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# DPS WAX, INC.

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## PARAFFLEX 4627 - E-Z COMFORT BLEND

**Parafflex 4627A** is a smooth and creamy blend of petroleum derived waxes designed for manufacturing container candles of various sizes. Parafflex 4627A is formulated to facilitate a “Single Pour” filling process, however, it is recommended that customers pre evaluate using their specific containers. Containers should be pre-warmed to a temperature between 122°F and 140°F for optimum results.

### PHYSICAL PROPERTIES

TEST METHODS	ASTM METHOD	SPECIFICATIONS		TYPICAL
		Minimum	Maximum	
Congealing Point °F (°C)	D938	115 (46.1)	126 (52.2)	118 (47.8)
Kinematic Viscosity, cSt @ 210°F (98.9°C)	D445	6.0	10.5	9.0
Saybolt Color	D6045	+10	----	+15
Odor	D1833	---	2	1.5
Needle Penetration, dmm @ 77°F (25°C)	D1321	150	210	170

<b>Product Type</b>	Container Candles
<b>Properties (Typical)</b>	<b>Congealing Point</b> (ASTM D938): 118°F (55.0°C) <b>Needle Penetration @77°F (25°C)</b> (ASTM D1321): 170 dmm
<b>Description</b>	A specialty wax blend for “one pour” container candle applications
<b>Benefits</b>	<ul style="list-style-type: none"> <li>• Good single pour characteristics under optimal controlled production conditions in containers up to 24 oz. (approx. 700 ml) jars, accommodating approximately 500 g of wax.</li> <li>• Smooth and creamy look</li> <li>• Pre-blended; no additives required</li> <li>• Fragrance oil retention of up to 10% by weight is possible</li> <li>• Exhibits good adhesion to glass containers when poured under optimal conditions</li> <li>• Good burn characteristics when used with a wick of appropriate size: flame size generally 0.5 inches, no sooting, minimal hang-up.</li> </ul>
<b>General Guidelines</b>	<ul style="list-style-type: none"> <li>➤ Container choice: This is probably one of the most critical things to choose correctly for any container candle to get good results.</li> <li>➤ Container pre-warming: Containers should be pre-warmed to 122°F – 140°F</li> <li>➤ Pour Temperature: 175°F – 185°F (78°C – 85°C).</li> <li>➤ Fragrances and dyes specifically developed for candles should be used.</li> </ul>



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## 4627 - E-Z Comfort Blend – Page 2

The container shape affects the cooling rate of the wax; for optimal results, the cooling rate should be as uniform as possible.

- Containers with uniform wall thickness help to maintain a uniform cooling rate of the candles and also will be easier to pre-warm.
- Containers with smooth rounded corners will work better than ones with sharp corners.
- Containers with bottoms comparable in thickness to the walls will promote uniform cooling rate of the candles, and will be easier to heat;
- Containers with thinner walls will pre-warm faster than ones with thicker walls or bottoms;
- Containers with uniform volumes along its height will work better than ones that have varying volumes along its height (e.g. a straight up-and-down glass container will work better than one with a bulge in the middle);
- Containers with smooth inside surfaces will work better than ones with uneven surfaces.
- Generally round containers will give better results than square, oval, or angular ones.

Suggestions for optimizing production and storage conditions:

- Evaluate containers by pouring candles within the specified parameters, using the desired fragrance and dye combinations.
- 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.

Troubleshooting Guide:

- Pull-away of candle from container walls:
  - Check container temperatures before pouring;
  - Check pour temperature;
  - Check container design against guidelines above
  - Check candle cooling area for drafts which could result in non-uniform cooling.
- Excessive shrinkage:
  - Note that a small amount of shrinkage is normal, and that this will be more noticeable on large volume candles. The shrinkage is usually less noticeable once a wick is used.
  - Check pour temperature.
- 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.