

| Testing Items          |                           | Testing Method | Typical Value | Unit              |
|------------------------|---------------------------|----------------|---------------|-------------------|
| Viscosity              |                           | ASTM D445      | 300 ~ 400     | mPa·s (25°C)      |
| Density                |                           | ASTM D792      | 1.100 ~ 1.200 | g/cm <sup>3</sup> |
| Color                  |                           | -              | Clear         | -                 |
| Temperature Properties |                           | ASTM D648      | 56.5          | °C (0.45 MPa)     |
| Shore Hardness         |                           | ASTM D2240     | 75            | Shore D           |
| Tensile Properties     | Ultimate Tensile Strength | ASTM D638      | 34.3          | MPa               |
|                        | Tensile Modulus           | ASTM D638      | 2092.6        | MPa               |
|                        | Elongation                | ASTM D638      | 19.3          | %                 |
| Flexural Properties    | Flexural Strength         | ASTM D790      | 69.1          | MPa               |
|                        | Flexural Modulus          | ASTM D790      | 1935.1        | MPa               |
| Impact Properties      | Notched IZOD              | ASTM D256      | 45.87         | J/m               |

**Notes:**

1. It was tested with 3D printed specimen.
2. All test pieces were printed with a Rayshape Shape 1 3D printer.

**Specimens**

Fig 1. Tensile testing specimen

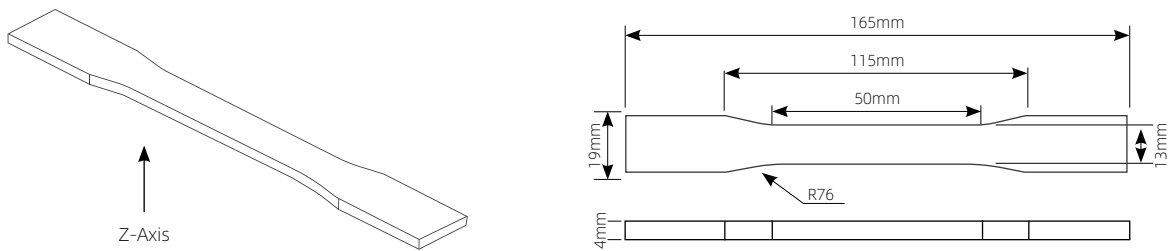


Fig 2. Impact testing specimen

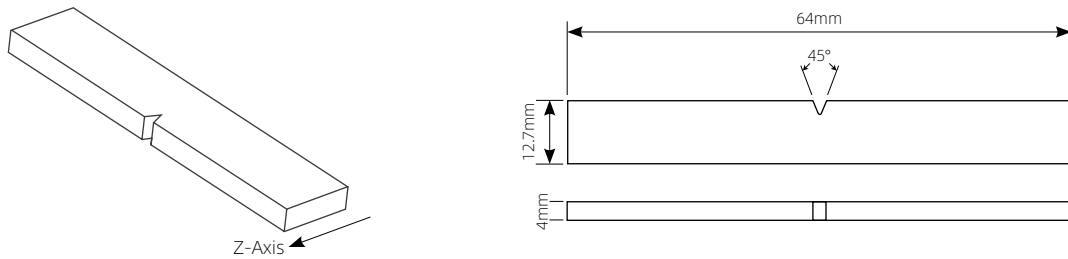
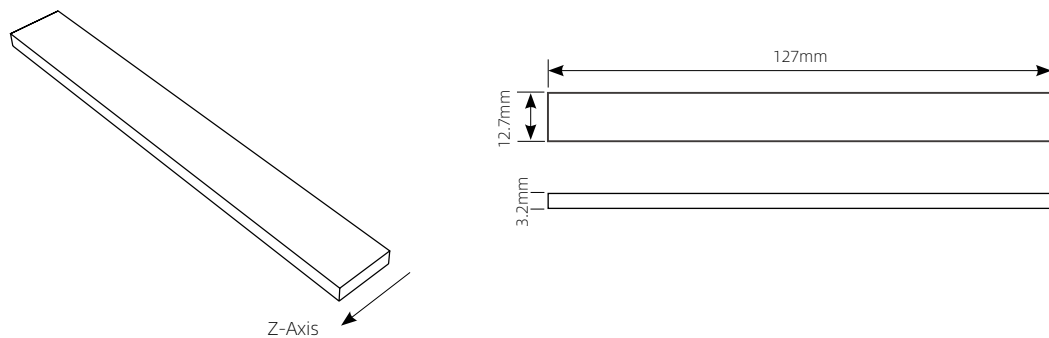


Fig 3. Flexural testing specimen



**Disclaimer**

The typical values presented in this data sheet are intended for reference and comparison purposes only. They should not be used for design specifications or quality control purposes. Actual values may vary significantly with printing conditions. Enduse performance of printed parts depends not only on materials, but also on part design, environmental conditions, printing conditions, test conditions, etc. Product specifications are subject to change without notice.

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