

IC732

PRO14732-Casting Resin

Technical Data Sheet

General Information

IC732 is a high performance 3D printing resin for investment casting applications. It fully melts during burnout and provides for exceptional casting. Printed parts exhibit good handling ability and show excellent detail with an opaque green color.

Product Data

		Method
Viscosity (cps @25 °C)	600	Brookfield SP #31
Bulk Properties		
Tensile Modulus (MPa)	1600	ASTM D 638
Tensile Strength (MPa)	52	ASTM D 638
Elongation (%)	4.4	ASTM D 638
Flexural Modulus (MPa)	1900	ISO4049
Flexural Strength (MPa)	93	ISO4049
CTE (um/m.C)	190	

Print Settings

Monochrome LCD screens (~3 mW/cm²)

- 50 µm layer thickness
- Burn in 80s a layer for 8 layers
- 5s a layer

LCD screens (~0.6 mW/cm²)

- 50 µm layer thickness
- Burn in 80s a layer for 8 layers
- 25s a layer

Post Cure Procedure

Although post curing may not be necessary, users may want to post cure for 2-5 minutes a side using LED or broadband light.

Storage and Handling

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

PRO14732 is versatile and can be burned out in the way that best suits the user! Material will completely burn out after 1 hr at 500 °C, or can be burned out in just a few minutes at temperatures above 1000 °C without a ramp without damaging the investment.