

# Accura® Bluestone™

Composite material for manufacturing stable, high stiffness parts



## Technical Data

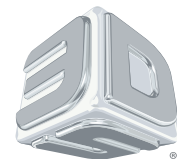
Post-Cured Material			
Measurement	Condition	Metric	U.S.
Tensile Strength (MPa/PSI)	ASTM D 638	66-68	6900-9800
Tensile Modulus (MPa/KSI)	ASTM D 638	7600-11700	1100-1700
Elongation at Break	ASTM D 638	1.4 - 2.4 %	1.4 - 2.4 %
Flexural Strength (MPa/PSI)	ASTM D 790	124-154	1800-2230
Flexural Modulus (MPa/KSI)	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	ASTM D 648		
	UV Postcure only @ 66 PSI	65-66 °C	149-151 °F
	UV Postcure only @ 264 PSI	65 °C	149 °F
	UV + Thermal Postcure (120°C) @ 66 PSI	267-284 °C	513-543 °F
Coefficient of Thermal Expansion (CTE)	ASTM E 831-93		
	TMA (T<Tg, 0-200 °C)	33-44 (x10-6 m/m °C)	18.3 - 24.4 (µin/in °F)
	TMA (T<Tg, 90-150 °C)	81-98 (x10-6 m/m °C)	45 - 54.4 (µin/in °F)
Glass Transition (Tg)	DMA, E"	78-81 °C	172-178 °F
Shore D		92	92

## Liquid Material

Measurement	Condition	Value
Viscosity	@ 30 °C (86 °F)	1200-1800 cps
Penetration Depth (Dp)		4.1 mils
Critical Exposure (Ec)		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™

## Features

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



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