



Polyjet DETAILS

Layer thickness : 0,032 mm or 0,016 mm (for veroclear)

Standard accuracy : 0,1mm

Digital ABS, Green (RGD5160-DM, RGD5161-DM) made of RGD515 & RGD535
 Digital ABS, Ivory (RGD5130-DM, RGD5131-DM) made of RGD515 & RGD531

	ASTM	Units	Metric	Units	Imperial
Tensile strength	D-638-03	MPa	55-60	psi	8000-8700
Elongation at break	D-638-05	%	25-40	%	25-40
Modulus of elasticity	D-638-04	MPa	2600-3000	psi	375,000-435,000
Flexural Strength	D-790-03	MPa	65-75	psi	9,500-11,000
Flexural Modulus	D-790-04	MPa	1700-2200	psi	245,000-320,000
HDT, °C @ 0.45MPa	D-648-06	°C	58-68	°F	136-154
HDT, °C @ 0.45MPa after thermal post treatment procedure A	D-648-06	°C	82-90	°F	180-194
HDT, °C @ 0.45MPa after thermal post treatment procedure B	D-648-06	°C	92-95	°F	198-203
HDT, °C @ 1.82MPa	D-648-07	°C	51-55	°F	124-131
Izod Notched Impact	D-256-06	J/m	65-80	ft lb/inch	1.22-1.50
Tg	DMA, E»	°C	47-53	°F	117-127
Shore Hardness (D)	Scale D	Scale D	85-87	Scale D	85-87
Rockwell Hardness	Scale M	Scale M	67-69	Scale M	67-69
Polymerized density	ASTM D792	g/cm3	1.17-1.18		



VeroClear RGD810

	ASTM	Units	Metric	Units	Imperial
Tensile strength	D-638-03	MPa	50-65	psi	7250-9450
Elongation at break	D-638-05	%	10-25	%	10-25
Modulus of elasticity	D-638-04	MPa	2000-3000	psi	290,000-435,000
Flexural Strength	D-790-03	MPa	75-110	psi	11000-16000
Flexural Modulus	D-790-04	MPa	2200-3200	psi	320,000-465,000
HDT, °C @ 0.45MPa	D-648-06	°C	45-50	°F	113-122
HDT, °C @ 1.82MPa	D-648-07	°C	45-50	°F	113-122
Izod Notched Impact	D-256-06	J/m	20-30	ft lb/inch	0.375-0.562
Water Absorption	D-570-98 24hr	%	1.1-1.5	%	1.1-1.5
Tg	DMA, E»	°C	52-54	°F	126-129
Shore Hardness (D)	Scale D	Scale D	83-86	Scale D	83-86
Rockwell Hardness	Scale M	Scale M	73-76	Scale M	73-76
Polymerized density	ASTM D792	g/cm3	1.18-1.19		
Ash content	USP281	%	0.02-0.06	%	0.02-0.06



VeroGray RGD850, VeroBlackPlus RGD875, VeroWhitePlus RGD835, VeroYellow RGD836, VeroCyan RGD841 , VeroMagenta RGD851

	ASTM	Units	Metric	Units	Imperial
Tensile strength	D-638-03	MPa	50-65	psi	7250-9450
Elongation at break	D-638-05	%	10-25	%	10-25
Modulus of elasticity	D-638-04	MPa	2000-3000	psi	290,000-435,000
Flexural Strength	D-790-03	MPa	75-110	psi	11000-16000
Flexural Modulus	D-790-04	MPa	2200-3200	psi	320,000-465,000
HDT, °C @ 0.45MPa	D-648-06	°C	45-50	°F	113-122
HDT, °C @ 1.82MPa	D-648-07	°C	45-50	°F	113-122
Izod Notched Impact	D-256-06	J/m	20-30	ft lb/inch	0.375-0.562
Water Absorption	D-570-98 24hr	%	1.1-1.5	%	1.1-1.5
Tg	DMA, E»	°C	52-54	°F	126-129
Shore Hardness (D)	Scale D	Scale D	83-86	Scale D	83-86
Rockwell Hardness	Scale M	Scale M	73-76	Scale M	73-76
Polymerized density	ASTM D792	g/cm3	1.17-1.18		
Ash content VeroGray, VeroWhitePlus	USP281	%	0.23-0.26	%	0.23-0.26
Ash content VeroBlackPlus	USP281	%	0.01-0.02	%	0.01-0.02



Rubber-like Materials

TangoBlackPlus FLX980 and TangoPlus FLX930

	ASTM	Units	Metric	Units	Imperial
Tensile strength	D-412	MPa	0.8-1.5	psi	115-220
Elongation at break	D-412	%	170-220	%	170-220
Compressive set	D-395	%	4-5	%	4-5
Shore Hardness (A)	D-2240	Scale A	26-28	Scale A	26-28
Tensile Tear resistance	D-624	Kg/cm	2-4.	Lb/in	18-22
Polymerized density	ASTM D792	g/cm3	1.12-1.13		