

Poly Wax 15

Hard, Low-Shrinkage Wax Blend for Carving and Casting

DESCRIPTION: Poly Wax 15 is a white, hard, low shrinkage, mineral-filled wax, which can be cast and carved. When cast, it replicates the mold surface in detail and finish. Tool cuts are smooth and lustrous. Dull surfaces can be hand polished with a soft cloth to a satin luster.

MELTING AND CASTING: Poly Wax 15 softens below 130°F and is quite fluid at 160°F. Viscosity decreases rapidly as temperature is increased. At 200°F, components of the wax separate slightly. Mix the melted wax thoroughly before pouring. Complete mixing is quick and easy to determine visually -- mixed wax is uniformly colored with no streaks. Use a non-porous, heat resistant stirrer such as a metal spatula. Pour temperatures of 210 to 280°F are best; however, the ideal temperature depends on the mold size, shape and material. Since Poly Wax 15 holds temperature for a long time, large or multiple molds can be filled in a single pour. When slush molding, excessively high temperatures will cause remelting of layers already laid down and significantly prolong the procedure. Casting temperatures that are too low will result in surface bubbles and “knit” marks because the wax solidifies too rapidly on the mold surface. Avoid heating Poly Wax 15 above 280°F.

PHYSICAL PROPERTIES

Softening point		126°F
Use temperature		210°F - 280°F
Viscosity	@ 100°C (212°F)	116 cP
Specific Volume (in ³ /lb)	@ 25°C (77°F)	19.5
	@ 100°C (212°F)	21.6

PACKAGING

Poly Wax 15 is available in 5-lb blocks

FEATURES

- Ideal for prototypes
- Suitable for master models
- Smooth and lustrous surfaces
- Cast carving blanks from rubber molds of rough originals

Poly Wax 15 can be poured in Poly 74 Series, Poly-Fast 72-40, Poly-Sil®, Polygel® or Hydrogel® molds. Latex will be softened by continual pours of Poly Wax 15. Most heat resistant resins and metal molds are also suitable; however, a small trial casting is always recommended to be sure castings release satisfactorily and do not damage the mold material.

SAFETY: Before use, read product labels and Material Safety Safety Sheets. Follow safety precautions and directions. Hot wax can cause severe burns and ignites easily. Avoid skin contact. Do not heat with an open flame. Do not heat above 300°F since vapors can ignite.

STORAGE LIFE: At least 12 months from date of shipment.

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