



FRAG3281

# REZEPT - FLACHER ZYLINDER (62X107MM) STUMPENKERZE WEIHNACHTSBAUM IN HPM

# CANDLE SHACK

## WAS DU BRAUCHST

<a href="#">1x Flacher Zylinder 62x107 - Kerzengießform Für Stumpenkerzen</a>
<a href="#">8,1g Weihnachtsbaum Duftöl</a>
<a href="#">261,9g Hochleistungs-Schmelzmischung (HPM)</a>
<a href="#">1x LX14 Docht (250mm)</a>
<a href="#">1x 2,5mm Edelstahl Rundstab</a>
1x Blu Tack
1x Lolly-Stick

# SCHRITT-FÜR-SCHRITT-ANLEITUNG

## SCHRITT 1

Stecke den Dochtstab in das Dochtloch und dichte ihn am Boden der Kerzengießform mit Blu Tack ab.

## SCHRITT 2

Schmelze das HPM-Wachs bei 75 °C.

## SCHRITT 3

Sobald das Wachs vollständig geschmolzen ist, fügst du deinen Duft hinzu und rührst ca. 1 Minute um, bis die Mischung homogen ist.

## SCHRITT 4

Gieße die Mischung langsam bis zur gewünschten Höhe in die Form.

## SCHRITT 5

Stecke den Dochtstab durch die Dochtzentrierhilfe, um ihn zu zentrieren.

## SCHRITT 6

Lasse das Wachs aushärten. Sobald es vollständig ausgehärtet ist, in der Regel nach etwa 2,5 Stunden, nimmst du die Dochtzentrierhilfe heraus und füllst die Kerze auf, um einen eventuell entstandenen Hohlraum auszufüllen.

## SCHRITT 7

Wenn die Kerze vollständig ausgehärtet ist, etwa 5 Stunden nach dem ersten Gießen, nimmst du den Dochtstab vorsichtig heraus und nimmst die Kerze aus der Form.

## SCHRITT 8

Fädle den vorgewachsenen Docht durch das Loch und schiebe den Stützstab in den Kerzenboden.

## SCHRITT 9

Schmelze den Boden der Kerze auf einem heißen Backblech, um einen flachen und ebenen Boden zu erhalten.

## SCHRITT 10

Lasse die Kerze 48 Stunden aushärten und kürze den Docht vor dem Anzünden auf 5 mm.

# CANDLE SHACK

Candleshack Ltd, Unit A, West Carron Works,  
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Technical report on a test set of candles made in Candle Shack R&D department for  
sooting behaviour testing and fire safety testing

Date of Report: 04/10/23

Testing Period: 29/09/2023 - 04/10/2023

Sample Ref	PIL0009C	No. of Samples	3
Candle Name	270g Round, Flat Top Pillar Candle, 3% in HPM		
Description	270g Mineral Blend Wax Fragranced Candle		
Fragrance	Christmas Tree	Weight per candle	8.1g
Wax	HPM Wax	Weight per candle	261.9g
Colour	White	Height	105mm
Wick Type	LX14	Width	62mm
Wick Positioning	Centred	Depth	62mm
Surface Defects	None		

## TECHNICAL REPORT

### Part 1: SPECIFICATION FOR SOOTING BEHAVIOUR

To evaluate the performance of a test set of candles in a controlled environment against the requirements of BS EN 15426:2018 (Candles. Specification for sooting behaviour)

### Part 2: SPECIFICATION FOR FIRE SAFETY

To evaluate the performance of a test set of candles in a controlled environment against the requirements of BS EN 15493:2019 (Candles. Specification for fire safety)



# CANDLE SHACK

## Part 1: SPECIFICATION FOR SOOTING BEHAVIOUR

### Requirement

When tested in accordance with clause 9 of EN 15426:2018, the average soot index per hour from three tests (samples) shall be less than 1.0/h

The room temperature during testing was 20±5°C

Wicks were trimmed to 5mm before lighting.

Cycles: 2 x 240 ± 5 min cycles with >60min pause between cycles)

Soot testing was performed in wire mesh cylinder Type 1 (Diameter: 230 ± 10 mm)

Sample Ref.	Total burn time $t_m$ (h)	Hourly soot index $S_{i_h}$	Average soot index per hour $S_{i_h}$	Result
PIL0009C-1	8.00	0.00	0.02	PASS
PIL0009C-2	8.00	0.03		
PIL0009C-3	8.00	0.03		



# CANDLE SHACK

## Part 2: SPECIFICATION FOR FIRE SAFETY

Test Property	Test Method	Test Requirements	Result
Stability	EN 15493:2019 4.1 (Visual Check)	Candle should not tip over when placed on a 10° incline plane	PASS
Secondary Ignition	EN 15493:2019 4.2 (Visual Check)	No secondary ignition shall occur for more than 10 s	PASS
Flame Height	EN 15493:2019 4.3 (Measurement)	The flame height for all candle types, except for tea lights, shall not exceed 75mm. The flame height for tea lights shall not exceed 30mm	PASS Maximum: 30 mm
Behaviour after extinguishing	EN 15493:2019 4.5.1 (Visual Check)	After extinguishing the candle shall not spontaneously re-light	PASS
	EN 15493:2019 4.5.2 (Measurement)	The wick shall not continue to glow or smoke for an average time of more than 30 s after extinguishing	PASS Average: 5 s

The room temperature during testing was 20±5°C  
Wicks were trimmed to 5mm before lighting.

Candle Performance (240 ± 5 min cycles with >60min pause between cycles)

Sample Ref.	Gross Weight (g)	Total Wax Consumed (g)	*Total Burning Time (h)	Wax Consumption Rate (g/h)
PIL0009C-1	282.8	197.5	44.0	4.49
PIL0009C-2	256.9	201.3	44.0	4.58
PIL0009C-3	275.9	197.0	44.0	4.48

\*If a candle self-extinguishes during the final burn cycle, the time of self-extinguishing is estimated.

### Notes and Discussion:

Candles were burned to a residual height of 15-25mm.



# CANDLE SHACK

## IMAGE GALLERY



End of Burn Front - Sample 1



End of Burn Front - Sample 2



End of Burn Front - Sample 3



End of Burn Top - Sample 1



End of Burn Top - Sample 2



End of Burn Top - Sample 3

## END OF REPORT

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