



Accura® Bluestone™

Specialty Class

Composite material for manufacturing stable, high stiffness parts

Post-Cured Material

MEASUREMENT	CONDITION	METRIC	U.S.
Tensile Strength (MPa PSI)	ASTM D 638	66-68	9500-9800
Tensile Modulus (MPa KSI)	ASTM D 638	7600-11700	1100-1700
Elongation at Break (%)	ASTM D 638	1.4 - 2.4	1.4 - 2.4
Flexural Strength (MPa PSI)	ASTM D 790	124-154	18000-22300
Flexural Modulus (MPa KSI)	ASTM D 790	8300-9800	1200-1417
Impact Strength (J/m ft-lbs/in)	ASTM D 256	13-17	0.24-0.32
Heat Deflection Temperature UV Postcure only UV Postcure only UV + Thermal Postcure (120°C)	ASTM D 648 @ 66 PSI @ 264 PSI @ 66 PSI	65-66 °C 65 °C 267-284 °C	149-151 °F 149 °F 513-543 °F
Coefficient of Thermal Expansion ($\mu\text{m}/\text{m}\cdot^{\circ}\text{C}$ $\mu\text{m}/\text{in}\cdot^{\circ}\text{F}$)	ASTM E 831-93 T < T _g (0-30°C): 33-44 T > T _g (110-150°C): 81-98	33-44 81-98	18.3 - 24.4 45 - 54.4
Glass Transition (T _g)	DMA, E''	51 °C	124 °F
Hardness, Shore D		92	92

Liquid Material

MEASUREMENT	CONDITION	VALUE
Viscosity	@ 30 °C (86 °F)	1450 cps
Penetration Depth (Dp)		4.1 mils
Critical Exposure (Ec)		6.9 mJ/cm ²
Color		Blue
Solid Density	@ 25 °C (77 °F)	1.78 g/cm ³ at 25 °C
Liquid Density	@ 25 °C (77 °F)	1.70 g/cm ³ at 25 °C
Tested Build Styles		EXACT™

Features

- Highest stiffness available
- Heat and abrasion resistant
- Excellent chemical resistance
- Great for windtunnel models, jigs and fixtures



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