



SLA[®] Bluestone

Features & Benefits

- High Heat Deflection
- Resists Temperatures up to 250°C
- High Humidity Resistant
- Excellent Surface Finish
- Long Term Dimensional Stability
- Ideal For:
 - Wind Tunnel Models
 - Functional Models
 - Electronic Applications
 - Water Applications
 - High Heat Applications
 - CMM Fixtures
 - Automotive "Under the Hood" Applications

Additional Information

- Available for Instant Online Quoting
- Maximum Build: 25x29x21in
- Tolerances: +/- .003" for the first 3 inches, +/- .001" for each additional inch
- Minimum Wall Thickness: .030"
- Finish Options Include:
 - Standard
 - Mold / Paint Ready
 - Color Paint (High Heat Resistant Paint)

Liquid Material

MEASUREMENT	CONDITION	VALUE
Appearance		Opaque blue
Liquid Density	@ 25 °C(77 °F)	1.70 g/cm ³
Solid Density	@ 25 °C(77 °F)	1.78 g/cm ³
Viscosity	@ 30 °C(86 °F)	1200-1800 cps
Penetration Depth (Dp)*		4.1 mils
Critical Exposure (Ec)*		6.9 mJ/cm ²
Tested Build Styles		EXACT

Post-cured Material

MEASUREMENT	CONDITION	VALUE
Tensile Strength	ASTM D 638	66-68 MPa (9.6-9.8 KSI)
Tensile Modulus	ASTM D 638	7,600-11,700 MPa (1,100-1,700KSI)
Elongation at Break (%)	ASTM D 638	1.4-2.4%
Flexural Strength	ASTM D 790	124-154 MPa (18-22.3 KSI)
Flexural Modulus	ASTM D 790	8,300-9,800 MPa (1,200-1,417 KSI)
Impact Strength (Notched Izod)	ASTM D 256	13-17 J/m (0.24-0.32 ft-lbs/in)
Heat Deflection Temperature	ASTM D 648	
	@ 66 PSI	65-66 °C(149-151 °F)
	@ 264 PSI	65 °C(149 °F)
	@ 66 PSI with 120 °C Thermal Postcure	267-284 C(513-543 F)
Hardness, Shore D		92
Co-efficient of Thermal Expansion	ASTM E 831-93	
	TMA (T<Tg, 0-20 °C)	33-44 (x 10 ⁻⁶ m/m °C)
	TMA (T<Tg, 90-150 °C)	81-98(x 10 ⁻⁶ m/m °C)
Glass Transition (Tg)	DMA, E"	71-83 °C(160-181 °F)

* Dp/Ec values are the same on all systems.