

SP2-1000 Pattern Wax

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SP2-1000 is a pattern wax that does not include a filler material. Therefore, the wax pattern surface is thin and smooth. Additionally, there is no mold cracking through de-waxing because the viscosity of the wax in its liquid state is very low. This wax is suitable for the production of the high quality investment casting products such as turbine blades and nuclear power generation parts.

Physical Properties (Representative Value)

Wax Type	Non-Filled Wax	
Color	green	
Softening point	72C	
Congeaing Point	60C	
Needle Penetration	200g/5sec./25C	10
Viscosity	at 120C	33 mPa·s
	at 110C	45 mPa·s
	at 100C	69 mPa·s

Contraction by Injection Test Piece (Representative Value)

Injection Test Parameter		
Injection Temperature		54C
Injection Pressure		30 kg/cm ²
Injection time		20 sec.
Contraction	125mm	0.85%
	75mm	0.79%
Surface Sink		0.23 mm
Length of Wax Flow		161 mm

Strength by 3 Points Bending Test (Representative Value)

Size of Test Bar	10×10×80mm
Span	60 mm
Maximum Load	55 N
Maximum Bending Stress at Maximum Load	5.0 MPa
Maximum Bending Strain at Maximum Load	3.7 mm
Young's Modulus	346 MPa

