

## Liquid Material

MEASUREMENT	CONDITION	VALUE
Appearance		Clear
Liquid Density	@ 25 °C (77 °F)	1.13 g/cm <sup>3</sup>
Solid Density	@ 25 °C (77 °F)	1.21 g/cm <sup>3</sup>
Viscosity	@ 30 °C (86 °F)	150- 180 cps
Penetration Depth (Dp)*		6.3 mils
Critical Exposure (Ec)*		7.6 ml/cm <sup>2</sup>
Tested Build Styles		EXACT, FAST, QuickCast

## Post-cured Material

MEASUREMENT	METHOD/CONDITION	METRIC	US
Tensile Strength	ASTM D638	58 - 68 MPa	8410 - 9860 psi
Tensile Modulus	ASTM D638	2690 - 3100 MPa	390 - 450 ksi
Elongation at Break (%)	ASTM D638	5 - 13%	5 - 13 %
Flexural Strength	ASTM D790	87 - 101 MPa	12620 - 14650 psi
Flexural Modulus	ASTM D790	2700 - 3000 MPa	392 - 435 ksi
Impact Strength (notched Izod)	ASTM D256	15 - 25 J/m	0.3 - 0.5 ft-lb/in
Impact Strength (Gardner)	ASTM D5420	1.1 J	0.81 ft-lbs
Heat Deflection Temperature	ASTM D648 @ 66 psi @ 264 psi	53 - 55 °C 48 - 50 °C	127 - 131 °F 118 - 122 °F
Hardness, Shore D			86
Co-efficient of Thermal Expansion	ASTM E 831-93 TMA (T < T <sub>g</sub> , 0-40 °C) TMA (T < T <sub>g</sub> , 75-140 °C)	71 μm/m-°C 153 μm/m-°C	
Glass Transition (T <sub>g</sub> )	DMA, E''	58 °C	136 °F

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