



SLA BLUESTONE

Liquid Material

MEASUREMENT	CONDITION	VALUE
Appearance		Opaque Blue
Liquid Density	@ 25 °C (77 °F)	1.70 g/cm ³
Solid Density	@ 25 °C (77 °F)	1.78 g/cm ³
Viscosity	@ 30 °C (86 °F)	1200 - 1800 cps
Penetration Depth (Dp)*		4.1 mils
Critical Exposure (Ec)*		6.9 ml/cm ²
Tested Build Styles		EXACT

Post-cured Material

MEASUREMENT	METHOD/CONDITION	METRIC	US
Tensile Strength	ASTM D638	66 - 68 MPa	9.6 - 9.8 ksi
Tensile Modulus	ASTM D638	7,600 - 11,700 MPa	1,100 - 1,700 ksi
Elongation at Break (%)	ASTM D638	1.4 - 2.4 %	
Flexural Strength	ASTM D790	124 - 154 MPa	18 - 22.3 ksi
Flexural Modulus	ASTM D790	8,300 - 9,800 MPa	1,200 - 1,417 ksi
Impact Strength (notched Izod)	ASTM D256	13 - 17 J/m	0.24 - 0.32 ft-lb/in
Heat Deflection Temperature	ASTM D648 @ 66 psi @ 264 psi @ 66 psi with 120 °C Thermal Postcure	65 - 66 °C 65 °C 267 - 284 °C	149 - 151 °F 149 °F 513 - 543 °F
Hardness, Shore D		92	
Co-efficient of Thermal Expansion	ASTM E 831-93 TMA (T < Tg, 0-20 °C) TMA (T < Tg, 90-150 °C)	33 - 44 (x 10 ⁻⁶ m/m °C) 81 - 98 (x 10 ⁻⁶ m/m °C)	
Glass Transition (Tg)	DMA, E''	71 - 83 °C	160 - 181 °F

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

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