

Liquid Material

MEASUREMENT	CONDITION	VALUE
Appearance		White
Liquid Density	@ 25 °C (77 °F)	1.13 g/cm ³
Solid Density	@ 25 °C (77 °F)	1.20 g/cm ³
Viscosity	@ 30 °C (86 °F)	155- 185 cps
Penetration Depth (Dp)*		5.2 mils
Critical Exposure (Ec)*		7.4 ml/cm ²
Tested Build Styles		EXACT, FAST, Exact HR

Post-cured Material

MEASUREMENT	METHOD/CONDITION	METRIC	US
Tensile Strength	ASTM D638	63 - 68 MPa	9200 - 9850 psi
Tensile Modulus	ASTM D638	3200 - 3380 MPa	460 - 490 ksi
Elongation at Break (%)	ASTM D638	5 - 8 %	5 - 8 %
Flexural Strength	ASTM D790	88 - 110 MPa	12830 - 15920 psi
Flexural Modulus	ASTM D790	2690 - 3240 MPa	390 - 470 ksi
Impact Strength (notched Izod)	ASTM D256	12 - 22 J/m	0.2 - 0.4 ft-lb/in
Impact Strength (Gardner)	ASTM D5420	1.1 J	0.81 ft-lbs
Heat Deflection Temperature	ASTM D648 @ 66 psi @ 264 psi	55 - 58 °C 51 - 53 °C	131 - 138 °F 123 - 127 °F
Hardness, Shore D		85	85
Co-efficient of Thermal Expansion	ASTM E 831-93 TMA (T < T _g , 0-20 °C) TMA (T < T _g , 90-150 °C)	61 μm/m-°C 163 μm/m-°C	141 μin/in-°F 326 μin/in-°F
Glass Transition (T _g)	DMA, E''	56 °C	132 °F

* Dp/Ec values are the same on all solid-state laser SLA systems.