

F-145F28 Filled Pattern Wax

SHINWA SANGYO Co.,Ltd

15-18, Ainokawa, 2-Chome, Ichikawa-Shi, Chiba Prefecture, Japan

Tel:+81-47-356-3281 Fax:+81-47-356-3288

F-145 F 28 is a pattern wax containing 28% filler material. Although it is a filled wax, the Surface of the Pattern remains shiny and light. In addition, because of the very low viscosity of the wax in its liquid state, there is no mold cracking due to de-waxing. This wax has a relatively large contraction range and is thus suited to automatic pattern making with the use of extrusion machines.

Physical Properties (Representative Value)

Wax Type	Filled Wax	
Color	Green/Blue	
Softening point	72C	
Congeaing Point	60C	
Needle Penetration	200g/5sec./25C	10
Viscosity	at 120°C	98 mPa·s
	at 110°C	101 mPa·s
	at 100°C	125 mPa·s

Contraction by Injection Test Piece (Representative Value)

Injection Test Parameter		
Injection Temperature		58C
Injection Pressure		30 kg/cm2
Injection time		20 sec.
Contraction	125mm	1.34%
	75mm	1.25%
Surface Sink		0.21 mm
Length of Wax Flow		181 mm

Strength by 3 Points Bending Test (Representative Value)

Size of Test Bar	10×10×80mm
Span	60 mm
Maximum Load	54N
Maximum Bending Stress at Maximum Load	5.0 MPa
Maximum Bending Strain at Maximum Load	2.0 mm
Young's Modulus	362 MPa

