

AM plastic materials

Technical Data

Parameter	HiPAC (SLS)	HiDEF-12 (SLS)	Accura® HPC PIV (SLA)	Accura® Xtreme (SLA)
Color	Dark grey, anthracite	White, dyeable	Purple	Grey
Sintered at 25°C [g/cm³]	1.2	0.93	-	-
Density at 25°C [g/cm³]	-	-	1.61	1.19
Melting point [°C]	179 ±2	177±3	-	-
Heat Resistance [°C]	169 ±3	163 ±2	250 ±5 (Nachbehandelt)	54
Glass transition temperature [°C]	-	67 ± 5	-	-
Build Volume	700 x 380 x 580 mm ³	500 x 330 x 400 mm ³	650 x 750 x 480 mm ³	650 x 750 x 480 mm ³
X-direction				
Young's modulus tensile [MPa]	6700	1650	9587 ± 218	1368 ± 50
Tensile strength [MPa]	65 ±4	48	75 ±8	11 ±2
Elongation at break [%]	2.6 ±0.3	18	1.4 ± 0.2	5.5 ± 1.5
Y-direction				
Young's modulus tensile [MPa]	3542 ±142	1650	9388 ± 179	1236 ± 80
Tensile strength [MPa]	46 ± 2	48	67 ± 5	25 ± 1
Elongation at break [%]	3.7 ± 0.3	18	1.3 ± 0.2	6.5 ± 1
Z-direction				
Young's modulus tensile [MPa]	2900 ±130	1650	9947 ± 143	1352 ± 50
Tensile strength [MPa]	34 ± 2	42	38 ± 2	28 ± 1
Elongation at break [%]	2.2 ± 0.4	4	0.5 ± 0.1	15 ± 1.5