

Liquid Material

MEASUREMENT	CONDITION	VALUE
Appearance		White
Liquid Density	@ 25 °C (77 °F)	1.13 g/cm ³
Solid Density	@ 25 °C (77 °F)	1.19 g/cm ³
Viscosity	@ 30 °C (86 °F)	250 cps
Penetration Depth (Dp)*		4.2 mils
Critical Exposure (Ec)*		10.5 ml/cm ²
Tested Build Styles		FAST, EXACT, Exact HR

Post-cured Material

MEASUREMENT	METHOD/CONDITION	METRIC	US
Tensile Strength	ASTM D638	38 MPa	5450 - 5570 psi
Tensile Modulus	ASTM D638	1590 - 1660 MPa	230 - 240 ksi
Elongation at Break (%)	ASTM D638	13 - 20 %	
Flexural Strength	ASTM D790	55 - 58 MPa	7960 - 8410 psi
Flexural Modulus	ASTM D790	1380 - 1660 MPa	200 - 240 ksi
Impact Strength (notched Izod)	ASTM D256	19 - 24 J/m	0.4 ft-lb/in
Heat Deflection Temperature	ASTM D648 @ 66 psi @ 264 psi	58 - 63 °C 51 - 55 °C	136 - 145 °F 124 - 131 °F
Hardness, Shore D		80	
Co-efficient of Thermal Expansion	ASTM E 831-93 TMA (T < T _g , 0-20 °C) TMA (T < T _g , 90-150 °C)	107 x 10 ⁻⁶ m/m °C 151 x 10 ⁻⁶ m/m °C	
Glass Transition (T _g)	DMA, E''	60 °C	163 μm/m-°C40 °F

* Dp/Ec values are the same on all systems.

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