



## Material data sheet for plastic parts

### PLASTIC

|                         |  |   |
|-------------------------|--|---|
| Base material           | PMMA particulate material (55 µm)  | PMMA particulate material (85 µm)   |
| Binder-type             | Polypor B (PPB)  | Polypor C (PPC)   |
| Tensile strength        | ≥ 2,0 MPa  | ≥ 2,0 MPa   |
| Yield point             | 1 %  | 1 %   |
| Burn-out temperature    | 700 °C   | 600 °C  |
| Residual ash content    | < 0.01 % weight  | < 0.01 % weight   |
| Especially suitable for | investment casting; design models  | investment casting; architectural models  |
| Advantages              | sharp edges; for highest accuracy and true-to-detail; reusable particle material | burns out well with practically no residual ash content; reusable particle material |

### TECHNICAL DATA PLASTIC PARTS

|                 |                         |
|-----------------|-------------------------|
| Layer thickness | Standard 150 µm         |
| Resolution x, y | up to 600 dpi           |
| Accuracy        | ± 0.4 % (min. ± 0,3 mm) |

### SUITABLE FINISHING TREATMENT

|                       |                                 |                         |
|-----------------------|---------------------------------|-------------------------|
|                       | Wax                             | Epoxy                   |
| Tensile strength      | see base material               | up to 25 MPa            |
| Softening temperature | 73 °C                           | 80 °C                   |
| Burn-out temperature  | see base material               | –                       |
| Characteristics       | smooth liquid-resistant surface | solid material, dyeable |

## ADVANTAGES OF PLASTIC MODELS

- Model sizes up to 1,000x600x500 mm (LxWxH)
- up to 600 dpi print resolution
- Same handling as for conventional wax parts after wax infiltration
- No shell cracking due to negative coefficient of thermal expansion.
- Suitable for autoclaves, even for thin-walled shells
- Low residual ash content
- No heat distortion as hardening process is purely a chemical process
- Coloured display models through epoxy infiltration

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