

# Technical Data Sheet

## ClearVue Material

For the SLA process



### Features, benefits and applications

- Clear and transparent
- Can be polished to a high finish
- Applications include headlamps and lenses
- Gearbox oil flow visualisation

### Machines

- Available on iPro 8000 machines

Post-Cured Material					
Measurement	Condition	Metric		Imperial	
		Low	High	Low	High
Tensile Strength (MPa/PSI)	ASTM D 638	41	46	5950	6670
Tensile Modulus (MPa/KSI)	ASTM D 638	2030	2220	294	322
Elongation at Break	ASTM D 638	4%	7%	4%	6%
Flexural Strength (MPa/PSI)	ASTM D 790	53	67	7690	9720
Flexural Modulus (MPa/KSI)	ASTM D 790	1560	2040	226	296
Impact Strength (J/m /Ft-lbs/in)	ASTM D 256	43	67	0.81	1.26
Heat Deflection Temperature	ASTM D 648 @ 66 PSI @ 264 PSI	46°C 41°C		115°F 106°F	
Coefficient of Thermal Expansion (CTE)	ASTM E 831-93 <35°C >60°C	70 160		70 160	
Glass Transition (Tg)	DMA, E"	56°C		133°F	
Shore D		84		84	

Liquid Material		
Measurement	Condition	Value
Viscosity	@ 30°C (86°F)	235-260 cps
Penetration Depth (Dp)		6.1 mils
Critical Exposure (Ec)		9.5 mJ/cm <sup>2</sup>
Colour		Clear
Solid Density	@ 25°C (77°F)	1.17 g/cm <sup>3</sup>
Liquid Density	@ 28°C (82°F)	1.10 g/cm <sup>3</sup>



Got a question? Need more technical data?  
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