



CPS IC163 Investment Casting Resin

Technical Data Sheet

General Information

CPS IC 163 is a fully formulated resin that is tuned to print on a variety of SLA and DLP 3D printers to create reliable prints with high resolution, good handling characteristics, and burns out cleanly. IC 163 is offered in Orange.

Product Data

		Method
Viscosity (cps @ 25 °C)	200	Brookfield SP #31
Density (g/mL)	1.12	

	Post-Cured Properties	
Tensile Modulus (mPa)	610	ASTM D 638-14
Tensile Strength (mPa)	24	ASTM D 638-14
Elongation (%)	5.1	ASTM D 638-14

Print Conditions

Prints in Open Mode (Grey V4) on the Form2
Prints on Ember at 2.2s per layer.

Post Cure Procedure

For best results post cure under broadband UV light for 10 minutes

Storage and Handling

CPS IC163 stable for at least 1 year at ambient conditions.

This product is light sensitive and should not be exposed to daylight, UV light and artificial lighting during storage.

Exposure to daylight, UV light and artificial lighting should be kept to a minimum during handling.

Burnout Procedure

After thoroughly post curing the parts, the recommended cycle is:

- 150 °C for 2 hrs
- 450 °C for 5 hrs
- 750 °C for 3 hrs
- Casting temperature

To the best of our knowledge the information contained herein is accurate. However, CPS makes no warranty, expressed or implied, regarding the accuracy of these results to be obtained from the use thereof.