



CPS IC163-LCD Investment Casting Resin

Technical Data Sheet

General Information

CPS IC163-LCD is a fully formulated resin that is tuned to print on a variety of LCD 3D printer to create a polymer that is easy to handle and burns out cleanly.

Product Data

		Method
Viscosity (cps @ 25 °C)	200	Brookfield SP #31
Bulk Properties		
Tensile Modulus (mPa)	610	ASTM D 638-14
Tensile Strength (mPa)	24	ASTM D 638-14
Elongation (%)	5	ASTM D 638-14
Shore Hardness	82 D	

**Parts were post-cured with a Broadband UV light source at 10 mW/cm² for 10 minutes each side.*

**Properties may vary with orientation and post-treatment.*

Print Settings

CPS IC163-LCD is recommended 60s for first layers, and 5-9 seconds for the model layers, depending on the printer.

Post Cure Procedure

Post curing is not necessary, but may improve surface quality. For best results post cure uniformly under broadband light at 30 mW/cm² for 10 minutes, then anneal 5°C above working temperature for 1 hr

Storage and Handling

CPS IC163-LCD stable for up to 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.