



SLS[®] Castform

Powder Properties

MEASUREMENT	METHOD/CONDITION	METRIC	US
Density - Tap	ASTM D4164	0.46 g/cm ³	0.46 g/cm ³
Specific Gravity @ 20 °C	ASTM D792	0.86 g/cm ³	0.86 g/cm ³
Moisture Absorption @ 20 °C, 65% R.H.	ASTM D570	0.06 %	0.06 %
Ash Content	ASTM D482	0.02 %	0.02 %

Mechanical Properties

MEASUREMENT	METHOD/CONDITION	METRIC	US
Tensile Strength, Ultimate	ASTM D638	2.84 MPa	412 psi
Tensile Modulus	ASTM D638	1604 MPa	232 ksi
Impact Strength (notched Izod)	ASTM D256	<11 J/m	<0.21 ft- lb/in
Impact Strength (unnotched Izod)	ASTM D256	14 J/m	0.26 ft- lb/in

Thermal Properties

MEASUREMENT	METHOD/CONDITION	METRIC	US
Glass Transition (Tg) - Polystyrene	ASTM D3418	89 °C	192 °F
Melting Point (Mp) - Wax		>63 °C	>145 °F
Flash Point (Cleveland Open Cup)	Polystyrene Wax	350 °C	662 °F
Autoignition Point	Polystyrene	>200 °C	>392 °F
		410 °C	770 °F

Surface Finish

MEASUREMENT	METHOD/CONDITION	METRIC	US
Upward Surface			
As Processed (Ra)	Mitutoyo SurfTest-402	13 µm	13 µm
After Polishing (Ra)	Mitutoyo SurfTest-402	3 µm	3 µm

* Data was generated from the testing of parts produced by an SLS system from CastForm PS material under typical processing conditions. Secondary wax infiltration performed with Red Dip Wax #2-D504.

Features & Benefits

- Low Ash Content
- Low Density
- Ideal For:
 - Investment Casting Master Patterns
 - Complex to Simple Geometries

Additional Information

- Available for Instant Online Quoting
- Maximum Build: 15x13x18in
- Tolerances: +/- .003" for the first 3 inches, +/- .001" for each additional inch
- Minimum Wall Thickness: .035"
- Finish Options Include:
 - Wax Coated