



# PRO9499-White

## Basic Property

Measurement	Unit	Test Method	1x30min in XiP Cure, 2x15min in xCure, min % in xCure Desktop
<b>Tensile Property</b>			
Young's Modulus	MPa	ASTM D638	1500
Ultimate Tensile Strength	MPa	ASTM D638	40
Elongation at Break	%	ASTM D638	8
<b>Flexural Property</b>			
Flexural Modulus	MPa	ASTM D790	2164
Flexural Stress at Yield	MPa	ASTM D790	95
Flexural Elongation at Break	%	ASTM D790	6.7
<b>Impact Property</b>			
IZOD Impact (Notched)	J/m	ASTM D256	28.7
<b>Thermal Property</b>			
HDT at 1.82 Mpa	°C	ASTM D648	62.6
HDT at 0.45 Mpa	°C	ASTM D648	50.3
<b>General Property</b>			
Viscosity at 25°C (77°F)	cP	ASTM D7867	506
Liquid Density	g/cm <sup>3</sup>	ASTM D1475	1.12
Solid Density	g/cm <sup>3</sup>	ASTM D792	1.18
<b>Other Property</b>			
Water Absorption (24hrs)	%	ASTM D570	0.21
Water Absorption (72hrs)	%	ASTM D570	0.3
Shore Hardness (3s)	D	ASTM D2240	77
<b>Biocompatibility Property</b>			
Irritation		ISO 10993-23	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

PRO9499-White 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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