



## Polyjet Specifications

Last Revised: 17 April, 2007

Material	FullCure 720	FullCure 970 Tango Black	FullCure 950 Tango Gray	FullCure 930 Tango Plus
Color	Amber	Black	Gray	Amber
Machine	Objet Eden 500V	Objet Eden 500V	Objet Eden 500V	Objet Eden 500V
Standard Finish Level	Matte	Matte	Matte	Matte
Build Envelope (in.)	19.3 x 15.4 x 7.9	19.3 x 15.4 x 7.9	19.3 x 15.4 x 7.9	19.3 x 15.4 x 7.9
<b>Typical Properties : Cured Resin</b>				
Density g/cc	1.092			
Tear Strength (KG/cm)	n/a	3.8	9.5	3.47
Tensile Strength ASTM D638 psi (Mpa)	6134 (42.3)	290 (2.0)	632 (4.36)	218 (1.5)
Modulus of Elasticity ASTM D638 psi (Mpa)	290,000 (2000)	n/a	n/a	n/a
Elongation at Break ASTM D538	15% - 25%	47%	47%	218%
Flexural Strength ASTM D790 psi (Mpa)	10,237 (70.6)	n/a	n/a	n/a
Flexural Modulus ASTM D790 psi (Mpa)	286,810 (1978)	n/a	n/a	n/a
Notched Izod Impact Strength ASTM D256 (ft-lb/in) J/m	3625 - 5510 (0.5-0.7)	n/a	n/a	n/a
Hardness Shore Scale	81 D	61 A	75 A	27A
Compression Strength ASTM D695 psi (Mpa)	10,063 (69.4)	n/a	n/a	n/a
Heat Deflection Temperature ASTM D648 @ 66psi	110° F (43° C)	n/a	n/a	n/a
Heat Deflection Temperature ASTM D648 @ 264psi	115° F (46° C)	n/a	n/a	n/a

Typical tolerances for Shore D Polyjet parts are +/- .005" total for dimensions less than 5". For dimensions larger than 5", we hold +/- .0015 inch per inch.

Floor thicknesses should be a minimum of .010" to build in the 720 material, .030" thick to build in Tango Gray and Tango Plus, and .050" thick to build in Tango Black.

Shore A materials, particularly the Tango Black, have a relatively low resistance to tearing. These parts are best used in a compression application (O-rings, gaskets, etc) where they don't receive a lot of stress. They are not recommended for applications where the part needs to stretch or deform repeatedly. The TangoPlus is the most elastic, and most resistant to tearing, of all the Tango materials.

Please ask your Project Manager or Sales Manager for any geometry-specific questions or process recommendations, and to obtain a sample.