



FRAG3281

REZEPT- SPITZER ZYLINDER (50X140) STUMPENKERZE WEIHNACHTSBAUM IN HPM

CANDLE SHACK

WAS DU BRAUCHST

1x Spitzer Zylinder 50x140 - Kerzengießform Für Stumpenkerzen
6,9g Weihnachtsbaum Duftöl
223,1g Hochleistungs-Schmelzmischung (HPM)
1x LX12 Docht (250mm)
1x 2,5mm Edelstahl Rundstab
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.

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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	PIL0009D	No. of Samples	3
Candle Name	230g Round, Pointed Tip Pillar Candle, 3% in HPM		
Description	230g Mineral Blend Wax Fragranced Candle		
Fragrance	Christmas Tree	Weight per candle	6.9g
Wax	HPM Wax	Weight per candle	223.1g
Colour	White	Height	130mm
Wick Type	LX12	Width	50mm
Wick Positioning	Centred	Depth	50mm
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)



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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: 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 Si_h	Average soot index per hour Si_h	Result
PIL0009D-1	8.00	0.06	0.10	PASS
PIL0009D-2	4.00	0.13		
PIL0009D-3	8.00	0.12		



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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: 25 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: 3 s
Container Candles	EN 15493:2019 4.6 (Visual Check)	The container shall not crack or break at any time throughout the burning test	PASS

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)
PIL0009D-1	222.9	40.2	16.0	2.51
PIL0009D-2	235.7	16.1	4.0	4.03
PIL0009D-3	241.2	39.5	12.0	3.29

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

Notes and Discussion:

Sample 2 soot tested only for 4 hours
Candles were burned to a residual height of 15-25mm.



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IMAGE GALLERY



End of Burn Front - Sample 1



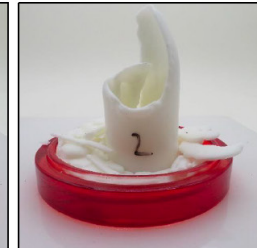
End of Burn Front - Sample 2



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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