

SL 7811

STEREOLITHOGRAPHY MATERIAL

For use on:
Solid State Laser
SLA® Systems

- ABS-like Performance
- Good Durability

DESCRIPTION

SL 7811 stereolithography material is a white, low viscosity stable liquid that produces strong white models and prototypes with good surface finish and detail, an ABS-like appearance.

MEASUREMENT	CONDITION	VALUE
Appearance		White liquid
Density	@ 25°C (77°F)	1.11 g/cm ³
Viscosity	@ 28°C (82°F)	240 cps
Viscosity	@ 30°C (86°F)	210 cps
Penetration depth (Dp)		5.25 mils
Critical exposure (Ec)		10.97 mJ/cm ²
Part building layer thickness*		0.10mm (0.004 in.)

* Dependent upon part geometry and build parameters.

Post-Cured Material

MEASUREMENT	TEST METHOD	VALUE 90-minute UV post-cure	VALUE 90-minute UV + 2 hours @ 80°C (176°F) thermal postcure
Hardness, Shore D	ASTM D-2240	86	86
Flexural modulus	ASTM D-790	1,500-2,200 MPa (220-320 ksi)	1,500-2,000 MPa (220-2900 ksi)
Flexural strength	ASTM D-790	35-54 MPa (5,000-7,800 psi)	33-52 MPa (4,800-7,500 psi)
Tensile modulus	ASTM D-638	1,500-2,000 MPa (220-290 ksi)	1,500-2,000 MPa (220-290 ksi)
Tensile strength	ASTM D-638	34-42 MPa (4,900-6,000 psi)	34-40 MPa (4,900-5,800 psi)
Elongation at break	ASTM D-638	15-30%	15-30%
Impact strength, notched Izod	ASTM D-256	J/m (0.78-1.10 ft.-lb./in.)	J/m (0.80-1.21 ft.-lb./in.)
Heat deflection temperature	ASTM D-648 @ 66 psi @ 264 psi	47°C (117°F) --°C (--°F)	46°C (115°F) --°C (---°F)
Glass transition, Tg	DMA, E" peak	63°C (145°F)	n/a
Coefficient of thermal expansion	TMA (T<Tg) TMA (T>Tg)	92 x 10 ⁻⁶ /°C 207 x 10 ⁻⁶ /°C	n/a
Cured Density		1.15g/cm ³	n/a