



TECHNICAL INFORMATION SHEET

Castylene B81

Castylene B81 is an unfilled pattern and runner wax with a low melt viscosity and a relatively low melting point. It has a low congealing point making it suitable for paste injection purposes as well as the traditional liquid injection. The material is tough and flexible to resist breakage and chipping during handling and assembly.

SUGGESTED APPLICATION TEMPERATURES

Liquid injection:	65 – 70°C
Paste injection:	54 – 59°C

IMPORTANT

Avoid overheating the wax (100°C max.) or holding it at elevated temperatures for long periods. Doing so will thermally degrade the product. Avoid skin contact with the molten material and avoid inhaling fumes from it. See the relevant Material Safety Data sheet for more information.

TECHNICAL PROPERTIES

Property	Method	Typical Value
Melting Point (°C)	IP. 371	65
Congeaing Point (°C)	IP. 76	59
Penetration @ 25°C (dmm)	IP. 49	9
Penetration @ 43.4°C (dmm)	ASTM D1321	76
Viscosity @ 99°C (cSt)	IP. 71	85
Ash Content (% w/w)	DCF. 2	0.030 max.
Colour	DCF. 4	Green/Blue/Natural

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