

# Ultracur3D® EL 60

Flexible | 75 A | Clear

## Extended TDS

Complete Technical Documentation  
and Testing Summary



Version: 1.0

# Contents

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Technical Data Sheet .....	3
Industrial Chemical Resistance.....	5
Dynamic Mechanical Analysis (DMA).....	7
Biocompatibility.....	8
Sterilization.....	9

# Technical Data Sheet

**Flexible resin with quick elastic response and low hardness (Shore 75 A).**

General Properties	Norm	Typical Values
Appearance	-	Clear
Viscosity, 25°C	Cone/Plate Rheometer <sup>1)</sup>	4900 mPas
Viscosity, 30°C	Cone/Plate Rheometer <sup>1)</sup>	3400 mPas
Density (Printed Part)	ASTM D792	1.12 g/cm <sup>3</sup>
Density (Liquid Resin)	ASTM D4052-18a	1.08 g/cm <sup>3</sup>
Tensile Properties <sup>2)</sup>	Norm	Typical Values
Ultimate Tensile Strength	ASTM D412 C	9 MPa
Elongation at Break	ASTM D412 C	95%
Impact Properties	Norm	Typical Values
Unnotched Izod, 23°C	ASTM D256	No break
Mechanical Properties	Norm	Typical Values
Tear Strength (Graves)	ASTM D624 type C	18 N/mm
Tear Strength (Trouser)	ASTM D624 type T	3 kN/m
Rebound Resilience	ASTM D7121	21%
Relative Abrasion Loss	ISO 4649	781 mm <sup>3</sup>
Compression set at 23°C, 72h (constant force)	ASTM D395-A	3%
Compression set at 23°C, 72h (constant deflection)	ASTM D395-B	9%
Rosflex, 23°C, 60° angle	ASTM D1052 (2 mm)	>10.000 Cycles (no crack propagation)

The data contained in this publication is based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, this data does not relieve processors from carrying out their own investigations and tests; neither does this data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose.

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Thermal Properties	Norm	Typical Values
Glass transition temperature (DMA, tan(d))	ASTM D4065	29°C

Biocompatibility	Norm	Typical Values
Cytotoxicity – Neutral Red	ISO 10993-5 (2009)	PASS <sup>4)</sup>
Human Skin Irritation <sup>3)</sup>	ISO 10993-10 (2013)	PASS <sup>4)</sup>
In vitro Sensitization Testing-KeratiSens™	prEN ISO 10993-10 (2020)	PASS <sup>4)</sup>

Other	Norm	Typical Values
Hardness Shore A	ASTM D2240	75
Water Absorption, Short-Term (24 hours)	ASTM D570	1.12%

## Mechanical properties overview

- 1) Determined with TA-Instrument DHR rheometer, cone/plate, diameter 60 mm, shear rate 100 s<sup>-1</sup>
- 2) Pulling speed 500 mm/min
- 3) Patch test on 30 volunteers
- 4) For the statement on Biocompatibility data see Chapter: [Biocompatibility](#).
- 5) If not noted otherwise, all specimens are 3D printed. Samples were tested at room temperature, 23°C. ASTM sample size (L x W x H): D256 63 x 3.2 x 12 mm, ASTM D1052 150 x 2 x 20 mm

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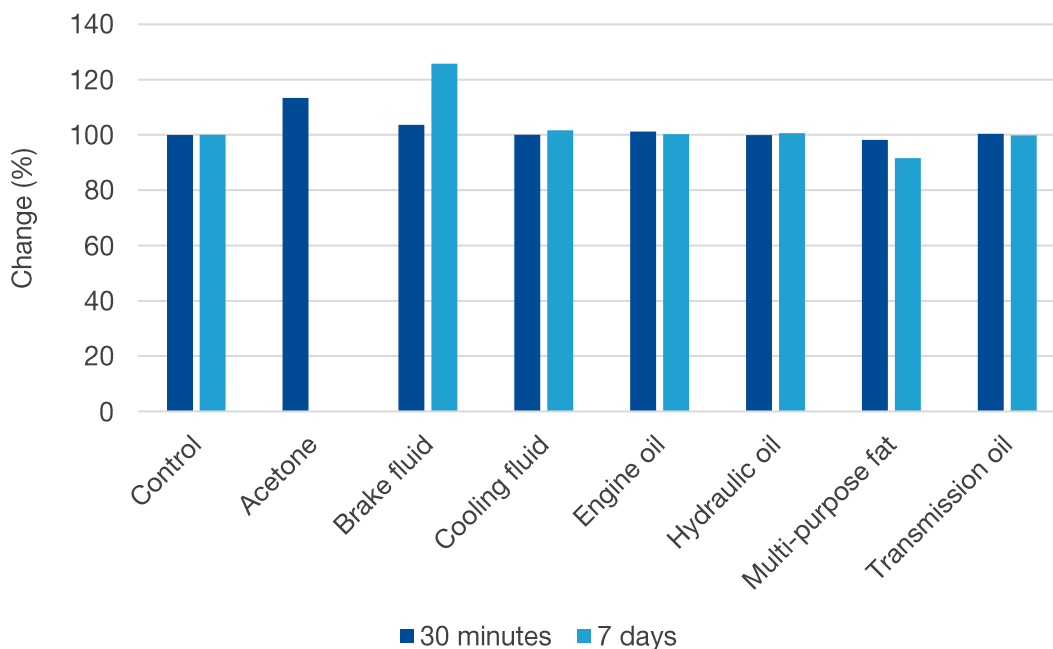
# Industrial Chemical Resistance

The resistance of resin materials against chemicals, solvents and other contact substances is an important criterion of selection for many industrial applications. General chemical resistance depends on the period of exposure, the temperature, the quantity, the concentration and the type of the chemical substance. When exposed to industrial chemicals, the chemical bonds of photopolymers can break or degrade, causing a change in the mechanical properties.

## Test Method and Specimens

ASTM D412 C tensile bars were soaked in each fluid at room temperature, one set for 30 minutes and one set for 7 days. Upon completion of the soaking time, the parts were removed from the test fluid and were dried to measure the weight and the mechanical properties.

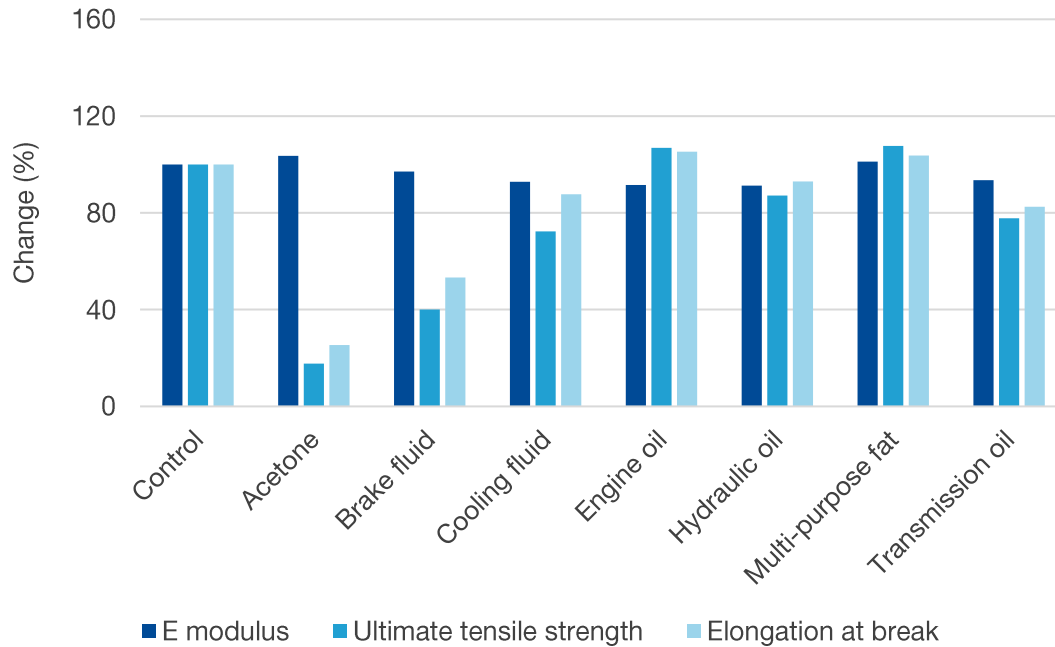
## Weight Measurement



*Change in weight after immersion time*

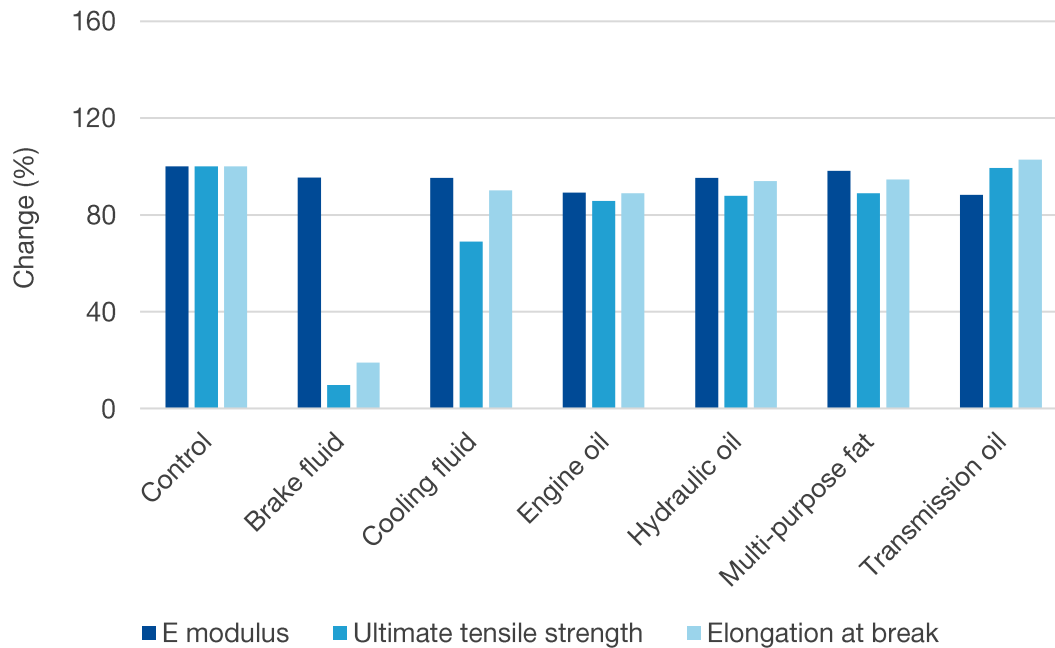
## Mechanical Testing

### 30 minutes



*Change in mechanical properties after 30 minutes immersion*

### 7 days



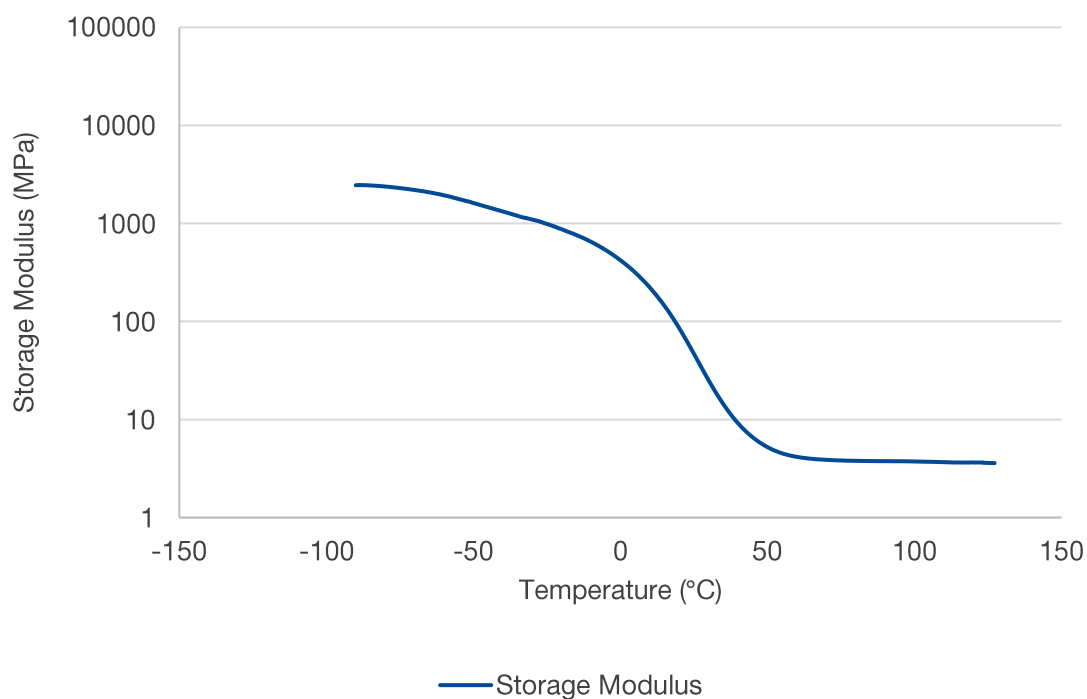
*Change in mechanical properties after 7 days immersion*

# Dynamic Mechanical Analysis (DMA)

In this DMA measurement, a cyclic strain is applied to the sample, and the response of the sample is recorded as a function of temperature. This can give a good impression of the changes in material behavior, both at low and high temperatures. The measured Storage modulus is a good indication of the stiffness of the material. The maximum in Tan Delta gives the glass transition temperature.

	Setting
Measurement	Strain-controlled
Temperature sweep	3°C / min
Strain	0.12% (linear viscoelastic regime)
Type of loading	Single cantilever
Frequency	1 Hz

*Testing conditions DMA*



*DMA curve*

# Biocompatibility

**Product: Ultracur3D® EL 60**

Revision: 05<sup>th</sup> of May 2021

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**3D printed test items of the above stated product have fulfilled the requirements of tests as stated below:**

**Cytotoxicity Testing- Neutral Red:**

(ISO 10993-5 (2009))

**Human Skin Irritation Test:**

(ISO 10993-10 (2013))<sup>6)</sup>

**In vitro Sensitization Testing- KeratinoSens™**

(prEN ISO 10993-10 (2020))

<sup>6)</sup> Patch test on 30 volunteers

The biocompatibility tests were recorded on test specimen of the above referenced product to show compatibility of the material in general. The biocompatibility tests listed are not part of any continuous production protocol. The test assessments reflect only the test specimen and have to be retested on the final product. It remains the responsibility of the device manufacturers and /or end-users to determine the suitability of all printed parts for their respective application.

**For notice:**

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# Sterilization

Sterilization is an essential requirement in many applications especially when used in the medical field. Testing not only ensures the material quality but also determines how effectively the chosen sterilization process is eliminating potential microorganisms.

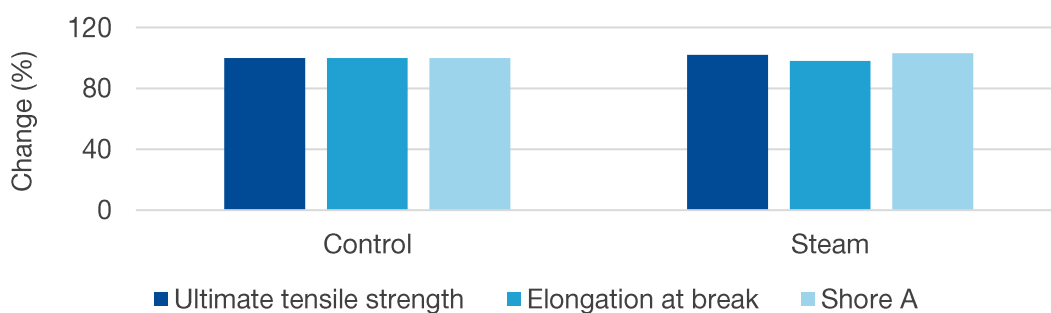
## Test Method and Specimens

### Steam Sterilization

Steam sterilization parameters	Settings
Vacuum pulses	4
Temperature	134°C
Pressure	210 kPa
Holding time	4 minutes
Drying time	20 minutes

*Testing conditions steam sterilization*

### Mechanical Testing



*Change in mechanical properties after sterilization*

### Coloration



*Color samples before and after sterilization*