

A-452E Pattern Wax

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A-452E is a pattern wax that does not include a filler material. Thus, the wax pattern surface is thin and smooth. Additionally, there is no mold cracking due to de-waxing because its viscosity in the liquid state is very low. This wax is strong and is the best product for use in the construction of automatic patterns for small investment casting products such as machine and automobile parts.

Physical Properties (Representative Value)

Wax Type	Non-Filled Wax	
Color	Green/Blue	
Softening point	72C	
Congeaing Point	60C	
Needle Penetration	200g/5sec./25C	10
Viscosity	at 120C	20 mPa·s
	at 110C	30 mPa·s
	at 100C	40 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	0.90%
	75mm	0.82%
Surface Sink		0.21 mm
Length of Wax Flow		168 mm

Strength by 3 Points Bending Test (Representative Value)

Size of Test Bar	10×10×80mm
Span	60 mm
Maximum Load	58N
Maximum Bending Stress at Maximum Load	5.3 MPa
Maximum Bending Strain at Maximum Load	3.2 mm
Young's Modulus	354 MPa

