

Stereolithography (SL) Material:

Accura® Bluestone™

For use with the Viper™ SLA® system, SLA 5000 and SLA 7000 systems.



A breakthrough nano-composite engineering material that opens up new fields of application for SLA system owners.

Features & Benefits:

An engineered, non-settling nano-composite formulation.

- No additional expensive mixing equipment necessary
- Minimal stirring required
- Processes like traditional SL resins
- Produces a part with consistent mechanical properties throughout

Parts have exceptional stiffness and thermal resistance.

- Significantly broadens the range of applications for SL parts
- Improves and enhances applications such as scaled wind tunnel models
- Can be used in aggressive thermal environments — up to 250°C (480°F)

Low shrinkage and good humidity resistance.

- Excellent part accuracy
- Good long-term dimensional stability increases part life

Excellent surface finish and sidewall quality.

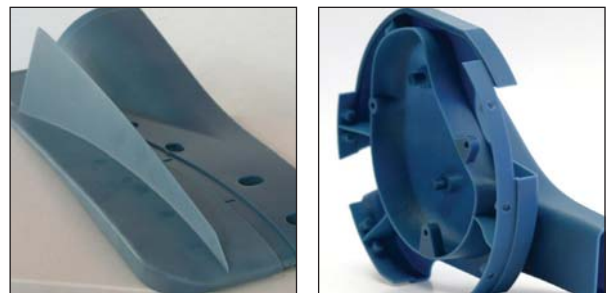
- Only minimal post-processing is required for superb quality parts

Build styles fully tested and developed by 3D Systems.

- Highly reliable and consistent builds for high productivity

Applications:

- Wind tunnel testing for the motorsports and aerospace industries
- Production of CMM/inspection and assembly jigs and fixtures
- Lighting design and other applications where heat generated by electrical components may be a factor
- Covers and enclosures of electrical and mechanical components
- Water-handling products, such as pump and impeller design or other components
- Automotive "under-the-bonnet" applications
- Housings and enclosures that require high stiffness and rigidity, such as those for business machines
- Electronic applications, such as insulating components, connectors, adaptor fittings, bases, sockets and areas where ceramics might be used



Aerodynamic and functional parts produced with Bluestone SL material. Image (right) courtesy of the Renault F1 Team.

Expert Testimonial

"Bluestone resin is an excellent fit for applications requiring added stiffness and thermal resistance. This material is perfect for applications in aerodynamics, lighting applications (such as reflectors) and masters for vacuum casting and thermoforming. As a service provider, we need to have flexibility in our material offerings, and Bluestone resin allows us to fulfil many customers' needs for a variety of applications. Now we can offer our customers a unique material with improved part quality and functionality."

Rainer Neumann, General Manager, 4D Concepts GmbH.

Specifications – Accura Bluestone SL material

For use with the Viper SLA system, SLA 5000 and SLA 7000 systems.

Liquid Material

MEASUREMENT	CONDITION	VALUE:
Appearance		Opaque blue
Liquid Density	@ 25°C (77°F)	1.78 g/cm ³
Solid Density	@ 25°C (77°F)	1.78 g/cm ³
Viscosity	@ 30°C (86°F)	1200 - 1800 cps
Penetration Depth (Dp) *		4.1 mils
Critical Exposure (Ec) *		6.9 mJ/cm ²
Tested Build Styles		EXACT™

Post-cured Material

MEASUREMENT	CONDITION	VALUE:	VALUE:
Tensile Strength	ASTM D 638	66 - 68 MPa	9,600 - 9,800 PSI
Tensile Modulus	ASTM D 638	7,600 - 11,700 MPa	1,100,000 - 1,700,000 PSI
Elongation at Break (%)	ASTM D 638	1.4 - 2.4 %	
Flexural Strength	ASTM D 790	124 - 154 MPa	18,000 - 22,300 PSI
Flexural Modulus	ASTM D 790	8,300 - 9,800 MPa	1,200,000 - 1,417,000 PSI
Impact Strength (Notched Izod)	ASTM D 256	13 - 17 J/m	0.24 - 0.32 ft-lbs/in
Heat Deflection Temperature	ASTM D 648		
	@ 66 PSI	65 - 66°C	149 - 151°F
	@ 264 PSI	65°C	149°F
	@ 66 PSI with Thermal Postcure	267 - 284°C	513 - 543°F
Hardness, Shore D		92	
Co-efficient of Thermal Expansion	ASTM E 831-93		
	TMA (T<T _g , 0 - 20°C)	33 - 44 (x 10 ⁻⁶ m/m °C)	
	TMA (T>T _g , 90 - 150°C)	81 - 98 (x 10 ⁻⁶ m/m °C)	
Glass Transition (T _g)	DMA, E''	71 - 83°C	160 - 181°F

* Dp/Ec values are the same on all systems.



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