



## xMODEL15-Black

Available Colors: Black and Gray

### Basic Properties

Measurement	Unit	Test Method	2x15min in XiP Cure, 1x30min in xCure, 2x4min 50% in xCure Desktop
<b>Tensile Properties</b>			
Young's Modulus	MPa	ASTM D638	1800
Ultimate Tensile Strength	MPa	ASTM D638	55
Elongation at Break	%	ASTM D638	10
<b>Thermal Properties</b>			
HDT at 1.82 Mpa	°C	ASTM D648	58
HDT at 0.45 Mpa	°C	ASTM D648	53
<b>General Properties</b>			
Viscosity	cP	GB/T 22235	250
Liquid Density	g/cm <sup>3</sup>	GB/T 4472	1.10
<b>Other Properties</b>			
Water Absorption (24hr)	%	ASTM D570	0.7
Shore Hardness	D	ASTM D2240	80
<b>Biocompatibility</b>			
Cytotoxicity		ISO10993-5	Pass
Irritation		ISO10993-10	Pass
Sensitization		ISO10993-10	Pass

### Printing Process

The material should be processed at room temperature. Before usage, the material should be shaken well. Pour it slowly into the vat and wait a couple of minutes, until a smooth, bubble-free surface is obtained before starting the print job.

The 3D printer examples and settings stated above are only for general guidance. The fully optimized settings should always be determined by the users themselves, according to their specific needs. Please always refer to the user manual of the employed 3D printer for instructions on printer settings and handling.

Remove the parts carefully from the build platform with a suitable tool, for more information, refer to the user manual of the used 3D printer.

### Washing

xMODEL requires post processing to achieve specified properties. Prior to post curing, the part should be washed. Nexa3D recommends using xCLEAN followed by IPA as standard cleaning procedure. Parts should not be submerged in xCLEAN for longer than 2 minutes or in IPA for longer than 5 minutes to avoid any impact on performance.

**Note:** The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Nexa3D is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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