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DPS/MORRIS WAX
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Clear Container Gellant Base

The clear container gellant candle base product brings a new level of performance to the clear candle market. Its unique traits set it apart from other products in the clear candle market. This new product allows the ability to make container candles "bubble free." This polyamide base candle gel is produced with patented technology that offers an unmatched beauty and elegance. It is very easy to work with and increases design flexibility. All the ingredients are provided except fragrances and dyes. The working temperature is between 170°F to 190°F with a melting point of 155° F. The flash point of the base is over 400°F. It is offered in one grade. The finished product will normally burn 2-4 times longer than regular paraffin candles.

- Excellent clarity of finished candle
- No odor from gel, no interference with fragrances
- Linear release of fragrances
- No bubbles: (can create bubbles with low pour temps.)
- Low burn pool temperature (67°C-70°C) (152°F-174°F)
- Low processing temperature (80°C-90°C) (176°F-194°F)
- Low viscosity during processing
- Stable from (-20°C-50°C/68°F-122°F)
- No creep or shrinkage
- Compatible with polyamide-based icons
- No paraffin imbeds/ Use Clear Pillar Base
- No pigments bleed into gel from icons



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Clear Container Gellant Base Guidelines:

The following are guidelines, recommended manufacturing procedures and safety factors to consider when working with the clear candle base.

Fragrance Selection

Selection of the fragrance is critical with the clear candle base. There are certain characteristics that you must look for in the fragrances to ensure solubility and compatibility. The fragrances must have non-polar characteristics and have flash points above 170°F. These are essential to ensure the safety of the candle. Testing it with mineral oil can check the polarity of the fragrance. We suggest you test it at the same percentage you're going to be using it in the clear container gellant base.

It is recommended that you do not exceed 6% fragrance loads with product. The container base will hold higher fragrance loads but it will jeopardize the safety of the burning candle.

Color Selection

There are no known safety concerns in regard to the type of dyes used in the base. The dyes used in the clear candle base should be oil soluble and should be heat stable.

Melting & Processing of Clear Candle Base

The clear candle base is available in 5-gallon pails (35LB.) or 360-pound drums. Because of the properties of the clear candle base it is very simple to get out of the bucket or drum. In both the bucket and the drums the lids will come completely off making it much easier to work with the material. Once the lid is off you can take a small cup or bucket and scoop out the desirable amount. If you want to melt larger amounts in the steel drum you can take a flexible heat belt and wrap it around the drum to melt. You can either use a displacement pump or you can use a pouring pot to get it out. The base can be melted in direct heat or water-jacketed tanks in larger amounts. The clear candle base can also be heated in pouring pots, metal or glass on low direct heat. The melting point of the clear candle base is 155 degrees F. It is suggested that you heat the base to 185 degrees F and add the color and the fragrance. Make sure it is thoroughly blended; we suggest agitating it for several minutes. Once the clear container base is fully agitated we suggest pouring it into the containers between 170 to 190 degrees F. Once you begin working with the base you will be surprised how quickly the material will melt and set up, which should assist you in speeding up your production time.

Containers/Preparation

The containers used to make candles using the clear container base should be gel candle safe. We suggest doing rigid testing on the jars for safety purposes. We suggest that containers/glassware be at ambient or slightly warmer temperatures before pouring the clear candle base. The jars should be thoroughly cleaned. Once the jar is cleaned take the base of the wick assembly (sustainer/tab) and adhere it to the bottom of the jar with our Blue Dots or a high melt point adhesive. Once the sustainer/tab is secured to the bottom of the



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jar, wrap the top of the wick around a wick bar or take a predrilled hole in a wooden bridge and clamp the wick at the top of the hole.

Wick Selection

We recommend using pre-waxed assemblies with the 210°F wax coating. We suggest this for two reasons: the first is to prevent the wax melting and getting an unwanted cloud around the wick. The second is to prevent air bubbles being released into the clear candle base. Priming the wicks is always best for preventing the unwanted release of air bubble from the wick. We also recommend that you use a sustainer/tab with a 6 or 9 mm neck, this will help prevent the candle's flame from reaching the very bottom of the container. This is to ensure the safety of the candle.

The wick selection will start with the diameter of the containers you are using. Though this is just the starting point, amount of fragrance and amount and type of color will affect the burning properties. We have found HTP, CD and HZL series of wicking to be most effective in the clear candle base. The final selection is going to have to be determined by the candle maker/manufacturer. We recommend rigid test burning to ensure the proper burn of the candle. This product is not a paraffin wax so the burning characteristics are going to be slightly different. With the correct wick selection this product will give you a very desirable burn.

When test burning your candles using the base, you want to avoid carbon deposits, smoking and soot; these are strong indications that your wicks are oversized. Tunneling and small flame size indicates that, the wick is too small. We have found in testing that some residue left on the containers wall is likely in large containers. It is important for the safety in any candle that you avoid excessive carbon deposits (mushrooming). The excessive carbon deposits can fall into the melt pool, which can jeopardize the safety of the candle when it reaches the bottom of the container. We can't emphasize enough that correct wick selection is the most important part of candle making.

Embedding

Because of the transparency of the clear candle base you are able to achieve true elegance by embellishing it with inserts. These embeds can be added to the jar before pouring or after the candle is poured. We suggest soaking these embeds in mineral oil or dipping them in the gel before putting them in the jar. This will help eliminate the air bubbles that could be released from the embeds. Do not use embeds that are flammable, for obvious reasons. The only limitation is your imagination.

Candle Care/Labeling

Once the molten candle base is poured into the container, allow it to cool at ambient temperature in order to allow it to gel completely. Once the candle has completely gelled remove the wick bar or wood bridge. It is recommended covering the top of the candle container with a plastic film for shipping.

Make sure all your candles for sale are labeled with your warning labels and/or burning instructions. Some things to keep in mind on the labels/instructions for the consumers include:

- Don't burn candle for more than 4 hours at a time
- Allow to cool before re-lighting
- Make sure the wick is trimmed ¼"
- Never leave the candle unattended



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Avoid burning the candle in a draft