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.

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