighten it, taken **BDC Mould Sealer** and roll it into a ball and then press it down (Fig 2). Smooth the edges of the BDC Mould Sealer down against the mould, making sure that there are no gaps or spaces. Otherwise the wax will slip out and can make mess. The BDC Mould Seal is reusable. Secure the wick at the top to the **BDC Wick Rod** which will be across the opening of the mould (Fig 3) the mould is ready to fill (Fig 4)*

Step Three: MELTING YOUR WAX

*We recommend **BDC Fully Refined Paraffin Wax** it is available in granules& block / slabs. If it is in slabs or block form cut it small pieces with help of hammer & chisel works well for making into small pieces then melt this wax along with **BDC Stearin & BDC Soft Wax** till it becomes in liquid form. Our suggestion ration is if you take one kilo of Paraffin wax then add 75/100 grams of Stearin plus 200 grams of Soft Wax melt all together for good result & smooth finishing of the ready candle. Never leave the wax unattended while it is on the gas/burner*

Step Four: ADDING COLOURS TO WAX

*When the wax is in liquid form add colour. U can use **GELOWAX COLOURS or FLOURALWAX COLOURS** which comes in powder form. Start with a small amount as GELO are strong highly concentrated dyestuff. Stir it properly after adding. To get an idea of colour concentration when the dye is melted, place a few drops of the coloured wax on any white paper, the wax will set an immediately to show your candle colour. If required you can add more colour until your desired shade is reached.*

Step Five: ADDING AROMA FRAGRANCE OIL

*Just before pouring you melted wax into the mould add your aroma scent oils, stir the wax until completely dissolved and pour it immediately. Do not use too much scent aroma oils as an excess of oil will cause blemishes or moulting on the candle surface. You can also avoid this by using VYBAR approx. 0.5 % to 1 % we have wide range of **BDC AROMA FRAGRANCE OIL** to choose.*

Step Six: POURING YOUR CANDLE

When your above work is done, remove the heat. Wipe excess moisture off to the extensor of the pot to prevent water droplets from entering the candle mould and pour the wax slowly into the prepared mould. Be sure your mould is at room temperature or hotter when you pour the wax slowly into the prepared mould. When pouring the wax into the mould you can leave the mould standing upright and pour the wax directly into the mould or you tilt the mould slightly this will prevent the wax from causing the air bubbles (Fig 5) . Be cautions when tilting the mould always wears an oven gloves because the mould will get very hot once the wax is inserted into it. After the desired height of your candle is reached save a cup full of wax from the original pouring to refill the mould after the well has formed due to the settling of the hardened wax.

Step Seven: FILLING THE WELL

Approximately 45 min. after pouring (less time for small candles) a crater will form in the candle, that is the well and it must be filled. Insert a dowel or any pointed thing and make hole two to four times at an angle towards the wicks, this will relieve the surface tension and will admit air into the void are formed by setting wax. Refill the cavity with the left over wax you had set aside, heated. Be careful not to overfill the well, if too much wax is poured into the well it will soap down between the mould and the shrunken wax from the original pouring. You will then have difficultyfor removing the candle from the mould. It is best to refill the well only to widithing ¼ "of the top. The ¼" ridge may be trimmed off easily after removing the candle from the mould. Plan to refill at leat one or to additional times allowing approximately 45 mint Interval between each pouring.

Step Eight: SET UP TIME

You may let your candle set up overnight before removing it from the mould or if you are inpatient you may place the mould in refrigerator for an hour or more to hasten the set. When the mould is cold to touch the candle should be renowned. Do not place the mould in the freezer or leave too long into the refrigerator because this may cause cracks on the candle.

Step Nine: REMOVING CANDLE FROM THE MOULD

To take the candle out of the mould, first remove the BDC Mould Sealer, this allows the wick to hank free. Remove the ***BDC Needle Rod*** *turn the mould upside down and the candle should drop right down out of the mould if the mould feels cold but does not release, place it in the refrigerator for about 15 min. and then try again, if you are still unable to remove it pull the wick there as a last resort only heat the mould with help of blow dryer This will soften the wax and will normally ruin the candle, but it does not permit withdrawal of the wax mould, without damaging the mould. NEVER BEAT OR PRY THE MOULD to remove stubborn wax. Any indentations on the mould will only bend to hold the wax more firmly. Thus , adding to your trouble adding to your trouble and making your mould useless. To remove any seamier on the candle surface take a knife or spatula and slide it down the seam. To provide high gloss shiny professional finish to your candle use DIP SHINE CLEAR LIQUID. If your candle is uneven on the bottom you may so lair the base by either cutting or trimming with knife or rotating the candle in a heated fry pan there by melting off irregularities and smoothing the base.*

Step Ten: CLEANING THE MOULDS

It is very important to keep your mould clean for great looking candles. We recommend spraying the mould with BDC MOULD RELEASE SPRAY every time you pour to keep the inside of the mould in great condition. You can also clean the mould in the oven. Place the mould onto a cookie sheet lined with foil , insert the mould into a preheated oven (not to exceed more heat) turn the oven off and then keep the mould for 5 to 10 min. Any wax in the mould should melt and drain in the foil. Please do not over heat the mould, it may melt, the solder on the mould which will ruin the mould.

Step Eleven: CARE OF YOUR MOULDS

Never scratch the interior with a sharp instrument of abrasive. Never strike it with any hard object. Clean thoroughly before storing. Store in a warm dry place prevent rusting. Keep covered to protect the interior from the dust. Your mould will produce beautiful candles as long as they are properly handled. Any scratches, dent, dust or foreign matterin your mould will affect the surface of your candle. If you follow the above simple guidelines your moulds should continue to serve you for many years.

CAUTIONS:

Candle Crafting is fun and easy to do but there are certain precautions that you should take when working with this medium. Do not exceed heat while melting the wax. You must stay alert and concentrate on your project. Hot wax if you exceed the temperature called for may catch fire. Candle wax contains oil similar to cooking oils which are flammable at high temperature. However by staying alert and watching the temp there need not be any accident. Should the watch catch fire because of overheating, immediately turn off the heat source and smoother the fire with lid or baking soda. Do not use water as this spreads fire. If wax splashes on the skin apply cold water immediately, do not leave pot handles sticking out from the stove. Keep al the candle crafting supplies out of reach of children. Always place finished candles on heat resistance hold to protect furniture.

TROUBLE SOOTING

Air bubbles on the surface. *Wax was poured too fast or the mould was not tapped to remove air.*
Candle does not come out of the mould. *Candle well refilled above original level, causing wax to seep between mould and candle. Mould was not sprayed with BDC MOULD RELEASE SPRAY. Mould may be dented.*
Candle smokes *Wick is too large on the candle is in draft when it is burned.*
Candle drips *Candle is burning in a draft or you are using inferior wax.*
Wick drowns out (flame out) *. Wick size is too small.*
Fractures *in the candle. Candle was cooled too rapidly, candle cooled in a draft of cold air, candle was placed in a refrigerator for too long period of time , or the well was pulled after the wax had hardened completely.*
Frost marks on the candle. *Wax was too cool when poured in to the mould, the mould was too cold when the wax was poured into it or the mould was not cleaned properly from the previous use.*
Pit marks on the candle. *Wax was poured at too high temperature wax was poured into the mould too fast or the mould was not tapped when poured.*

HINT: *Use nylon stocking to buff slightly imperfection or fingerprints on the surface of candle.*

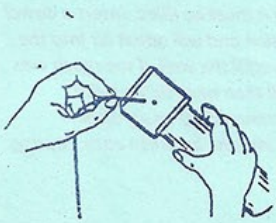

Fig. 1

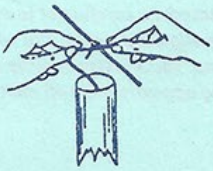

Fig. 2

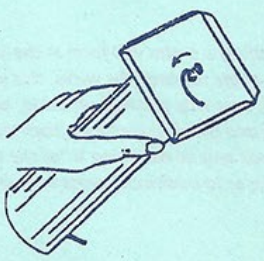

Fig. 3

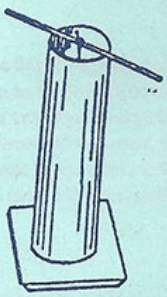

Fig. 4

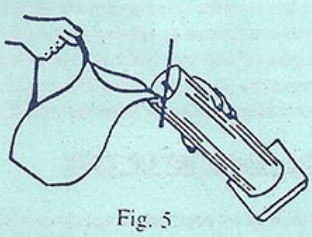

Fig. 5