

SCULPTACAST™ WAXES



SculptaCast Dragon & SculptaCast Limerick Waxes

SculptaCast waxes are formulated with the purest synthetic and natural raw materials available in the industry; producing extremely low ash content and enabling the cleanest burnout and most accurate reproductions allowable.

Characteristics such as flow, toughness, durability, replication of detail, ductility, memory and release have all been engineered into SculptaCast waxes for specific applications.

SculptaCast waxes are available in numerous formulas to meet virtually all requirements from hand forming to slush casting. Whether you are a sculpture artist or a foundry making sculpture castings, SculptaCast waxes have been designed to meet your specific needs.

Wax Selection*

SculptaCast Dragon wax

A general purpose wax designed to be used on its own or with additions of either SculptaCast Victory or Hardener waxes.

SculptaCast Limerick wax

Can be used for most sculpture applications. It reduces or eliminates wax pattern deformation associated with bulging or lifting from mold walls. SculptaCast Limerick wax is an ideal prime wax for castings requiring painting of fine detail. SculptaCast Limerick wax sets up faster than other SculptaCast waxes, providing improved working characteristics in warmer climates.

*Always refer to application instructions when selecting painting temperatures.

	SculptaCast Dragon wax	SculptaCast Limerick wax
Color	Red	Green
Fluidity	Moderate	High
Hardness (1=Soft/10=Very Hard)	7	6
Shrinkage	Moderate	Very Low
Ductility	Low	Moderate
Polishing	Excellent	Excellent
Hand Forming	Poor	Good
Set-up Time	Moderate	Fast
Tacky/Sticky	Moderate	Very Low



RANSOM & RANDOLPH

3535 Briarfield Boulevard | Maumee, OH 43537 USA
 800.800.7496 | 419.865.9497 | 419.865.9997 (FAX)
www.ransom-randolph.com





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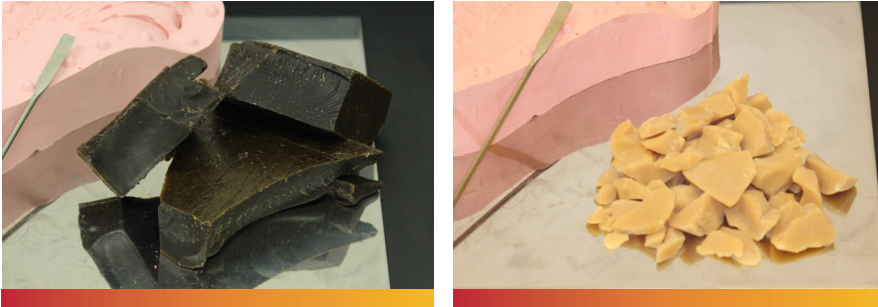
Ransom & Randolph GmbH
 Leipziger Straße 40 | 04571 Rötha Germany
 +49 342 06373999

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SculptaCast Victory & Hardener Waxes

For in-house wax adjustments, SculptaCast waxes also include SculptaCast Victory wax for a soft addition and SculptaCast Hardener wax for a hard addition.



Quality

All SculptaCast waxes undergo stringent quality control testing in a state-of-the-art laboratory to ensure the highest level of quality.

Handling Guidelines (Melting & Conditioning)

1. Melt wax at a minimum of 180-220 °F (82-104 °C) with regular agitation for proper heat transfer and to produce a homogenous blend.
2. Once the wax has completely melted, transfer the wax to the appropriate holding reservoir and condition the wax to the desired temperature. Allow the wax temperature to stabilize.

Note: Refer to recommended application temperatures below for primary coat, backup and slushing.

Note: It is recommended that wax temperature not exceed 302 °F (150 °C).

Recommended Application Temperatures**

	SculptaCast Dragon wax	SculptaCast Limerick wax
Painting Temperature (Primary Coat)	195-245 °F (91-118 °C)	195-245 °F (91-118 °C)
Painting Temperature (Backup)	175-195 °F (79-91 °C)	175-195 °F (79-91 °C)
Slushing Temperature	160-170 °F (71-77 °C)	175-185 °F (79-85 °C)

**Actual melt and application temperatures will depend on individual circumstances of use.

Safety

Before handling this material, review the corresponding Safety Data Sheet (SDS).

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