

IORA Black – Spec Sheet

(to be used on PolyJet® rapid prototyping machines)

Iora Black is a general purpose resin for PolyJet-3D-Printer. It offers a good balance between stiffness and flexibility. Post processing can be done easily.

Mechanical Properties	Value	Test Method
Tensile Modulus	2000-3000 MPa	ASTM D638
Tensile Strength, Ultimate	50-65 MPa	ASTM D638
Tensile Elongation at Break	13-24 %	ASTM D638
IZOD Impact, notched (Method A, 23°C)	20-30 J/m	ASTM D256
Flexural Strength	75-110 MPa	ASTM D790
Flexural Modulus	2200-3200 MPa	ASTM D790

Thermal Properties	Value	Test Method
Heat Deflection (HDT) @ 0,45 MPa	46-51°C	ASTM D648
Heat Deflection (HDT) @ 1,82 MPa	46-51°C	ASTM D648
Glass Transition Temperature (Tg)	52-54°C	DMA

Other Properties	Value	Test Method
Water Absorption (24h)	1,1-1,5%	ASTM D570

The given values are typical values only, which are not intended for design or specification purposes. Test parts were printed on a Stratasys® Eden 260V printer under standard parameters. All parts were printed in flat XY-orientation.

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