

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 & CASTING: Poly Wax 15 begins to soften at 126°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.

Poly Wax 15 can be poured into Poly 74-Series, Poly 75-Series, Poly-Fast 74-20, PlatSil®, TinSil®, Polygel® or Hydrogel® molds. Latex will be softened by pours of Poly Wax 15. Most heat-resistant resins and metal molds are also suitable; however, a small trial casting is recommended to be sure castings release satisfactorily and do not damage the mold material.

SAFETY: Before use, read product labels and Safety Data 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.

DISCLAIMER: The information in this bulletin and otherwise provided by Polytek® is considered accurate. However, no warranty is expressed or implied regarding the accuracy of the data, the results to be obtained by the use thereof, or that any such use will not infringe any patent. Before using, the user shall determine the suitability of the product for the intended use and user assumes all risk and liability whatsoever in connection therewith.

Hard Wax Blend for Carving & Casting

Why Choose Poly Wax 15?

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

PHYSICAL PROPERTIES

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

PACKAGING

Product	Size
Poly Wax 15	5-lb Block