

F-118F28 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-118 F 28 is a pattern wax containing 28% filler material. Although it is a filled wax, the pattern's surface remains even and light. Further, as the viscosity of the wax in its liquid state is very low, there is no mold cracking because of de-waxing. This wax is strong is best suited for automatic pattern making for small investment casting products such as machine and automobile parts.

Physical Properties (Representative Value)

Wax Type	Filled Wax	
Color	Green/Blue	
Softening point	72C	
Congeaing Point	60C	
Needle Penetration	200g/5sec./25C	11
Viscosity	at 120C	84 mPa·s
	at 110C	900mPa·s
	at 100C	104 mPa·s

Contraction by Injection Test Piece (Representative Value)

Injection Test Parameter		
Injection Temperature		58C
Injection Pressure		30 kg/cm ²
Injection time		20 sec.
Contraction	125mm	0.81%
	75mm	0.76%
Surface Sink		0.21 mm
Length of Wax Flow		175 mm

Strength by 3 Points Bending Test (Representative Value)

Size of Test Bar	10×10×80mm
Span	60 mm
Maximum Load	61N
Maximum Bending Stress at Maximum Load	5.5 MPa
Maximum Bending Strain at Maximum Load	1.9 mm
Young's Modulus	502 MPa

