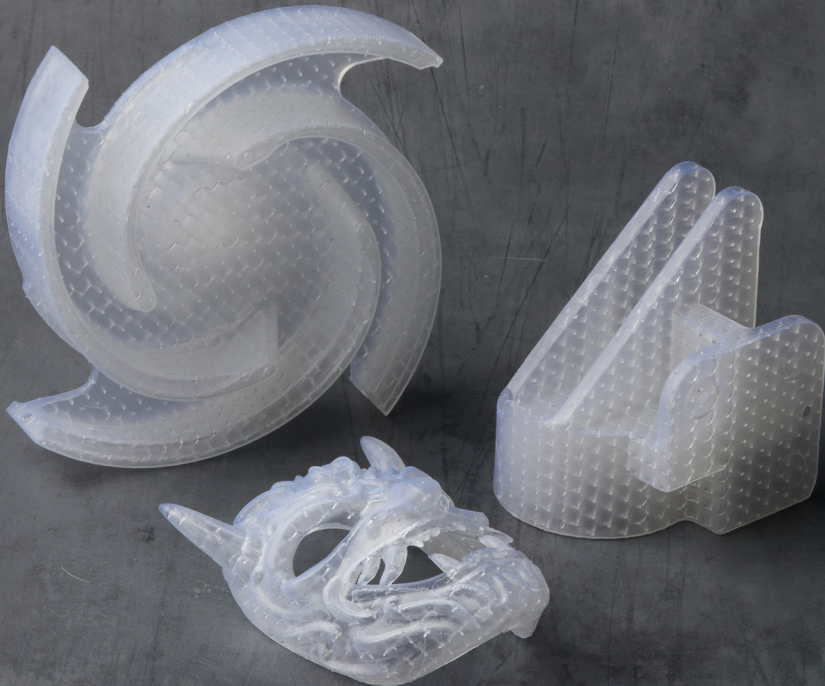


Clear Cast Resin

3D Print Accurate, Low Ash Patterns for Investment Casting Directly in House

Clear Cast Resin is a resin designed for investment casting, to directly print patterns that can be invested and cast. It has an extremely low thermal expansion, low ash, and antimony free with no trace heavy metals.

Patterns for investment casting



FLCCCL01

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To the best of our knowledge the information contained herein is accurate. However, Formlabs, Inc. makes no warranty, expressed or implied, regarding the accuracy of these results to be obtained from the use thereof.

Material Properties	METRIC ¹		IMPERIAL		METHOD
	Green	Post-Cured	Green	Post-Cured	
Mechanical Properties	METRIC ¹		IMPERIAL		METHOD
Ultimate Tensile Strength	38 MPa	65 MPa	5510 psi	9380 psi	ASTM D638-14
Tensile Modulus	1.6 GPa	2.8 GPa	234 ksi	402 ksi	ASTM D638-14
Elongation at Break	12%	6%	12%	6%	ASTM D638-14
Flexural Modulus	1.3 GPa	2.2 GPa	181 psi	320 psi	ASTM D790-15
Notched Izod	16 J/m	25 J/m	0.3 ft-lb/in	0.46 ft-lb/in	ASTM D256-10
Thermal Properties	METRIC ¹		IMPERIAL		METHOD
Thermal Expansion, -30-140°C	-	94.8 µm/m/°C	-	52.6 µin/in/°F	ASTM E831-19
Heat Deflection Temp. @ 1.8 MPa	43 °C	58 °C	109 °F	137 °F	ASTM D648-16
Heat Deflection Temp. @ 0.45 MPa	50 °C	73 °C	121 °F	163 °F	ASTM D648-16
Burnout Characteristics	METRIC ¹		IMPERIAL		METHOD
Ash Content	-	<0.020%	-	<0.020%	ASTM D2584-18
Antimony ²	-	<10 ppm	-	<10 ppm	ASTM E1479-16
Detected Transition Metals (>10 ppm)	-	Al, Cu	-	Al, Cu	ASTM E1479-16
High Concentration Transition Metals (>50 ppm)	-	none	-	none	ASTM E1479-16

Clear Cast Resin TGA Trace

