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Flex HD

Flexible resin has elastomeric properties the parts are pliable when thin and resilient when thick. Flexible has compression characteristics that make it great for creating parts like custom grips, stamps, keypads, gaskets and wearable prototypes. It does not shatter upon failure making it ideal for high impact applications.

Material properties:

	METRIC ¹		IMPERIAL ¹		METHOD
	Green ²	Postcured ³	Green ²	Postcured ³	
Mechanical Properties					
Tensile Strength at yield	3.3 – 3.4 MPa	7.7 – 8.5 MPa	483 – 494 psi	1110 – 1230 psi	ASTM D412-06 (A)
Elongation at Failure	60%	75 – 85%	60%	75 – 85%	ASTM D412-06 (A)
Compression Set	0.40%	0.40%	0.40%	0.40%	ASTM D395-03 (B)
Tear Strength	9.5 – 9.6 kN/m	13.3 – 14.1 kN/m	54 – 55 lbf/in	76 – 80 lbf/in	ASTM D624-00
Shore Hardness	70 – 75 A	80 – 85 A	70 – 75 A	80 – 85 A	ASTM 2240
Thermal Properties					
Vicat Softening Point	231 °C	230 °C	448 °F	446 °F	ASTM D1525-09

NOTES:

¹Material properties can vary with part geometry, print orientation, print settings and temperature.

²Data was obtained from parts printed using 100 um, Flexible settings and post-cured with 290 J/cm² of fluorescent bulb UV light, centered at 365 nm.

³Tensile testing was performed after 3+ hours at 23 °C, using a Die C dumbbell and 20 in/min cross head speed.

⁴Compression testing was performed at 23 °C after aging at 23 °C for 22 hours.

⁵Tear testing was performed after 3+ hours at 23 °C, using a Die C tear specimen and a 20 in/min cross head speed.

⁶Thermal testing was performed after 40+ hours with a 10 N loading at 50 °C/hour. Cracks formed in samples during testing.



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SOLVENT COMPATIBILITY

G = Good resistance.

Parts exposed to this solvent should not experience a decrease in mechanical properties. ($\leq 1\%$ weight gain, $\leq 1\%$ width increase over 24 hours for a 1 x 1 x 1 cm cube)

A = Acceptable resistance.

Parts exposed to this solvent may experience a small decrease in mechanical properties. (1 – 2% weight gain, 1 – 2% width increase over 24 hours for a 1 x 1 x 1 cm cube)

X = Unacceptable resistance.

Parts exposed to this solvent will experience a significant decrease in mechanical properties as well as visible degradation. ($> 2\%$ weight gain, $> 2\%$ width increase over 24 hours for a 1 x 1 x 1 cm cube)

Material	GREEN	POST CURED
Acetic Acid, 5%	A	A
Acetone	X	X
Bleach (~5% NaOCl)	G	A
Butyl Acetate	X	X
Diethyl glycol monomethyl ether	X	X
Hydrogen Peroxide (3%)	A	A
Isooctane	G	G
Isopropyl alcohol	X	X
Sodium hydroxide (0.025%, pH = ~10)	A	G
Salt Water (3.5% NaCl)	G	G
Water	G	G
Xylene	X	X