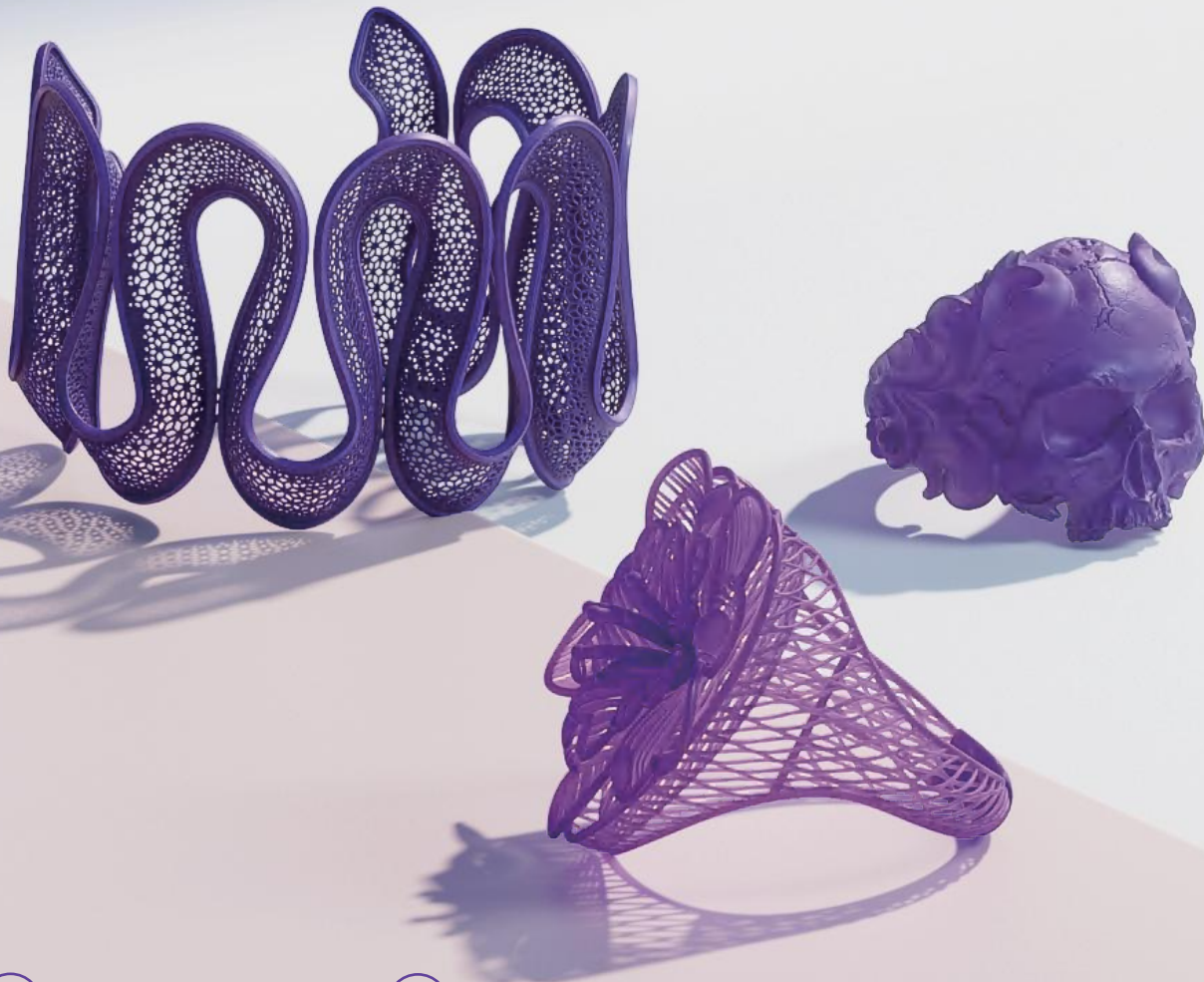


ULTRAPRINT CASTING

PAC10 Wax Casting Resin

PAC10 has up to 75% wax content and 0.02% ash content. It features low odor and burns cleanly, and it offers excellent printability for smallest convex details down to 0.08 mm.

It balances toughness and strength, it is ideal for lightweight jewelry with mesh or hollow designs, and is also suitable for heavy solid pieces and precious metals.



Wax content 70-75%



Excellent printability

Color

Specifications



Ash content 0.01-0.02%



High surface quality

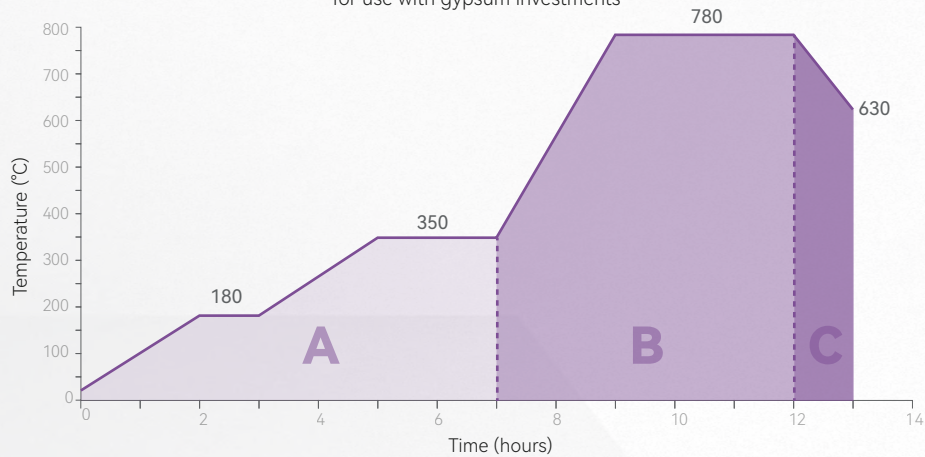
Violet ●

1000g/Bottle

Basic Performance¹

	Property	Standard	Results	Unit
Burnout Properties²	Temperature @ 5% Mass Loss	ASTM E 1131	274 (525.2)	°C (°F)
	Ash Content (TGA)	ASTM E 1131	0.01-0.02	%
Toughness	Impact Strength (Notched)	ASTM D256	13	J/m
	Elongation at Break	ASTM D638	16	%
Stiffness	Tensile Modulus	ASTM D638	450	MPa
	Flexural Modulus	ASTM D790	680	MPa
Strength	Tensile Strength	ASTM D638	21	MPa
	Flexural Strength	ASTM D790	30	MPa
Others	Hardness	ASTM D2240	64	Shore D
	Viscosity	ASTM D4212	259	mPa · s

PAC10 Standard Burnout Schedule
for use with gypsum investments



	Phase	Time	Schedule °C	Schedule °F
A Diffusion Hold <small>Sprue melts out. Liquid wax diffuses out, increasing airflow to pattern.</small>	Insert flasks into hot oven ³	0 min	Room temp	Room temp
	Ramp	120 min	1.5 °C/min	2.5 °F/min
	Hold	60 min	180 °C	356 °F
	Ramp	120 min	1.5 °C/min	2.5 °F/min
B Resin Wax Burnout <small>Remaining resin in the investment is eliminated.</small>	Hold	120 min	350 °C	662 °F
	Ramp	120 min	3.6 °C/min	6.5 °F/min
C Holding and Metal Casting <small>Flask is cooled to the desired casting temperature of the selected metal.</small>	Hold	180 min	780 °C	1436 °F
	Ramp	60 min	-2.5 °C/min	-4.5 °C/min
	Casting Window	Approx. 60 mins	Desired casting temp	Desired casting temp

Sample Request



¹ Data from HeyGears Lab. The material results are the average values from testing, with a deviation of ±10%.

² For detailed information about the casting process, please consult our sales team or distributors.

³ We recommend placing the flasks in the oven at temperatures between room temperature and 150°C. Avoid overheating to prevent breakage.