

JEWELLERY WAX

DW4500 Jewellery Casting Wax

DESCRIPTION

DW 4500 is a low viscosity unfilled wax specifically designed for jewellery and artwork casting. The wax can be used for gravity pouring in silicone rubber moulds, for slush casting and for use in jewellery injection casting machines.

FEATURES

High surface definition.
Low shrinkage.
Supplied in bead form for easy handling.
Good strength and flexibility at demoulding temperatures.



Wax bent at 180°

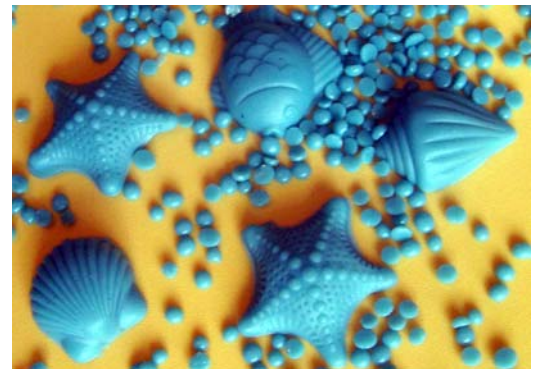
TYPICAL PROPERTIES

Melting point	63 – 70°C
Viscosity @ 99°C	110 – 140 cSt
Ash content	< 0.03%
Flash Point	>200°C
Density	0.9 g/cc

PROCESSING JEWELLERY WAX

When gravity pouring into silicone rubber moulds, the moulds need to be made in a manner to avoid significant undercuts, which may inhibit the release of the wax from the mould.

The pouring temperature should be as low as practical, still allowing good flow of the wax into the mould. This will probably be between 80 and 95°C. Low temperatures could result in flow lines or incomplete filling of some of the extremities. As a rule of thumb, simple moulds can be poured at the lower temperatures while more complex moulds will need to be poured at higher temperatures.



The amount of time needed before demoulding will depend on ambient temperatures and the size of the casting. Larger castings will need longer in the mould to cool. Premature removal can cause distortion of the casting if the wax has not properly solidified.