

Castable Wax Resin

Casting Resin optimized for fine features

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



FLCWPU01

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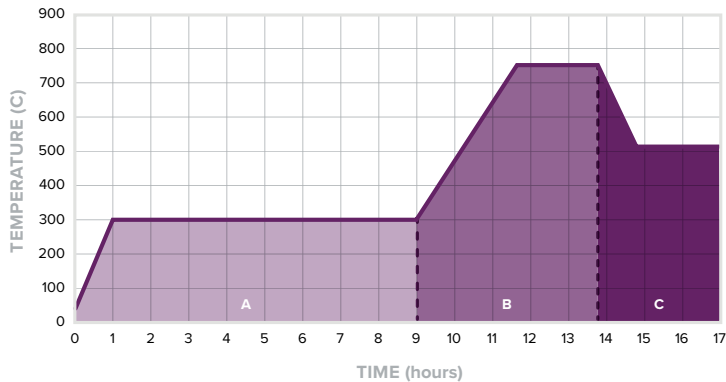
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Material Properties	METRIC ¹	IMPERIAL ¹	METHOD
	Green ²	Green ²	
Tensile Properties	METRIC ¹	IMPERIAL ¹	METHOD
Ultimate Tensile Strength	12 MPa	1680 psi	ASTM D638-10
Tensile Modulus	220 MPa	32 ksi	ASTM D638-10
Elongation at Break	13%		ASTM D638-10
Burnout Properties	METRIC ¹	IMPERIAL ¹	METHOD
Temp @ 5% Mass Loss	249 °C	480 °C	ASTM E1131
Ash Content (TGA)	0.0 - 0.1%		ASTM E1131

STANDARD BURNOUT SCHEDULE

The Standard Burnout Schedule is designed to provide the maximum possible investment strength and complete burnout of the finest details using Certus Prestige Optima 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	21 °C	70 °F
	Ramp	60 min	4.7 °C / min	8.4 °F / min
	Hold	480 min	300 °C	572 °F
B	Ramp	100 min	4.5 °C / min	8.1 °F / min
	Hold	180 min	750 °C	1382 °F
C	Ramp	60 min	- 4.0 °C / min	- 7.1 °F / min
	Casting Window	Up to 2 hours	512 °C (or desired casting temp)	954 °F (or desired casting temp)



Post-Curing Info:

No post-cure required.

¹ Material properties can vary with part geometry, print orientation, print settings, and temperature.

² Data was obtained from parts printed using Form 2, Castable 50 µm Fine Detail settings and washed without post-cure.