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STEREOLITHOGRAPHY

Accura[®] ClearVue[™] Material



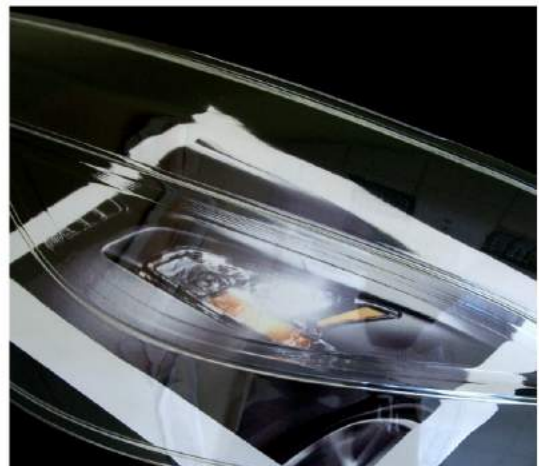
Simulate the properties and appearance of Polycarbonate and ABS with this durable clear plastic.

Applications

- General purpose prototyping
- Models requiring high clarity
 - Headlamps and lenses
 - Fluid flow and visualization models
 - Transparent assemblies
- Snapfits and complex assemblies
- Medical models and medical devices

Benefits

- The highest clarity and transparency
- Durable and strong
- Humidity and moisture stable
- USP class VI capable





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



Technical Data

Liquid Material

Measurement	Condition	Value
Appearance		Clear/Transparent
Liquid Density	@ 25 °C (77 °F)	1.1 g/cm ³ at 25°C
Solid Density	@ 25 °C (77 °F)	1.17 g/cm ³ at 25°C
Viscosity	@ 30 °C (86 °F)	235-260 cps
Penetration Depth (Dp)		6.1 mils
Critical Exposure (Ec)		9.5 mJ/cm ²

Post-Cured Material

Measurement	Condition	Metric	U.S.
Tensile Strength	ASTM D 638	46 - 53 MPa	6,700 - 7,700 PSI
Tensile Modulus	ASTM D 638	2,270 - 2,640 MPa	329 - 383 KSI
Elongation at Break (%)	ASTM D 638	3 - 15 %	3 - 15 %
Flexural Strength	ASTM D 790	72 - 84 MPa	10,400 - 12,200 PSI
Flexural Modulus	ASTM D 790	1,980 - 2,310 MPa	287 - 335 KSI
Impact Strength (Izod Notched)	ASTM D 256	40 - 58 J/m	0.70 - 1.1 ft-lb/in
Heat Deflection Temperature	ASTM D 648 @ 66 PSI @ 264 PSI	51 °C 50 °C	124 °F 122 °F
Hardness, Shore D		80	80
Co-efficient of Thermal Expansion	ASTM E 831-93 25-50° C 50-100° C	122 µm/m-°C 155 µm/m-°C	68 µin/in-°F 86 µin/in-°F
Glass Transition (Tg)	DMA, E*	62° C	144° F
Water Absorption	ASTM D 570-98	0.3%	0.3%