SM472
Tough Material

Technical Data Sheet

General Information
SM472 is formulated to work with DLP and SLA 3D printers using 385-405 nm light. It is specifically tuned to print on the Autodesk Ember printer. SM472 will extend the window lifetime of the Ember and other printers that use PDMS windows. This resin is recommended for applications where some elongation and high modulus are required. SM472 is offered in black.

Chemical Data

<table>
<thead>
<tr>
<th></th>
<th>Fresh Print</th>
<th>Post-cured</th>
<th>Method</th>
</tr>
</thead>
<tbody>
<tr>
<td>Viscosity (cps @ 25 °C)</td>
<td>600</td>
<td></td>
<td>Brookfield SP #31</td>
</tr>
<tr>
<td>Tensile Modulus (mPa)</td>
<td>100</td>
<td>800</td>
<td>ASTM D 638-14</td>
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<tr>
<td>Tensile Strength (mPa)</td>
<td>9</td>
<td>40</td>
<td>ASTM D 638-14</td>
</tr>
<tr>
<td>Elongation (%)</td>
<td>60</td>
<td>40</td>
<td>ASTM D 638-14</td>
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</table>

*Parts were post-cured for 10min a side with a broad spectrum UV light at 30mW/cm2.
*Properties may vary in orientation and post-treatment.

Recommended Ember Print Parameters for 50 µm

First layer
- Wait before exposure: 15 s
- Exposure: 8 s
- Separation and approach velocity: 4 rpm

Burn in layer
- Wait before exposure: 10 s
- Exposure: 4s
- Separation and approach velocity: 4 rpm

Model layer
- Wait before exposure: 3 s
- Exposure: 2.2 s
- Separation and approach velocity: 7 rpm

Print parameters might require modification based on the geometry of the printed part.

Post Cure Procedure
Parts should be post cured under a broad band, UV light for 10 minutes on a side at 30 mW/cm² to bring the parts up to their full properties.

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.