



# 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	6900-9800
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	1800-2230
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 <sub>g</sub> (0-30°C): 33-44 T > T <sub>g</sub> (110-150°C): 81-98	33-44 81-98	18.3 - 24.4 45 - 54.4
Glass Transition (T <sub>g</sub> )	DMA, E''	51 °C	124 °F
Hardness, Shore D		92	92

### Features

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

### Liquid Material

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



Warranty/Disclaimer: The performance characteristics of these products may vary according to product application, operating conditions, or with end use. 3D Systems makes no warranties of any type, express or implied, including, but not limited to, the warranties of merchantability or fitness for a particular use.

© 2020 by 3D Systems, Inc. All rights reserved. Specifications subject to change without notice. 3D Systems, the 3D Systems logo and Accura are registered trademarks and Bluestone is a trademark of 3D Systems, Inc.