



Accura[®] 10 plastic

for use with solid-state stereolithography (SLA[®]) systems

Value leading, accurate plastic for general-purpose prototypes & master patterns.



APPLICATIONS

- General use prototyping for many uses, including:
 - Enclosures, covers and cases
 - Cellular/mobile phones
 - Automotive and aerospace design
 - Computers and control displays
- Accurate master patterns for RTV/silicone molding
- QuickCast™ patterns for investment casting
- Models for fluid flow and visualization of internal structures

FEATURES

- Value priced
- Outstanding accuracy
- Stiff and rigid
- Good humidity resistance
- High green strength
- Fully developed and tested build styles

BENEFITS

- Lowers cost per part
- Reproduces CAD data faithfully
- Maximizes reliability with no user R&D
- Parts hold their shape well and resist deformation and distortion
- Parts retain properties well over time

Accura[®] 10 plastic

For use with all solid-state stereolithography (SLA[®]) systems

TECHNICAL DATA

Liquid Material

MEASUREMENT	METHOD/CONDITION	VALUE
Appearance		Clear amber
Liquid Density	@ 25 °C (77 °F)	1.16 g/cm ³
Solid Density	@ 25 °C (77 °F)	1.21 g/cm ³
Viscosity	@ 30 °C (86 °F)	485 cps
Penetration Depth (Dp)	Viper/SLA 3500	6.3 mils
	SLA 5000	6.9 mils
	SLA 7000	6.8 mils
Critical Exposure (Ec)	Viper/SLA 3500	13.8 mJ/cm ²
	SLA 5000	17.7 mJ/cm ²
	SLA 5000	15.5 mJ/cm ²
Tested Build Styles		FAST [™] , EXACT [™] , QuickCast [™] and ThinLayer [™]

Post-Cured Material (at 90 minute UV Curing)

MEASUREMENT	METHOD/CONDITION	METRIC	U.S.
Tensile Strength	ASTM D 638	62 - 76 MPa	9010 - 10940 PSI
Tensile Modulus	ASTM D 638	3048 - 3532 MPa	440 - 510 KSI
Elongation at Break (%)	ASTM D 638	3.1 - 5.6 %	
Flexural Strength	ASTM D 790	89 - 115 MPa	12900- 16600 PSI
Flexural Modulus	ASTM D 790	2827 - 3186 MPa	410 - 460 KSI
Impact Strength (Notched Izod)	ASTM D 256	14.9-27.7 J/m	0.28 - 0.52 ft- lb/in
Heat Deflection Temperature	ASTM D 648		
	@ 66 PSI	58 °C	136 °F
	@ 264 PSI	50 °C	122 °F
Hardness, Shore D	ASTM D 2240		86
Co-efficient of Thermal Expansion	ASTM E 831-93		
	TMA (T<Tg, 0 - 20 °C)	64 x 10 ⁻⁶ m/m °C	
	TMA (T>Tg, 90 - 150 °C)	170 x 10 ⁻⁶ m/m °C	
Glass Transition (Tg)	DMA, E"	62 °C	143 °F



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