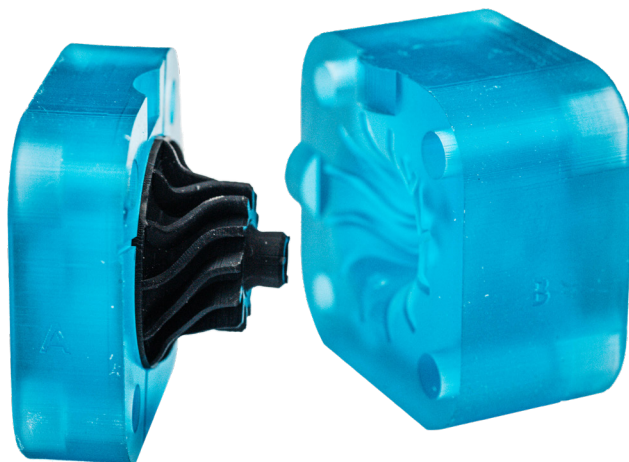




xMOLD

xMOLD is a high-performance dissolvable resin developed for Freeform Injection Molding (FIM). The resin is optimal prototyping injection molding parts without the hassle of complex mold design.



Part Properties

Measurement	Unit	Value	Test Method
Ultimate tensile strength	MPa	38 ± 3	ASTM D638
Young's Modulus	MPa	1152 ± 284	ASTM D638
Tensile stress at break	MPa	31 ± 2	ASTM D638
Hardness (shore D) post curing	Shore D	80	ASTM D2240
Toughness	MPa	18 ± 4	ASTM D638
Thermal conductivity	W/m K	0.187	ISO 22007-2 (2015)
Dissolvability		Fully dissolvable	Submerged in demolding solvent
Color		Transparent blue	Visual

The listed properties are determined by listed test method and based on appropriate test parts printed in xMOLD resin on XiP and post-cured in xCURE for 60min.

Workflow

Validated workflows need to be followed to achieve properties as provided in the TDS. Examples of validated workflow steps are listed below. Users should defer to the most current workflow information for best results which can be found at support.nexa3d.com.

Storage

Store product in the unopened container in a dry location. Optimal Storage: 46°F (8°C) to 70°F (21°C). Storage below 46°F (8°C) or greater than 82°F (28°C) can adversely affect product properties. Material removed from containers may be contaminated during use. Do not return product to the original container.

Post Processing

Parts printed in xMOLD should be cleaned after printing in accordance with FIM cleaning guide.

Post Curing

xMOLD is post cured to achieve listed results.

Additional methods can be found by contacting us at www.nexa3d.com.



Note: The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Nexa3D is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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