



M.ARGÜESO&CO.,Inc.

WAX TYPE

CERITA WATER SOLUBLE WAX 484S Form: Flakes Color: Green October 30, 2008

DESCRIPTION

Cerita soluble wax 484S is designed to have superior strength , smooth surface finish and is fast leaching. Injected for a wide array of parts – commercial and aerospace applications. Cerita 484S can be injected in liquid, paste and billet forms.

HANDLING PROCEDURE

LIQUID & PASTE INJECTION: Melt wax at 180-200⁰F/82.2⁰C (traditional melt tank), 190-210⁰F/88-99⁰C (plate type melt units). **DO NOT** heat material over 212⁰F / 100⁰C for extended period of time as filler material will breakdown. Continuous agitation is recommended to prevent filler separation. Allow wax to condition as close 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)	150 – 160 / 65.6 – 71.1	154.5 / 68.1
Penetration @ 77°F, 450g (dmm)	3.0 – 8.0	5.7
Specific Gravity	1.360 – 1.480	1.414

INJECTION PARAMETERS

TYPE	TEMPERATURE	PRESSURE
*Liquid	145-150 ⁰ F /62.8-65.6 ⁰ C	200-500 PSI
*Paste	130-135 ⁰ F/54.4 ⁰ C-57.2 ⁰ C	200-500 PSI
*Billet	130 ⁰ F/54.4 ⁰ C	400-800 PSI

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* Note: Recommended injection temperatures – slight differences may exist due to machine types.