



xMODEL17-Clear

Basic Properties

Measurement	Unit	Test Method	2x20min in XiP Cure, 1x40min in xCure, 2x5min 50% in xCure Desktop
Tensile Properties			
Young's Modulus	MPa	ASTM D638	1358
Ultimate Tensile Strength	MPa	ASTM D638	37
Elongation at Break	%	ASTM D638	28
Flexural Properties			
Flexural Modulus	°C	ASTM D648	1467
Flexural Stress	°C	ASTM D648	57
Impact Property			
IZOD Impact (Notched)	J/m	ASTM D256	47
Thermal Properties			
HDT at 1.82 Mpa	°C	ASTM D648	40
HDT at 0.45 Mpa	°C	ASTM D648	47
General Properties			
Viscosity	cP	ASTM D7876	471
Other Properties			
Water Absorption (24hr)	%	ASTM D570	0.24
Water Absorption (168hr)	%	ASTM D570	0.59
Shore Hardness	D	ASTM D2240	82

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

xMODEL17-Clear 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.

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