

## IORA Clear – Spec Sheet

(to be used on PolyJet® rapid prototyping machines)

Iora Clear is a general purpose resin for PolyJet-3D-Printer. It offers a good balance between stiffness and flexibility. Post processing can be done easily, for example by sanding and polishing, to achieve high surface gloss.

| Mechanical Properties                 | Value         | Test Method |
|---------------------------------------|---------------|-------------|
| Tensile Modulus                       | 2000-3000 MPa | ASTM D638   |
| Tensile Strength, Ultimate            | 50-65 MPa     | ASTM D638   |
| Tensile Elongation at Break           | 15-25 %       | 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  | 45-50°C | ASTM D648   |
| Heat Deflection (HDT) @ 1,82 MPa  | 45-50°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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