

## OCEANZ DETAILED

### Datasheet for acrylic parts produced by Multi Jet Modelling



MJM is a 3D printing technique that creates parts by selectively placing a photosensitive polymer on a build platform. After placement of the material, the polymer is cured with UV. MJM uses a layer thickness of 32  $\mu\text{m}$ , which results in very detailed printed parts. In addition, the parts have a very smooth surface. This makes this technique very suitable to print products with very thin walls and/or fine details. This material is not suited for long term loading or outdoor use.

The MJM material results in rigid, white and translucent acrylic parts.

Material properties	Value	Unit
Colour	Translucent white	-
Part density	1.14	$\text{g/cm}^3$

Process properties	Value	Unit
Minimum wall thickness	0.1 - 0.2	mm
Layer thickness	32	$\mu\text{m}$
Max. product size	294 x 211 x 144 mm	mm

Mechanical properties	Value	Unit
Tensile modulus	1500 - 2000	MPa
Tensile strength	30 - 35	MPa
Strain at break	55 - 65	%
Flexural modulus	1000 - 1200	MPa
Impact strength	40-50	J/m
Hardness	70	Shore D
Heat deflection temp. @1.8MPa	47	$^{\circ}\text{C}$

Please note that all mentioned mechanical properties are optimum values according to manufacturer. Due to the layer by layer production process and the specific design of each individual product values may differ. *If specific properties and/or dimensions are critical, always contact us so we can inform you how to obtain required specifications!*

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