

Candle making with ComposiMold. Learn how to make amazing and unique candles using simple mold making techniques.

By Stan Farrell and Michelle Miller

How To Make Candles

BY MAKING CANDLE MOLDS YOURSELF



Learn how to make imaginative candle shapes using simple candle mold making techniques to make your work amazing.

ComposiMold.com

How to Make Candles

By Making Candle Molds Yourself



Watch a video on how
to make these
candles:
[http://composimold.
com/candle-
moldmaking.html](http://composimold.com/candle-moldmaking.html)



ComposiMold is made by Wizbe Innovations
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Introducing: How to Make Candles

Candles can be more than just wax in a cup. Why stop there when you can create candles in almost any shape as easily? You can bring art into your candle making to make your work your own unique style, and learn to be amazing.

Votive candles are nice as far as they go, but candles can be so much more! The candles you make are only limited by your imagination and skills. People make candle from figurines, toys, jewelry, prototypes, ornaments, and much more. Whether you are a student, teacher, artist, sculptor, parent, maker or hobbyist, candle making with molds is a fun way to learn experiment and make your candles exciting and fun.

**CANDLES
don't have to
be just wax in a
cup! Make
them fun and
interesting!**

Candle making with ComposiMold allows you to learn as you create because this mold making material is safe, easy to use, and 100% reusable. As a heat and pour mold making material, it can be melted, poured and reused continuously. In other words, if you mess up, who cares? Both the wax and the mold making material are reusable! Whenever you need to, just re-melt your mold and start again.

Enjoy the candle making process!



There are plenty of basic candle molds on the market, however if you are trying to create truly unique candle or wax mold designs, then CompositMold is all you need. With CompositMold mold making materials, you are able to make as many unique molds as you want.

This book discusses many methods for making your own candles with reusable mold making. CompositMold is a mold making material that is used by melting and pouring. Many casts can be performed using the same mold, but then the real magic is CompositMold can be reused to make many different molds without worrying about wasting mold making material.

The format of this book starts with information about candle materials, and then goes detail about how to make your own candle molds. This includes simple instructions on how to make your own CompositMold mold and hopefully instructions to inspire you with different candle mold making projects.

As you experiment you will begin to see how the process works and learn what works for you. We hope they inspire you to use CompositMold in ways we never would have thought of.

The best instructions that we can give are to ***experiment*** and talk with others. Networking is easy on our Facebook, YouTube, and Blog pages. You will see that you can make molds and castings in lots of different ways. Trial and error are our favorite methods of mold making. With CompositMold you won't be wasting money in the process.

Please visit our social media sites for networking, video tutorials, and CompositMold news! Links for these sites are on our website at:

CompositMold.com

The Chill Method

ComposiMold melts at 130 F, so any wax with a higher melting point will need to use a chilled mold. For the wax that is poured into your molds at temperatures above 130 F, you will need to chill your ComposiMold mold first. If necessary, chill the mold in the freezer for a half hour to a couple of hours depending on the candle size and shape of your candle prior to pouring the hot wax and after to cool the hot wax faster.

The reason you are able to use a chilled mold even though ComposiMold has a lower melting point than the wax is because the wax cools at a faster rate than the ComposiMold heats so the ComposiMold will not melt.

Types of Wax

The most common waxes are paraffin wax, beeswax, and soy wax. Other candle waxes are also available as described below. To start, we recommend a low melt soy wax because it is better for the environment and will not require chilling your mold. The beeswax is also an excellent, high end wax that makes great candles.



Beeswax is a natural wax material produced by bees. It is widely available at most candlemaking supply companies and even many local beekeepers, but is much more expensive than paraffin. Beeswax has a melt point around 140 to 150 F and makes a high quality, beautiful smelling natural candle. Pure beeswax burns longer and cleaner with minimal dripping and less smoke than candles made with other waxes. It is a light to golden yellow wax naturally produced by honey bees, and it has a nice sweet scent. Beeswax also comes bleached white. If you don't want to use straight beeswax, you can also add beeswax to your paraffin wax to save some money. For 100% beeswax candles, you will need to chill your ComposiMold mold slightly before pouring in the wax.

Use a wick 1 to 2 sizes bigger for beeswax candles than you would use for other candles of the same size. For making beeswax candles it is a good idea to select a wick that is a high temperature paper core. It is a wax coated wick and it is a flat cotton braid which has a strand of paper braided into it for hotter burning.

Microcrystalline Waxes are typically higher temperature waxes that are stronger waxes than most paraffin waxes. They don't make good candles by themselves, but are a great additive to other candle waxes to prevent the separation of the candle materials and improve the candles strength. Microcrystalline wax comes from the distillation byproduct of heavy lube oil.

Mineral Oil (White Oils) is a colorless, odorless, tasteless mixture hydrocarbons. Viscosity can vary dramatically depending on the usage. Mineral oil can be added to other candle waxes to adjust the feel.

Polyethylene Wax Polyethylene waxes have a high melting point (above 100 C), but excellent strength.

Palm Wax is a natural wax derived from the palm tree. It is a hard wax with a melt point of around 140. It can be used straight or as an additive to other natural or synthetic waxes.



Paraffin Wax For many years, this has been the most common kind of wax. Paraffin wax is petroleum based. Paraffin wax is available in grocery stores in the canning section or at any craft store. The paraffin wax usually found has a melting point of 130 to 140 F, so for this wax you should chill your ComposiMold mold first, although you probably could pour smaller candles without chilling. Paraffin Candlewax made specifically for candles can be purchased from candlemaking suppliers online, or some most craft stores. They come in several different grades and melting points for the different types of candle applications.

Refined or Fully Refined Paraffin are harder, lower oil content waxes (less than 1% for slower burn). They are typically a white wax. Theoretically, food grade paraffin wax creates a less smoke and burns more slowly because of fewer impurities.

Slack wax is a partially refined mixture of oil and wax. It can have oil content up to 30 percent. It is typically the feedstock for making the refined waxes.

Scale Waxes typically contain up to 3 weight percent oil and is derived from slack wax by reducing the amount of oil content.

Soy Waxes are natural waxes made from the hydrogenation of the soy bean oil. They come in several melt points for different applications. These are generally clean burning waxes that produce little soot. The low melt point blends can be melted at 100 to 120 F making them ideal for ComposiMold

molds. You can use 100% pure soy or you can use blends with other natural and botanical oils. Soy waxes less toxic, biodegradable and environmentally safe, and longer burning than paraffin. They can also be safely melted in the microwave. They usually only require one pour, they clean up with just hot water and soap, and they work well with both fragrance oil and essential oils.

Soy wax is typically white without dyes and will require a higher concentration of colorant to make darker colors. The soy wax can be poured at low temperatures without affecting its look and finish.



Recycled Wax You can use pieces of old leftover candles and recycle them. Just remelt and reuse the wax pieces.

Wax Additives There are also several additives many candlemakers use to enhance the appearance and burning quality of candles, such as stearic acid to boost the burn time, binding agent (such as vybar) to allow increased scents, microcrystalline wax to increase strength, colorants, and scents.

Safety

BE CAREFUL with hot liquids and flames! It is important that you research the safety recommendations for specific materials that you are using.

Melting the wax should always be done safely. For paraffin waxes always use a double boiler or in a melter specifically designed to melt wax. Soy wax can be melted in the microwave using microwave safe containers or in a double boiler.

When pouring wax or the ComposiMold you should wear gloves to protect your hands from the hot liquids. Do not pour wax near the stove or any flame. Do not pour wax down the drain because most wax is insoluble and will clog the drain.

A multi-use fire extinguisher should be available. **Never use water to put out a wax fire**, it will spread the fire! If you don't have a proper fire extinguisher nearby, use baking soda, sand or flour to extinguish the flames.

Never leave melting liquids unattended. Keep melting wax or ComposiMold out of the reach of children and pets!

Remove melting wax from heat immediately if it begins to smoke. Wax will not boil, but will smoke and catch fire if it gets too hot. If a fire starts, remove pan from heat, smother fire with baking soda, and cover pan with a metal lid. Do not disturb pan until it is cooled.



If you drip hot wax on your skin, rinse immediately in cold water. Do not try to wipe off the hot wax, as it will spread the burn. After soothing with cold water, treat the burn.

Do not pour over-heated wax in your mold because it will melt the mold. ComposiMold melts at 130 F. If your wax is above this temperature, chill your mold first and cool the wax closer to its melting point before pouring.

Do not let any water drip into your melting wax. It can cause it to sputter and pop.

Remember to never lean too close over a burning candle, especially if wearing hairspray. Always keep long hair tied back and out of danger of falling into the flame.

Always keep your wicks trimmed to about 1/4 inch to prevent a smoking candle.

Wax Clean Up Tips

The first approach to easy clean-up, is to not make a mess. Take precautions to prevent melted wax from getting on clothes, furniture and kitchen counters. Cover your work surface with old newspapers, wear an apron, and have plenty of paper towels available.

Soy wax can be cleaned up with hot water. Paraffin candle wax can be removed from garments and furniture by cooling. Wax spills can be removed after the wax has hardened. Wax spilled on clothing can be refrigerated and then brushed out when the wax is cold and brittle.

Many liquid household cleaners will dissolve wax.

If paraffin wax gets on clothing or is in pots or pans or tools, chill the wax first by placing it in the freezer, then scrape off pieces of wax. Then submerge the dirty items in boiling water and follow with regular dishwashing.

To remove wax from carpet, set your iron on low heat and get an old towel. Place the towel on the spilled wax and press down with the iron. The towel will absorb the wax. Keep repeating this using different spots on the towel until all the wax substance is out of the carpet. If a little wax remains and the iron method has gotten all it can, let remaining wax harden and brush carpet and vacuum. Then try using a liquid carpet cleaner to remove any coloring that may have remained.

Wicks

Wicks come in all sorts of flavors. Experiment to see what you like best! If your candle doesn't burn properly, it's often because the wick isn't the right kind or size. The type of wax, the amount of fragrance, and whether you add color, all affect how the wick performs.

The type of wick, along with the candle wax and shape of the candle will determine the burn time of the candle, the scent throw, and the amount of smoking when the candle is in use. The best wick for a particular candle depends on wax type, scent added, and color.

Choose a wick that gives the candle:

- a consistent flame size that does not flicker too much
- low carbon build up (low black gunk)
- a well-formed wax pool



You can buy several different types and thicknesses of wick in a craft or candle supply store. Since all your candles will be different lengths and you do not need the pre-tabbed container wicks, buy the wicks by the foot.

When using spooled raw wick, it is best to prime your wicks before using. Priming means dipping the wicks a couple of times in melted wax to coat them. This helps the wicks burn better and prevents air bubbles releasing from the wick into the surrounding wax.

Inserting wicks into the candle: To keep the wick in position while pouring the wax, tie the wick to a wick rod or a pencil and lay it on top of the mold. Make sure the wick hangs in the very center of the mold. When making molded candles and you plan to over dip them, remember to leave a couple extra inches of wick to hold onto when dipping.

Wick Type

Square Braid wicks are used in beeswax candles, soy candles, tapers, pillars and citronella candles. This wick is also designed to give a slight bend at its tip when burning for an even burn.

Flat Braid wicks are used in taper and pillar candles. This wick is designed to bend slightly when burned allowing for an even burn and a reduction of carbon (mushrooming) at the tip.

Zinc Core wicks use Metal to help them stand up in candles that produce deeper melt pools. Zinc core burns the coolest and is the most commonly used wick type.

Paper Core wicks burn the hottest and is good for waxes that require heavy duty wicking to achieve a good melt pool.

Hemp Core wicks are a strong natural fiber which makes for rigid wicks that will stand up straight while burning. The stiffer wicks also is nice for staying in place when pouring in the wax.

Coreless Cotton Braided wicks are designed to bend at the tip when burning, forcing the tip of the wick into the outer portion of the flame where it burns the hottest. This causes more complete combustion, leaving less carbon (mushroom) behind and less smoking, making for a cleaner burn. These also tend to require less trimming, and are sometimes referred to as self-trimming.

Each wick acts differently. Most wicks will work reasonably well, but experimentation is important to making sure you have sufficient burn characteristics.

How to select the thickness of the Candle wick

Usually, the thicker the wick the larger the burning flame will be. And a larger flame means that the candle will burn more quickly. This is because a thicker candle wick will deliver more fuel to the flame and hence burn quicker with a bigger flame.

But, the melting point of the wax is also something to take into account when choosing your wick size. For example, the higher the melting point of the wax, the thicker your wick should be.

Unfortunately, it is difficult to provide an exact answer because so many variables influence how your candle burns and the type of wick that works best for that candle. The variables that can come into play are:

- Candle design: shape and diameter,
- If adding color or other additives to your candle
- The melting temperature of the wax you are using

A good idea is to make your candle with a well-chosen wick and then watch it carefully as it burns. You can tell pretty quickly if this is the right wick for the type of candle you are making as you can watch out for the following:

- **Size/height of the flame:** you want a good size flame, but not one so big that it burns through the wax too fast or creates too large of a melt pool.
- Rate at which the candle burns

Then, you can make changes to your wick based on what you observe. For example, if your flame is too high you can choose a thinner wick next time. Or if your candle is burning too slow, use a thicker wick.

Colorants

You can buy wax dye in either solid (blocks, chips or flakes), powdered or liquid form at a craft or candle making Supply Company. How much to use depends on the amount of wax, type of wax and how dark you want your candle. Try testing the color by dripping a little bit of the melted wax onto a white piece of paper and letting it dry. This should give you an idea of the finished color, but remember the actual color will be darker than what appears on the paper. You can also pour a little bit into a dixie cup and put it in the freezer to dry it fast so you can see the finished color.

Pre-blended waxes are very opaque and usually require more dye to get a deep color. Make sure to test burn every new combination of wax/color/scent you use, as sometimes really dark colors may require a larger wick.

Crayons can also be used to color candles, but crayons contain pigments that can clog the wick and drown out the flame giving you a poorer burning candle.



Scents/Fragrance

Fragrance oils for candle making can be purchased at many candle making supply shops, craft shops and specialty fragrance companies. It is best to use oils that are specifically made for use in candles, as the quality of the oil will affect the appearance and burning of the candle. The potpourri refresher oils sold in grocery stores are typically not as well suited for candle making as they may not blend with the wax. It may be worthwhile experimenting with these scents in soy waxes, but for other waxes the oil you use should be pure oil without water. You will have to experiment with the amount to use depending on how strong you want your candle to smell and the amount of wax you are using. Use anywhere from 3 to 10% fragrance per pound of wax.

Essential oils are all natural oils derived from plants and flowers and are not artificially composed like fragrance oils. Most essential oils are also more expensive than synthetic scents. Essential oils work well in soy wax. Using essential oils, you can make your own scents that are as unique as your designs. Some examples include coffee smell, vanilla, lemon, maple, spiced tea, brown sugar, cinnamon and whatever other scents you can design.



Basic Supplies

To make your candles you will need some basic supplies. Here is a list of the basics you will need to start.

Wax – Since this book is about making uniquely shaped candles, you will need a wax that can stand up on its own. Use soy wax, beeswax, or paraffin wax. Soy wax is nicer to the environment. Soy wax can also be melted in the microwave and is less susceptible to changes in pouring temperatures.

Wick – You have dozens of options for wicks. Start with a few different sizes. Here are some wick sizes to start you out.

- Smaller candles: (2-6 oz of wax): CD 12 or HTP 104
- Medium size candles (6-10 oz): CD 16 or HTP 105
- Larger candles (10 to 20 oz): CD 18 or HTP 105

You should buy some a bit smaller and some a bit larger also to test for each size candle. The shape will have an effect on the wick performance as well. If it is a long and narrow candle, you may want a slightly smaller wick. You do not need the wicks with the metal tabs on the bottom. When making your own unique candle shapes, you will likely just cut that tab off.

Scents/Fragrance Oil – So many choices! Choose what you like. Start with 1 ounce of fragrance oil per one pound of wax and adjust to your liking. You can also make your own scents using natural materials...orange peels, pine pitch, rose petals...

Color – Dye chips, blocks or liquid dye are all good choices for coloring candles. Soy waxes will require about twice the colorant as most paraffin waxes.

Molds – The next sections will discuss how to make your own candle molds using ComposiMold. The molds allow you to make candles that are a little more interesting than votive or jar.

Heat Source – Paraffin waxes do not melt in the microwave. Soy wax can be melted in the microwave. You can also use a stove or a hot plate for melting your wax. Heating your wax in a double boiler provides a consistent heat source so you don't overheat and damage your wax before pouring it.

Container for pouring the wax- For soy wax, a microwave safe container will work fine. For paraffin wax, use a saucepan so you can heat the wax in a double boiler.

Scale (optional, but good to have). A scale allows you to keep your ratios of wax to scents and colorants the same, but you can also use volume to measure.

Thermometer – (optional, but also good to have) A thermometer works well for measuring the temperature of your melted wax and for measuring the temperature of your reusable mold making material.

Miscellaneous Supplies –

- Paper towels
- Rubbing alcohol to clean up the wax before it cools.
- Gloves to protect your hands,
- Newspaper to cover your work surface.





Reusable Mold Making for Candles

This chapter will explain what ComposiMold is and how it benefits candle makers

Mold Making 101

Mold making is the process used to duplicate three dimensional models. Through the use of a mold making material, such as ComposiMold, a negative of a model part is made. That negative can be used to cast a second part that is the same as the original part in size and shape.



VIDEO LINK:

[Basic ComposiMold Instruction Video](#)

composimold.com/videos.html

What is ComposiMold?

ComposiMold is a heat and pour mold making material. **It is eco-friendly (certified non-toxic), Microwaveable, and Reusable!**

ComposiMold is a flexible, rubbery, molding material that can be melted poured and reused. This material is a thermoplastic mold making material that works well for casting parts using many different casting materials including plaster, cement, epoxy, polyurethane, polymer clay, and even chocolate. This book focuses on using ComposiMold to make amazing, one-of-a-kind candles. And shows you how to make them!

Advantages of ComposiMold include:

Advantages of ComposiMold:

- *Low Cost
- *Ease of Use
- *Reusability

- ✓ Lower costs over many mold making materials. The lower cost is especially true as you make more unique molds. Instead of being able to make one mold, you can re-melt the ComposiMold and make 10 to 50 different molds.
- ✓ Ease of use. ComposiMold is a one part system that does not require a scale or any measurement.
- ✓ Reusability. The ComposiMold can be continuously re-melted to make new molds as you learn and experiment.



ComposiMold can handle higher temperature casting materials by cooling the mold prior to pouring in the higher temperature casting materials.

Limitations and Warnings

The thermoplastic nature of ComposiMold allows it to be re-melted and easily moldable; yet heat is also the major limitation. Freeze the mold for candle wax that is above 130 F when pouring. Do not pour wax above 180 F.



ComposiMold is excellent for making many castings from the same mold. However, it will wear down over several cycles depending on the temperatures reached during casting, the type of mold release used, and complexity of the molds.

LIMITATIONS:

Limitations include:

- Less strength as compared to silicone or polyurethane molds
- Large molds may melt due to exothermic reaction of the casting material
- Less longevity per mold as compared to silicone or polyurethane molds
- Lower casting quantities than some other materials

WARNINGS:

ComposiMold materials are safe if used properly and as directed. Please Note: **ComposiMold is hot when in liquid form and can burn.** Use gloves to protect yourself from heat. The plastic containers will melt if overheated and the ComposiMold will break down. Do not exceed 200° F.

Do not eat or drink the ComposiMold or ComposiMold accessories.

Wearing heat resistant gloves, long sleeve clothing, and masks are recommended to minimize skin contact from the hot material.



ComposiMold is recommended for ages 12 and up. Mold making and casting is not for unsupervised children. Keep all materials out of the reach of children.

Keep ComposiMold covered when it is not going to be used for long periods. Over time, uncovered ComposiMold, may dry out and begin to stiffen. Molds may shrink over time if allowed to dry out.

How to Make a Basic Candle Mold

Now we will walk you through the HEAT, DUPLICATE, and REUSE process of creating a ComposiMold.



HEAT:

Melt the ComposiMold by heating in the microwave or double boiler.

Microwave times will vary. Start with short heating times until you understand how the microwave will heat the ComposiMold.

DUPLICATE:

To make molds, simply pour the ComposiMold over your master part after applying a Mold Release and Bubble Buster. Let the ComposiMold solidify by cooling. Remove the master part from the ComposiMold, apply a Mold Release to the mold, and pour or press in your casting material.

REUSE:

With the ComposiMold, many casts can be made with the same mold including plaster, wax, and plastic casts. When you finish making duplicate parts, reuse the ComposiMold, mold making material, to make more molds and cast parts. The unique aspect of ComposiMold is that it can be continuously re-melted and reused to make new, unique molds.



Although any ComposiMold will work, Use **ComposiMold Flex** for candle making. The flexibility makes it easier to remove the candle from the mold without damage.

Mold Release and Bubble Buster

Applying a mold release to your original object will allow it to be easily separated and removed from the ComposiMold. Also applying a mold release to the mold before casting will minimize wear and tear on the mold. This is important if you are using the mold to make many reproductions.



Applying Mold Release to your Original Object:

Spray a light mist coating of Mold Release over the entire surface of the original object and all surfaces of your mold box (and any surface that will come in contact with the ComposiMold). You can also use a clean paint brush or cloth to apply the mold release. Make sure that intricate details, undercuts and hard to reach areas are coated as thoroughly as possible.

Wipe off any excess mold release to make sure you do not have too much.

Applying Bubble Buster to your Original Object:

Spray a thorough coating of our Bubble Buster over your original object over the mold release. Make sure that intricate details, undercuts and hard to reach areas are coated as thoroughly as possible. Bubble Buster is useful when making your mold as it reduces bubble formation in the ComposiMold.

- Continue with your mold making process by pouring the melted ComposiMold over your original object.



Applying Mold Release to your ComposiMold When Making Your Casts:

Wipe small amounts of mold release over the inside of the mold. Use very small amounts.



HEAT; Melting the ComposiMold

MICROWAVE:

Melt the ComposiMold by heating above 130°F in the microwave. Microwave times will vary. Start with short heating times until you understand how the microwave will heat the ComposiMold. Below are general guidelines to melting ComposiMold in the microwave.

Container Size	Microwave times (estimates-times will vary)
10 oz.	30-60 seconds
20 oz.	3 to 5 minutes, stir every minute
40 oz.	7 to 10 minutes, stir every minute

After microwaving, gently stir and let the temperatures equilibrate throughout the molding compound. You can even leave a small portion of the material unmelted and let the heat of the melted ComposiMold melt this portion. This will equilibrate the temperature and make it perfect for pouring over your master part.

Be sure you aren't boiling your ComposiMold!

Boiling will introduce bubbles and burn the material.

WARNING: Use a microwave safe container. The ComposiMold container works but will melt if overheated. Do not heat the container without the ComposiMold in it. Also, the ComposiMold will be hot. Be careful.

DOUBLE BOILER:

You can also melt ComposiMold in a double boiler. A double boiler consists of one container inside another container with water between them. The bottom container will sit directly on the heat source.

Put your ComposiMold container into the inside container. It can sit on top of marbles or rocks to keep the ComposiMold container off of the bottom of the pot.

The purpose of the double boiler is to keep the heat from getting above 212°F. If the ComposiMold container is on a stove top directly, the container will melt. Heat the ComposiMold until it is melted.

Solidifying ComposiMold

ComposiMold solidifies when it cools back to its flexible, rubbery consistency. So to solidify, just let the part cool. To speed up to process, you can put your mold in the refrigerator or freezer.

Do not submerge the ComposiMold in water to cool.



DUPLICATE; Making a Candle Mold

Begin by choosing or making your original part that you want to mold. This object is also called your master. Your master can be made of a variety of different materials such as clay, wood, stone, plastic, glass, concrete, bone, paper, metal, fabric, etc.

SEALING THE SURFACE OF MASTER:

Models made of porous materials (plaster, some clays, concrete, wood, etc.) should be sealed to eliminate any surface porosity. To seal your model you can use shellac, wax, petroleum jelly, or specially formulated sealing materials.

WEIGH/SECURE YOUR MASTER PART DOWN:

Hot glue your master to the bottom of the container. Parts that are hollow or generally light weight will float to the surface of the melted ComposiMold. This can be very frustrating. Just take a deep breath and de-mold the part once the ComposiMold has solidified. The next time around you can weigh a hollow part down by filling it with sand and plugging the hole with clay OR you can secure the master part to the bottom of your mold box with clay or for more security use hot glue. It can easily be peeled away when you de-mold your master. Larger parts can even be nailed to a flat surface then placed into your mold box.



Definition:
Master is the original object you are duplicating.

TIP: Hot glue your Master to the bottom of your mold box so it won't float.

Creating The Mold

Pour the melted ComposiMold into your mold. Pour the ComposiMold to the lowest point in the container at a slow, constant rate. Let the ComposiMold rise up and over the model. This will displace air from the lowest point and help reduce air entrapment. Also, it may be helpful to heat the master slightly. This may reduce the number of bubbles that form on the surface of the part.



Cover the master part with approximately a ½ inch of ComposiMold. Don't worry about wasting the ComposiMold. You can always re-melt it and start again.

Let solidify by allowing the ComposiMold to cool. To speed up the solidifying, you can place the mold in the refrigerator or freezer. Or you can use cold packs against the side of the mold box.

When ComposiMold is solidified, peel the ComposiMold out of the container. Separate the original part from your ComposiMold mold.



You are now ready to make your amazing candles.

Making a Relief Sculpture Candle



Most candles are relief sculptures. This means one side has a flat base. Typically, there is not a huge amount of undercuts, but some is possible. If you have a lot of undercuts, you may want to use a two part mold.

Here we use a rubber foam capital building as your master.

Video Link: [Making the Capital Building Candle](http://composimold.com/candle-moldmaking.html) at:

<http://composimold.com/candle-moldmaking.html>

1. Hot glue your master into a mold box so it does not float in the ComposiMold. Spray or wipe with mold release, and spray with Bubble Buster to reduce bubbles from adhering to the master. Pour the ComposiMold until it covers your master by at least a $\frac{1}{4}$ inch to $\frac{1}{2}$ inch or more.



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2. Cool the mold faster by placing it in the freezer or refrigerator. This mold took approximately an hour in the refrigerator. Remove the mold from the mold box and remove your master from the mold.



3. Use a thin object to poke a hole through the spot where you want the wick to go through.

4. Pull the wick through the hole. Leave about $\frac{1}{4}$ inch of the wick in the ComposiMold.

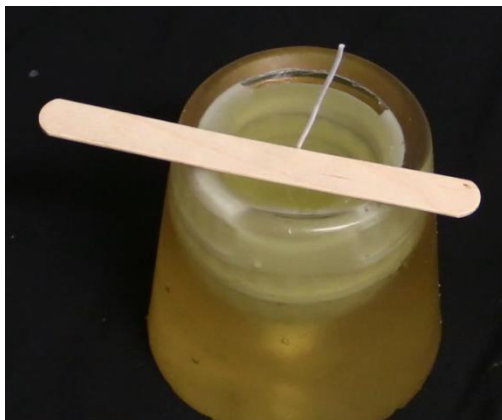
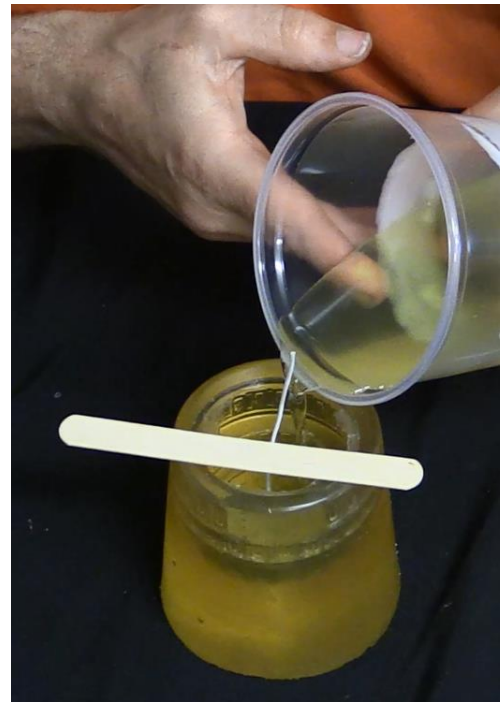


5. Align the wick through the mold. Keep it centered to provide equal burn on all sides.



6. Tape the wick in place or use a stick to keep the wick from moving. You can wrap the wick around the stick to keep it in place if needed.

7. Melt the wax. Soy wax can be melted in the microwave. Let it cool as much as possible before pouring. The soy wax used for this candle melts at 110 F, so we let it cool to 110 F before pouring. If the wax you are using melts at a temperature above 130 F, freeze the mold first so you do not melt the mold. Pour the wax into the mold.



8. Let the wax cool. If necessary, you may need pour a little more wax into the mold if the wax shrinks some. When removing from the mold, carefully pull the ComposiMold away from the wax. Be careful

to push the wick out of the mold so it does not stick.

Ice Cream Candle

Here's another example of a simple relief sculpture.

Ice Cream. The original was from children's toy.

Prepare your master. Place your master in a mold box. Spray or wipe with mold release. Be sure not to overcoat the master or you will lose details. Pour in the ComposiMold, let solidify.



Next, pull out the master, add the wick, and pour in the wax. If the wax is above 130 F, freeze your mold first by placing it in the freezer until thoroughly chilled.

Owl Candle: 2 Part

Cut Block Method

Even though the owl is quite high you can make this mold just like a relief sculpture. After you make the mold, you can cut down the sides to make it easier to remove and to go around any undercuts.

Because ComposiMold is a clear resin that you can cut, we will just pour it over the part, allow the ComposiMold to cool, and cut the mold in half. Sounds easy, and for the most part it is. You will still have to worry about where to make the parting line and keeping the part together while casting the new piece.

Although, the molds described are in two parts, there is no reason why more complex molds with three or pieces cannot be made using the same techniques.



The original owl was a wood carving, so she would float. So adhere the owl to the bottom of the container using hot glue. Coat with mold release and Bubble Buster, and pour on the ComposiMold. Let the ComposiMold cool.



We cut a line down the back of the mold after removing from the mold box to make it easier to remove the candle without causing damage.

Add wick, melt and pour the wax, let cool, remove and admire.



After the wax has solidified, remove the part from the mold. Carefully peel the ComposiMold mold away from the wax part. The ComposiMold can be stretched away from the casting. The mold will be a duplicate of the original model. Admire your work.

If you like, cast another part again using the same mold and more casting material.

Next, you can go in many different directions. Try more simple parts: one side of a coin, toy shapes or blocks, block letters etc.





REUSE; Our Greatest Advantage

ComposiMold is not only an awesome tool for any artist, but it's both biodegradable AND reusable!

Typical mold making materials are often environmentally *un*-friendly; filled with toxic chemicals for both the user and the environment, made as a one-time-use product, and certainly not *compostable* like our innovative and responsible product. ComposiMold is made of 100% natural ingredients and will biodegrade in an aqueous environment.

As a culture we've grown quite used to using products one time and discarding them. ComposiMold gives the artist and craftsman the ability to mold and re-mold over 35 times with one container. This frees the mold maker to experiment, make mistakes, and to ultimately create quality molds and casts of almost anything. ComposiMold enables this freedom for the art making process while taking responsibility of its environmental impact.

Fixing Molds



Because of the thermoplastic nature of ComposiMold, it has the advantage of being able to be patched through heating. This can provide unique molding capabilities for the creative mold maker. For example, molds can be adapted, patched, attached together, holes patched in the molds, or gaps filled or made with purpose.

Filtering the ComposiMold

Wax materials can often leave debris behind on your mold that cannot easily be wiped off. In this case you can easily clean your ComposiMold by melting it and pouring it through a filter.

FILTER WITH A FUNNEL AND FILTER:

Use a medium mesh paint filter

- Place a filter into a funnel.
- Hold the funnel above a container that can withstand the hot ComposiMold.
- Melt the dirty ComposiMold as you would before pouring a mold.
- Pour the ComposiMold through the filter and into a second container.
- Plan your next mold making project!

FILTER WITH CHEESECLOTH AND RUBBER BAND

You can also use a sheet of cheesecloth and a strong rubber band to filter your dirty ComposiMold.

- Melt the ComposiMold as you would before pouring a mold.
- Put the sheet of cheesecloth folded to determine how many layers you will be using. The more layers of cheesecloth the more filtration you will achieve.
- Lay the cheesecloth over the top of the open container of melted ComposiMold.
- Stretch the rubber band over the rim of the container holding the cheesecloth in place.
- Pour the ComposiMold through the cheesecloth filter and into a second heat safe container.
- Plan your next mold making project!

Cleaning the ComposiMold

Use cold water to clean. Let the ComposiMold dry after rubbing gently with a cold wet wash cloth. Do Not use hot water and do not place in the dishwasher.



Making 2 Part Candle Molds

In many cases, it is best to prepare the mold in two parts. This may be because there may be specific undercuts that you need to mold around, you want to make a parting line that is not straight, or you want a three part mold.

The following is an example of a two part, poured block mold using a bear figurine.



1. Place the figurine into a container. Use clay or polymer clay to build up around the figurine. Build up the area to the point where you want the parting line in the mold. This parting line is selected to allow the mold to be separated easily.



2. After the clay is completed, lightly cover the model bear and clay with a mold release. Pour ComposiMold over the figurine and clay to make the first half of your mold.



3. When the CompositMold has solidified, pull off the first half of the mold, pull the figurine out of the clay and clean off the clay.



4. Put the CompositMold mold into your container with the figurine in this mold. Cover the CompositMold and figurine with mold release again. Petroleum jelly over the CompositMold may provide a better separation between the two halves.



5. Pour melted CompositMold over the figurine and cured CompositMold to make the second half of the mold. Let solidify.

Before pouring the CompositMold freeze the first mold half and let the CompositMold cool to 130 F before pouring to keep the mold halves from adhering together.



6. After the second CompositMold half has solidified, pull it off of the figurine. Pull out the figurine from the mold. You are now ready to make your candle.



7. Add more mold release to the mold if necessary. Place the two ComposiMold mold halves together. The wick can be placed between the two mold halves or a hole can be punched through the ComposiMold.

You can use many different methods to hold the two halves together including: tape wrapped around the molds, two pieces of wood and a clamp, or string.



8. Clean up your mold, cut a pouring sprue. The sprue is the hole where you will pour in the wax. Place the sprue on the bottom of the candle mold.

For this mold, soy wax is used for the casting material. The soy wax is melted and poured into the mold after it cools to below 110 F. Let the wax solidify. De-mold and admire your work!



Cool Tool Crayons

This one isn't quite a candle. It's crayons! This is what you can do with old crayons or as a way to make something really unique or customized.



The process is the same as with candles, except you do not need to add a wick.

1. Secure the tools to the bottom of your mold box with clay or hot glue. (Note: The clay is fillings the holes in these tools to make the crayons a little stronger.)



2. Apply a mold release to the tools and all surfaces of the mold box. Then spray Bubble Buster over that to reduce bubble formation in your mold.

3. Pour your melted ComposiMold into the lowest part of the mold box and let it rise up and over your tools by at least 1/2inch.



4. Let your ComposiMold cool in back to it's original rubbery consistency.
5. Remove your tools from your mold.
6. Spray the cavities where the tools had been with a mold release.
7. Place your mold into the freezer for at least 30 minutes for this small sized mold.

DID YOU KNOW?

The key to creating wax castings with higher temperature waxes in a ComposiMold mold is chilling the mold.

The ComposiMold has a lower melting point than the crayon wax, but because the wax cools at a faster rate than the ComposiMold heats, the ComposiMold will not melt.

8. Melt your crayon pieces in a microwavable safe container. Melt similar colors together. For this project only blue colors were melted together then separately only shades of green. (Otherwise you'll end up with a bunch of brown crayons.)



HOW TO MAKE CANDLES BY MAKING CANDLE MOLDS

9. Pour your melted crayons into your cooled mold. Previously cooling the mold will ensure that the heat of this casting material won't melt your mold.



10. De-mold your crayons and enjoy!

CRAYON LEGOS!

Thank you to Allison Mitchell for this! She made these for a school fundraiser.



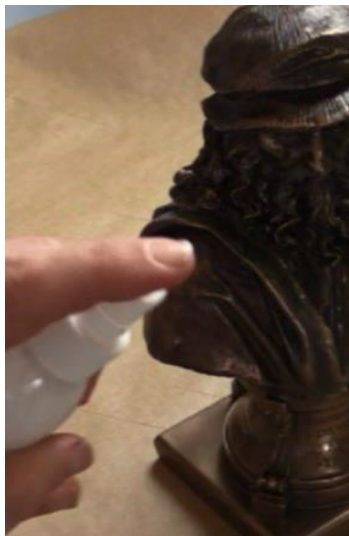
Dip Mold or Brush on Candle Molds



This candle of Leonardo DaVinci was made as a gift in celebration of his birthday. Over 50 candles were made. We used the brush-on mold making method because we wanted to mold just the head of this bust of Leonardo DaVinci. The brush on method is a good way to create molds when you don't have a mold box. For example, you could pull details off a wall or larger structures.



1. Prepare your Master. Wipe with mold release to ensure easy removal from the mold. Wipe away any access mold release so you don't have any pooling, which would reduce detail.



2. Spray on Bubble Buster to make it easier for any bubbles to not stick on the master object.



3. Melt the ComposiMold. Start dipping or brushing on ComposiMold onto the areas you want to duplicate. Make sure the first layers are filling in all the gaps and crevices. The first few layers are typically thinner, but after you get the shape you can use cooler ComposiMold and make thicker layers. Let each layer cool a bit before doing the next layer. Because each layer is thin, it will be quick to cool between layers.

4. Use a brush or a spatula to add more layers. Build up enough layers to give the mold enough strength to keep its shape. After the first few layers, you can build up the layers faster using thicker ComposiMold. Let the ComposiMold cool so it starts to solidify a little and then brush on in thick amounts. Because the first layers give you the details, the backing layers just need to give your mold support. If you are doing a large candle, make the walls thicker so you have more material to absorb the heat.



5. After the brush-on mold has cooled, peel it off of your master.



6. Use a needle, fork, or other thin object to poke a hole for the wick.



7. Push the wick through the hole into the mold cavity. Leave about $\frac{1}{4}$ inch of the wick in the ComposiMold mold.

8. To make it easier to remove the wax, we cut down the sides of the mold before pouring in the wax. We were nervous about breaking the tip of DaVinci's cap off.



9. Tape up the sides to keep the mold together and aligned so the wax won't leak.



10. Pour in the wax. Before pouring the wax, let it cool so it is at the lowest temperature that it can be before pouring. This Soy wax was poured at 100 F. By keeping the wax cool, you protect the mold, and reduce the shrinkage in the wax. If you are using wax that is above 130 F, freeze your mold first.



11. Remove the tape from the mold. Carefully peel the mold away from the candle. Be careful in undercure, like the tip of DaVinci's hat.

HOW TO MAKE CANDLES BY MAKING CANDLE MOLDS



ComposiMold as a Backing Material

If you are making production quantity candles (100s of candles), you may want to consider using ComposiMold as a backing material with a silicone or latex brush-on coat. One of the initial ways ComposiMold was used was as a backing to paint-on silicones and polyurethane mold making materials. This would allow



you to use very little of the silicone mold material and reduce the costs. By using silicone with the ComposiMold you get the benefits of the long lasting mold if needed without the expenses. High viscosity (brushable) Silicone is painted onto the original part in layers until a suitable thickness is “built up.” This process is similar to the process described in the *Brush-on Mold Tutorial*. Typically, the silicone, polyurethane, or latex layers are put on in one or two layers depending on the silicone.

After a thin layer of the paint-on mold material (silicone, polyurethane, latex, or other) is placed over the sample and allowed to cure, it is backed by the ComposiMold. ComposiMold is poured around the silicone/model to create a support shell prior to de-molding. The advantage of making a mold by brushing the paint-on mold materials onto the model is that it minimizes the amount of the expensive, one time use rubber that is used, saving you material costs. Also, the mold material allows larger, hotter molds to be made than what is possible with only the ComposiMold.



Frequently Asked Questions

Q. How Much ComposiMold do you need?

A. The critical information that you need to know is ComposiMold has a density of 1.2 grams per cubic centimeter or 0.7 ounces per cubic inch. In most cases approximately a 0.5 inch on the outside of your mold is enough to provide support to your mold.

ComposiMold has virtually no shelf-life if kept covered. It's a handy a tool to keep around.

Start by figuring out the size of your part. If your model has a simple shape, the easiest way to estimate is to take the length, width and height dimensions as an estimate in cubic centimeters or cubic inches. To this dimension, add an inch to each dimension and find the total area of your mold (Or use the volume of your container that you will be molding the part in) Subtract the part size from the container size and multiply by the density of the ComposiMold. This will give you the amount of ComposiMold you need.

Here is an example:

The part to be molded is 4.5 x 6 x 0.5 inches. It is suggested to use about a 0.5 inch of ComposiMold around to provide support.

So 5.5 x 7 x 1.5 inch container. 57.75 cubic inches of material

Minus the original piece 4.5 x 6 x 0.5 = 13.5 cubic inches. So 57.75 - 13.5 = 44.25

Convert to weight. ComposiMold has a density of 1.2 g/cc (0.7 ounces per cubic inch) so: 44 times 0.7 = about 30 ounces of ComposiMold to make this mold.

ComposiMold is also convenient because if you decide to make the mold bigger or use too much material, you can just reuse it later, so it is not just wasted unlike most mold making materials.



Q. How much casting material to do you need?

A. As you practice with Mold Making, you will typically just guestimate how much casting material you will need. With inexpensive materials like plaster and concrete on small parts that is fine, for larger parts you may want to figure

out the amount more accurately. In most cases, you are better off making a little extra than not having enough.

To find out more accurately how much casting material you need, you can measure how much water it takes to fill up a mold and use the same amount of casting material.

Or you can measure the dimensions of your part with a ruler and find the volume that way.

Q. What kind of casting materials can I use?

A. The ComposiMold can be used with many mold materials including:

- Wax! Soy wax, paraffin wax, Beeswax, and more. If the wax has a melting point above 130 F freeze your mold prior to pouring it.
- Plaster, Hydrocal, Ultracal, Dental Plaster, etc.
- Concrete or Cement
- Many Polyurethanes
- Silicone (Tin or Platinum Cured)
- Epoxy (Clear Casting Plastic)
- Many others.

A typical issue that may occur is if the casting material creates too much heat and melts the ComposiMold or the casting material is mixed incorrectly. It may not solidify.

ComposiMold melts at 130 F. Any casting that creates heats up to more than 130 F will melt the ComposiMold. If you are using a higher temperature material that has a temperature of 130 F to 180 F, you can typically freeze the mold and still cast with the casting material (such as wax or soap, but not low melt metals)

We also have a version specific for edible treats: ComposiMold-FC (Food Contact) is great for chocolates, molding chocolate, gum paste, and fondant. Isomelt is typically a little too hot.



Q. What are the advantages of using ComposiMold over Silicone molds?

A. ComposiMold is less expensive and much more forgiving in terms of allowing you to fix mistakes (Reheat or use a heat gun to heat an area) compared to silicone. Silicone is typically longer lasting for single molds, has excellent flexibility, and typically easy mold release. Disadvantages of silicones include the inability to fix the mold or reuse the material (you cannot fix them or recast them).

One of the first ways ComposiMold was used was as a backing to brush on silicones and polyurethane molds to reduce the costs. By using silicone with the ComposiMold you get the benefits of the long lasting mold if needed without the expenses of large amounts of silicone.



Q. How long does it take for the ComposiMold to solidify?

A. Solidification times depend on the shape and size of the molding. The larger the size, the longer it will take. You can speed up the solidifying by putting the part in a refrigerator, freezer, or using an ice pack.

VIDEO LINK:

[How Avoid Bubbles In Your Mold](http://composimold.com/video-avoid-bubbles-in-mold-making.html)

<http://composimold.com/video-avoid-bubbles-in-mold-making.html>

Q. How do I remove bubbles from the ComposiMold Mold?

A. When making your mold, an excellent way to reduce bubble formation is to use Bubble Buster over your mold release before pouring your melted ComposiMold over your original part. Bubble Buster is a PVA-water solution. You can your own by mixing PVA white glue and water. Use approximately 1 t-spoon of white glue (like Elmer's) with 1 cup of water (5 grams of glue to 100 grams of water). Spray, wipe, or dip your original part with this solution. The PVA reduces the surface tension and stops bubble formation. If this does not work, the bubbles could be caused by quite a few different things.

POTENTIAL CAUSES FOR BUBBLES IN YOUR MOLD:

- If your original master part is not sealed correctly, bubbles may come out from the part. This is probably the cause if you are using plaster, clay, or wood as the master. **FIX:** To solve, seal the master first with several layers of polyurethane spray or wood sealers. Elmer's-like glue

(PVA glue) works well to seal parts. In some case petroleum jelly can stop the air from escaping from your original part.

- Bubbles may be forming because you have too much mold release, so the interaction causes bubbles. This seems to happen quite a bit when you use a vegetable oil as a mold release, but other mold releases may have this affect. **FIX:** Be sure to wipe off any excess.
- You may have bubbles in the ComposiMold from bubbling in the microwave. **FIX:** It may be worthwhile to re-melt the ComposiMold and let it cool at room temperature so the bubbles can rise to the top and escape.
- Sometimes when you are making your casting, bubbles form because the heat from the resin (polyurethane and even hotter is epoxy) melts the ComposiMold. **FIX:** You can reduce the amount of exotherm by adding fillers into the resin so the resin mass per volume is less. The filler also absorbs some of the heat. Some typical fillers include sand, plaster, flour, and many specialty fillers that can be purchased.
- You may be putting bubbles in when you pour the ComposiMold into the container holding the original master. **FIX:** The best way to avoid this is to just pour gently into the lowest area of the mold so the ComposiMold rises up over the part. Be sure any holes are filled with the ComposiMold, and you are not trapping air.

You can also do quite a few things to get rid of bubbles that are in your mold while the mold is still liquid:

- You can use a toothpick or other object to push out the bubbles. This works well in small cracks or under undercuts
- Before sticking the ComposiMold in the freezer to cool, let it sit out for about 10 minutes to let the bubbles rise to the surface.
- Vibrate the part by pushing on the sides or even better a back massager against the mold sides.
- You can also paint on a thin layer of ComposiMold over the areas where the bubbles are forming. If you let this cool, you can be sure the bubbles won't be against the master part.

Candle Trouble Shooting

Mottling (white snowflake like marks): Too much oil in wax. Cooled too fast. Too much mold release. Use a higher melt point or harder wax. Additives like Vybar, Micro or Poly will reduce or increase mottling. Cool slower. Wipe out extra mold release.

Air Bubbles in Wax: Cooled too fast. Poured too cold. Poured too fast. Air didn't release. Cool slower. Pour at a hotter temperature. Pour more slowly and carefully. Tap the mold to release air bubbles. Also try tilting while pouring.



White frost marks or lines (also called 'jump lines') Too much stearic acid. Mold was too cold. Poured too cold. Try using less additive. Try warming the mold before pouring. Pour hotter. rature.

Candle won't come out of mold

Pouring temp too hot so melted the ComposiMold. Remake mold and chill mold.

Sink hole in center of candle

Natural shrinkage while cooling. Wax naturally expands as it's heated and contracts as it cools. This is totally normal and unavoidable. Try warming the mold or container before pouring. Also, the hotter the pouring temp, the more shrinkage there will be. Poke holes around wick and refill while cooling. This may need to be done several times.

Cracks in candle Cooled too fast. Cool at room temperature or in warm water bath. Cooling in the fridge or freezer can cause cracking.

Repour layer not blending Second pour too cool. Do the repour when the candle is still warm and not fully hardened yet.

Small pit/pock marks Too much mold release. Poured too hot. Wipe out mold and only leave light film of release. Lower pouring temperature.

Candle smokes when burned Wick too large. Less oil will reduce smoke and soot

Air pockets in candle Use higher pouring temperature and poke release holes and refill.

Flame too high High oil content, Try smaller wick size. Keep the wick trimmed to 1/4 inch.

Wick drowning out/not staying lit Wick too small.

Wick getting clogged Try larger size wick. Do not use dyes that container pigments, use those only for overdipping.

Flame too large Wick too large. Try smaller wick size.

Flame too small Wick too small. Try larger size wick.

Melt pool too small/ leaves leftover wax Wax too hard/too high melt point. Wick too small. Try a lower melt point/softer wax or additives such as petrolatum, hydrogenated vegetable oil, mineral oil, or beeswax. Try larger wick size.

Flame flickers/sputters Water trapped in wick from water bath.

Water in wax Make sure wick hole is sealed completely on mold. Be careful not to let any water drops from double boiler get into wax.

Oil droplets on candle surface Too much oil in wax Reduce amount of oil added to avoid oil leaking or seeping out.

Not enough fragrance when burning Low quality fragrance. Not enough fragrance. Fragrance burned away too much before pouring. Fragrance not able to release/escape into air. Try a better quality/stronger/concentrated fragrance product. Use a higher percentage of fragrance in wax. Add fragrance last, just before pouring. Use a softer/lower melt point wax to produce a larger melt pool so fragrance can release. Do not use too much of any binding additives.

Terms and Definitions

Additives: Materials added to candle wax to change properties. For example, stearic acid added to the wax will make a harder wax.



Candle Types:

- **Container:** Container candles burn in the actual container that you pour them into. The container is used to contain the wax.
- **Pillar:** Pillar candles are candles that stand on their own. This book is all about making unique pillar candles.
- **Taper:** Taper candles are the typical candles placed in candle holders. They are usually long and slim
- **Tealights:** Tealight candles are the same diameter as votives but are just 1 inch high. They're usually used under something, such as a pot of simmering potpourri or a lampshade.
- **Votives:** Votive candles are short, small candles that are only 2 to 3 inches high and 1/2 inch in diameter. Unlike pillar candles, votive candles are classified according to how long they burn. Most votives are 10-hour or 15-hour candles.

CASTING MATERIAL A casting material is a material that will take on and keep the shape that a mold gives. In this book, the candle wax is the casting material.

COMPOSIMOLD ComposiMold is a reusable mold making material that works by melting and pouring. Many casts can be performed using the same mold. ComposiMold is good for the mold maker and craft artist because it can be reused to make different molds without worrying about wasting mold making material. ComposiMold is an excellent material for those wanting to learn and become involved in sculpting, modeling, and mold making without having to worry about mistakes or wasting material. For candle making, use **ComposiMold-Flex** because it is a flexible rubber that allows easy wax removal.

DE-MOLD TIME The de-mold time is the time required to pass before the casted part can be removed from the mold. The wax will need to cool to solidify before pulling out of the mold.

FILLERS Fillers are added to your wax to reduce cost or provide specific properties.

MASTER/MODEL/ORIGINAL PART These terms are used to describe a 3-dimensional object you use as a pattern so you have something to make a

mold of. Typically, the 3-dimensional object is initially made by sculpting, carving, construction, or other method. Found objects make great master parts as well.

MOLD A mold is something that will give a certain shape to a casting material. A way to look at this is as the three dimensional negative of your master.

MOLD BOX A mold box is any container you use to hold your master part and the melted CompositMold. Be sure it is made of a flexible material such as a plastic food container and that it can withstand the heat of the melted CompositMold. You can also build a mold box out of folded tin-foil or line a shipping box with a trash bag for larger molds.

MOLD RELEASE/RELEASE AGENT is a substance that prevents one material from sticking to another. Potential Mold Releases are water, mineral oil, vegetable oil, PVA mold releases, and specially formulated mold releases. The wax does not need a mold release when removing from a CompositMold mold.

PAINT-ON/BRUSH-ON MOLDS Paint-on molds are made by painting the molding material directly onto a model's surface. The advantages of a paint-on mold are that it is possible to use less material and you can mold parts that you could not do with a typical molding process. An example where you may need to use a Paint-on mold is making a mold of something attached to a wall.

PUSH MOLDS Push Mold is a technique used when you push the casting material into the molds. For example, you can push polymer clay into the CompositMold mold to make your shape.

SPRUE A sprue is the opening in the mold where you pour in the casting material. Sprues are also added into the mold in locations where air would be entrapped into the casting. The sprues provide a way for the entrapped air to escape.

THERMOPLASTICS Resins or plastic compounds which in their final state as finished articles are capable of being repeatedly softened by increased temperature and hardened by decrease of temperature by means of physical change.



UNDERCUTS Areas on your master part with indentations or severe angles. These areas will determine the type of process you use to get the best results. You will also want to be sure that air bubbles don't get trapped in these spots.

Wax: The material used to make the candle. Hydrocarbons or various fatty acids allow the material to be burned. It is insoluble in water.



About the Authors

Stan Farrell stan@ComposiMold.com

Stan was educated in material science and has been researching advanced materials for the past 20 years. The idea for the reusable mold making material came from his inability to find a better material for making model airplane components. From there, he developed ComposiMold and other ideas have grown.

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Michelle is a graduate of the Maine College of Art with a BFA in Graphic Design and Media Arts. She brings with her tons of experience making unique shapes and eye catching crafts to all her work. Her aesthetic sensibilities are invaluable to the ComposiMold Team.

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Shawn is a graduate from University of Southern Maine in Industrial technology and management. Prior to working with Wizbe Innovations, Shawn worked in the electronics industry while completing his undergraduate work. He has become an expert in mold making and casting with ComposiMold

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Mike is a father of three, a Navy veteran with an engineering background, and a customer service expert. He supports existing resellers and customers and helps develop new business partnerships and opportunities.

And special thanks to Olympia Farrell!



**HOW TO MAKE CANDLES BY MAKING
CANDLE MOLDS**

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HOW TO MAKE CANDLES BY MAKING CANDLE MOLDS



How To Make Candles was written to provide you the skills, confidence, and lots of ideas for making your own unique candles.

In this book, you will find basic explanations of the different candle waxes and methods for making your own unique and amazing candles.

The innovative methods described in this book will give you the edge to make candles that are truly unique and one of a kind. Let your ideas run wild and make your own amazing candles.

