



M.ARGÜESO&CO.,Inc.

WAX TYPE

Cerita Soluble 28-8 Color: Yellow / Green Form: Flake / Slab October 26, 2007

DESCRIPTION

Cerita soluble wax 28-8 has excellent flow properties and is designed to make parts with superior crack resistance and a smooth surface finish. Cerita 28-8 contains fibers for increased strength and is suitable for a wide array of parts, including those destined for commercial and aerospace applications.

HANDLING PROCEDURE

LIQUID & PASTE INJECTION: Melt wax at 180-200°F/82.2°C (traditional melt tank), 190-210°F/88-99°C (plate type melt units). DO NOT heat material over 212°F / 100°C for extended periods as filler material will breakdown. Continuous agitation is recommended to prevent filler separation. Allow wax to condition as close as possible to injection temperature (without entrapping air) prior to transferring to injection machines or cylinders. **BILLET INJECTION:** allow billets to condition a minimum of 36 hours prior to injection.

PROPERTIES

	Specifications	Typical Analysis
Ring & Ball Softening Point (°F/°C)	145 – 155 / 62.8 – 68.3	149 / 65.0
Penetration @ 77°F, 454g (dmm)	3.0 – 9.0	5.0
Specific Gravity	1.450 – 1.650	1.560

INJECTION PARAMETERS

TYPE	TEMPERATURE	PRESSURE
Liquid (°F/°C)	140 -150 / 60.0 – 65.5	200 - 300 PSI
Paste (°F/°C)	130 -135 / 54.4 – 57.2	200 - 400 PSI
Billet (°F/°C)	130 / 54.4	300 - 500 PSI

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Note: Recommended injection temperatures: Equipment characteristics may necessitate different ranges.