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## 6028/R9728 Par/Veg Pillar Blend

**R-9728** is a specialty formulation of vegetable derived waxes and petroleum derived waxes suitable in consistency to be used for the manufacture of pillar candles.

### PHYSICAL PROPERTIES

TEST METHODS	ASTM METHOD	SPECIFICATIONS		TYPICAL
		Minimum	Maximum	
Congealing Point °F (°C)	D938	128 (53.3)	138 (58.9)	133 (56.1)
Kinematic Viscosity, cSt @ 210°F (98.9°C)	D445	7.0	7.8	7.4
Saybolt Viscosity, SUS @ 210°F (98.9°C)	D2161	49.1	51.8	50.5
Color	D1500	----	1.0	0.5
Needle Penetration, dmm @ 77°F (25°C)	D1321	----	----	21

<b>Product Description</b>	Paraffin/vegetable wax blend for scented pillar and other molded candles
<b>Properties (Typical)</b>	<p><b>Congealing Point</b> (ASTM D938): 133°F (56.1°C)</p> <p><b>Needle Penetration @77°F (25°C)</b> (ASTM D 1321): 21 dmm</p> <p><b>Color</b> (ASTM D1500): +.5</p> <p><b>Appearance (solid)</b>: opaque</p>
<b>Benefits</b>	<ul style="list-style-type: none"> <li>• Controlled batch consistency</li> <li>• Good mold release under specified conditions</li> <li>• Good burn characteristics with appropriate wick</li> <li>• Pre-blended; no additives required</li> </ul>
<b>General Guidelines</b>	<ul style="list-style-type: none"> <li>✓ Working/pouring temperature should be from 175°F – 185°F.</li> <li>✓ Fragrance oil retention of up to 5% by weight is possible.</li> <li>✓ The “HTP” and “Performa” wick lines from Atkins and Pearce (<a href="http://www.braidway.net">www.braidway.net</a>) have been found to work well with this blend.</li> <li>✓ Once material is melted, blend should not be kept at temperatures above 160°F for extended time. One melted, use within 48 hours.</li> </ul>



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## 6028/R9728 Par/Veg Pillar Blend

### Product Information Sheet

#### Product Type:

Pillar Candle Blend

#### Typical Properties:

Congealing Point (ASTM D-938): 133°F (56.1°C)  
Needle Penetration @ 77°F (ASTM D-1321): 21 dmm

#### Description:

A smooth, creamy and very opaque blend designed for manufacturing pillar candles, containing both vegetable and paraffin waxes.

#### Features:

- Can accommodate fragrance oil up to a 5% level
- Exhibits excellent mold release when poured under the specified conditions
- Good burn characteristics when used with a wick of appropriate size and design: Forms nice melt cup which is consumed, flame size generally 0.5 inches, clean burning, minimal blooming;
- Available in slabs.

#### General Guidelines for use:

- No need to pre-warm molds.
- Pour Temperature: 175 – 185°F (79 – 85°C).
- Fragrances and dyes specifically developed for paraffin/vegetable wax should be used.

#### Suggestions for optimizing production and storage conditions:

- Evaluate fragrance/dye combinations by pouring candles within the specified parameters.
- Evaluate wicks for each different fragrance-dye combination. The addition of a fragrance and dye to a candle blend changes the wicking properties of the wax, often requiring adjustment of wick size to obtain optimal burning. The Atkins and Pearce HTP and Performa lines have been found to work well with this blend. To optimize burning, different sizes of wicks within the lines may have to be used for each fragrance-dye combination. For more information on these Atkins and Pearce wick lines, visit [www.braidway.com](http://www.braidway.com).
- Storage conditions: If the required equipment is available, temperature cycling can be done, as follows: Age half of the candles at room temperature and temperature cycle the other half of the candles as follows:
  - Place the candles in a fridge (we recommend 40°F/4°C) for 24 hours.
  - Remove from fridge and place in an oven or other suitable hot place (temperature preferably above 95°F/35°C, up to 104°F/40°C).
  - Repeat this cycle for at least 2 weeks, preferably 3 weeks.

The temperature cycled candles should give a good indication of how the candles will behave for each fragrance/dye combination under various storage and transport conditions.

#### Handling and Storage

- Vegetable waxes are more reactive than petroleum waxes, and precautions need to be taken to prevent discoloration or odor developing.



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- Once the material has been melted, the blend should not be kept at temperatures higher than 160°F for extended times. It is recommended that once melted, the blend is used within 48 hours.
- Blending and holding tanks should preferably be cleaned between lots.

#### Troubleshooting Guide:

- Trouble removing candles from mold: Allow candle to cool down properly.
- Some fragrance/dye combinations work well, while others don't:
  - Although extensive testing with different fragrance/dye combinations have been done, it has obviously not been possible to test all fragrance/dye combinations. If consistent problems are seen with a particular combination, it is recommended to try a dye or fragrance from an alternative supplier.
- The candle emits smoke when it burns:
  - A candle can emit smoke if it wicks too much material for complete combustion. Undesirable burn characteristics can often be improved by changing to a smaller wick within the Atkins and Pearce lines as indicated above.
- The candle flame is too small and self-extinguishes:
  - The wick choice for the candle is not optimal. The type of wick may not be able to wick sufficient material to support a flame of a proper size. Try a wick within the Atkins and Pearce lines as indicated above. If the problem was experienced with a wick from one of the recommended lines, try a larger wick within the series.