

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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