

Clear ABS-Like Resin - Technical Data

Advantages:

- Excellent transparency
- Excellent humidity and moisture resistance
- Fast to build and easy to finish
- Accurate and dimensionally stable

Ideal Applications:

- Automotive lenses
- Bottles and tubes
- Tough functional prototypes
- Transparent display models
- Fluid flow analysis

Optical & Liquid Properties:

- Appearance: Clear
- Viscosity: 325-425 cps @ 28°C
- Density: 1.11-1.14 g/cm³ @ 25°C
- Building layer thickness: 0.1-0.15 mm
- Penetration depth (Dp): 0.135-0.155 mm
- Critical exposure (Ec): 9-12 mJ/cm²

Mechanical Properties (After UV Post-Curing):

Measurement	Test Method	Value
Hardness, Shore D	ASTM D 2240	72-78
Flexural modulus (MPa)	ASTM D 790	2,680-2,775
Flexural strength (MPa)	ASTM D 790	65-75
Tensile modulus (MPa)	ASTM D 638	2,170-2,385
Tensile strength (MPa)	ASTM D 638	25-30
Elongation at break (%)	ASTM D 638	12-20%
Impact strength, notched Izod (J/m)	ASTM D 256	58-70
Heat deflection temperature (°C)	ASTM D 648 @66PSI	50-60

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Glass transition (Tg, °C)	DMA, E" peak	55-70
Density (g/cm³)	-	1.14-1.16

Additional Notes:

- The resin is optically transparent and designed for quickly producing clear, functional, and accurate parts.
- Ideal for applications such as transparent assemblies, bottles, tubes, automotive lenses, lighting components.
- Recommended processing and storage temperature: 18°C-25°C.
- Mechanical properties may vary based on machine processing and post-curing practices.