



PRO9499-White

Basic Property

Measurement	Unit	Test Method	1x30min in XiP Cure, 2x15min in xCure, 2x7min 50% in xCure Desktop
Tensile Property			
Young's Modulus	MPa	ASTM D638	1500
Ultimate Tensile Strength	MPa	ASTM D638	40
Elongation at Break	%	ASTM D638	8
Flexural Property			
Flexural Modulus	MPa	ASTM D790	2164
Flexural Stress at Yield	MPa	ASTM D790	95
Flexural Elongation at Break	%	ASTM D790	6.7
Impact Property			
IZOD Impact (Notched)	J/m	ASTM D256	28.7
Thermal Property			
HDT at 1.82 Mpa	°C	ASTM D648	62.6
HDT at 0.45 Mpa	°C	ASTM D648	50.3
General Property			
Viscosity at 25°C (77°F)	cP	ASTM D7867	506
Liquid Density	g/cm ³	ASTM D1475	1.12
Solid Density	g/cm ³	ASTM D792	1.18
Other Property			
Water Absorption (24hrs)	%	ASTM D570	0.21
Water Absorption (72hrs)	%	ASTM D570	0.3
Shore Hardness (3s)	D	ASTM D2240	77
Biocompatibility Property			
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.

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