

# Stereolithography Materials (SLA)

## Accura<sup>®</sup> Phoenix

### Features

- ▶ High thermal resistance enhances automotive and other demanding applications
- ▶ Exceptional clarity improves
  - Viewing of hot fluid flow in complex automotive parts
  - Viewing of internal structures in assembly work
- ▶ Moderate stiffness and rigidity improves assembly operations
- ▶ Formulated without addition of antimony



### Post-Cured Material

MEASUREMENT	CONDITION	METRIC (PCA ONLY)	METRIC (THERMAL PC)	U.S. (PCA ONLY)	U.S. (THERMAL PC)
Tensile Strength (MPa/PSI)	D638	45-61	52-77	6530-8850	7540-11170
Tensile Modulus (MPa/KSI)	D638	2340-2640	2620-2940	339-383	380-426
Elongation at Break (%)	D638	3-5 %	2-6 %	3-5 %	2-6 %
Flexural Strength (MPa/PSI)	D790	96-100	123-139	13920-14500	17840-20160
Flexural Modulus (MPa/KSI)	D790	2140-2330	2290-2410	310-338	332-350
Izod impact notched, (J/m ft-lbs/in)	D256	13-19	18-23	0.2-0.4	0.3-0.4
Heat Deflection Temperature	D648				
	@ 66 PSI	83 °C	137 °C	181 °F	279 °F
	@ 264 PSI	64 °C	103 °C	147 °F	217 °F
Hardness, Shore D	D2240	80	80	80	80

### Liquid Material

MEASUREMENT	CONDITION	VALUE
Viscosity	@ 30 °C (86 °F)	120-130 cps
Penetration Depth (Dp)		6.4 mils
Critical Exposure (Ec)		11.7 mJ/cm <sup>2</sup>
Color		Clear/Transparent
Liquid Density	@ 25 °C (77 °F)	1.13 g/cm <sup>3</sup>

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