

# Castable Wax

Sharp Detail and Clean Casting Every Time

\$299 / L

A 20% wax-filled photopolymer for reliable casting with zero ash content and clean burnout, Castable Wax accurately captures intricate features and offers the smooth surfaces stereolithography 3D printing is known for.



FLCWPU01

# Material Properties Data for Castable Wax FLCWPU - Green<sup>1</sup>

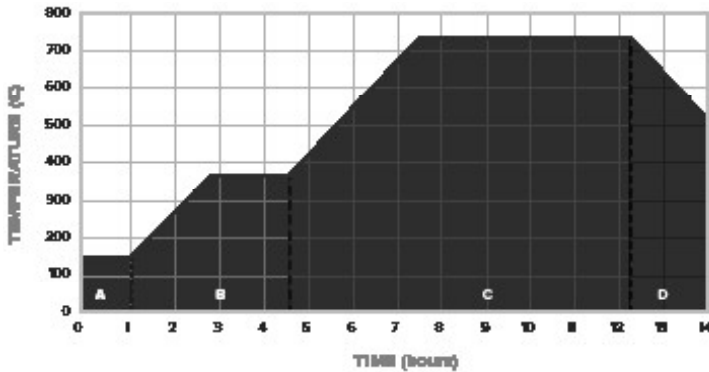
	METRIC <sup>2</sup>	IMPERIAL <sup>2</sup>	METHOD
<b>Tensile Properties</b>			
Ultimate Tensile Strength	11.6 MPa	1680 psi	ASTM D 638-10
Young's Modulus	220 MPa	32 ksi	ASTM D 638-10
Elongation at Break	13 %	13 %	ASTM D 638-10
<b>Burnout Properties</b>			
Temp @ 5% Mass Loss	249 °C	480 °F	ASTM E 1131
Ash content (TGA)	0.0-0.1%	0.0-0.1%	ASTM E 1131

<sup>1</sup>Data was obtained from parts printed using Form 2, Castable 50 µm Fine Detail settings, and post-cured with 2.5 mW/cm<sup>2</sup> of fluorescent bulb UV light, centered at 405 mm.

<sup>2</sup>Material properties can vary with part geometry, print orientation, print settings, and temperature.

## Standard Burnout Schedule

The Standard Burnout Schedule is designed to provide the maximum possible investment strength and complete burnout of the finest details using R&R Plasticast or similar investment materials. Use this schedule as a starting point and make adjustments as needed.



	PHASE	TIME	SCHEDULE °C	SCHEDULE °F
A	Insert Flasks	0 min	150 °C	302 °F
	Hold	60 min	150 °C	302 °F
B	Ramp	100 min	2.2 °C / min	4 °F / min
	Hold	120 min	371 °C	700 °F
C	Ramp	180 min	2.0 °C / min	3.6 °F / min
	Hold	280 min	732 °C	1350 °F
D	Ramp	100 min	- 2.2 °C / min	- 4 °F / min
	Hold (casting window)	Up to 2 hours	512 °C or casting temp	954 °F or casting temp