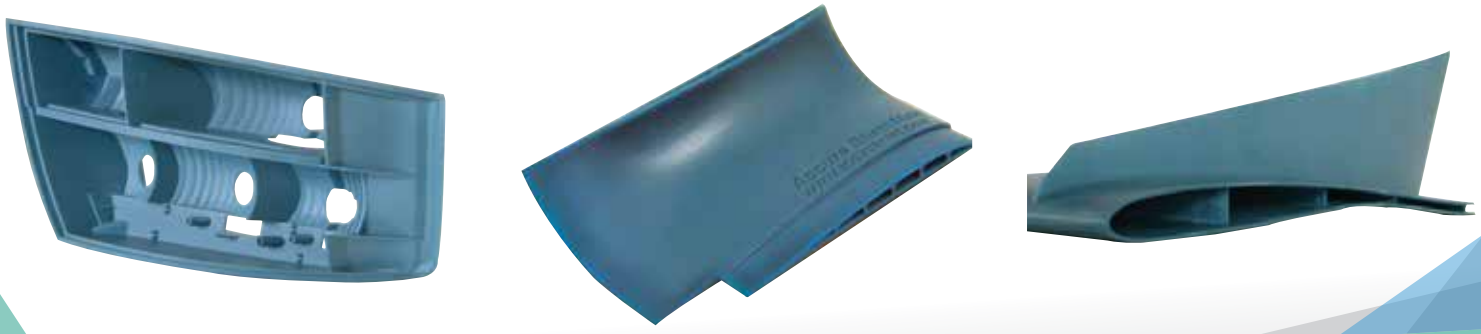

Accura® Bluestone™

Specialty Class

Composite material for manufacturing stable, high stiffness parts

Post-Cured Material

MEASUREMENT	CONDITION	METRIC	U.S.
Tensile Strength (MPa | PSI)	ASTM D 638	66-68	6900-9800
Tensile Modulus (MPa | KSI)	ASTM D 638	7600-11700	1100-1700
Elongation at Break (%)	ASTM D 638	1.4 - 2.4	1.4 - 2.4
Flexural Strength (MPa | PSI)	ASTM D 790	124-154	1800-2230
Flexural Modulus (MPa | KSI)	ASTM D 790	8300-9800	1200-1417
Impact Strength (J/m | ft-lbs/in)	ASTM D 256	13-17	0.24-0.32
Heat Deflection Temperature UV Postcure only UV Postcure only UV + Thermal Postcure (120°C)	ASTM D 648 @ 66 PSI @ 264 PSI @ 66 PSI	65-66 °C 65 °C 267-284 °C	149-151 °F 149 °F 513-543 °F
Coefficient of Thermal Expansion (µm/m-°C | µm/in-°F)	ASTM E 831-93 T<Tg (0-30°C): 33-44 T > Tg (110-150°C): 81-98	33-44 81-98	18.3 - 24.4 45 - 54.4
Glass Transition (Tg)	DMA, E"	51 °C	124 °F
Hardness, Shore D		92	92

Features

- Highest stiffness available
- Heat and abrasion resistant
- Excellent chemical resistance
- Great for windtunnel models, jigs and fixtures

Liquid Material

MEASUREMENT	CONDITION	VALUE
Viscosity	@ 30 °C (86 °F)	1200-1800 cps
Penetration Depth (Dp)		4.1 mils
Critical Exposure (Ec)		6.9 mJ/cm^2
Color		Blue
Solid Density	@ 25 °C (77 °F)	1.78 g/cm^3 at 25 °C
Liquid Density	@ 25 °C (77 °F)	1.70 g/cm^3 at 25 °C
Tested Build Styles		EXACT™

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