

ZWAX

A polymer alloy specially conceived for lost wax and micro casting.

Handling

Keep material dry, away from direct sunlight.

Printing surfaces

No special measures.

Support polymer(s): SSU03 or SSU04

To improve bed adhesion water soluble PVA glue sticks (UHU, PRITT,...) can be used.

Printing

No special measures. Just use SSI settings.

Support removal

Use mildly warm water (55°C max).

Let part completely dry before attempting any casting.

Don't place parts into microwave ovens for drying.

Post processing

Zwax parts can be smoothed with alcohol, but the sharp edges may lose precision.

Dipping parts in a small container for short time may suffice.

IMPORTANT: geometry is important – thin areas will erode faster than large bulky/thick parts.

Print a test part before attempting any finishing on large/expensive parts.

Let parts to completely dry (i.e.: 24h at room temp) before attempting any casting

Notes

Zwax leaves no residuals when cast metal temperature is above 450-500°C

Trapped humidity may get "foamed" parts.

Be sure that support geometry is completely dissolved to avoid carbonized residuals inside castings.