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Technical
Data Sheet

Ultracur3D® EPD 4006

Durable daylight resin with superior toughness
and impact resistance.

General Properties	Norm	Typical Values
Appearance	-	Black
Viscosity, 30 °C	Cone/Plate Rheometer[1]	300 mPas
Viscosity, 50 °C	Cone/Plate Rheometer[1]	100 mPas
Density (printed part)	ASTM D792	1.18 g/cm^3

Tensile Properties	Norm	Typical Values
E Modulus	ASTM D638	1800 MPa
Ultimate Tensile Strength	ASTM D638	45 MPa
Elongation at Break	ASTM D638	45 %

Flexural Properties	Norm	Typical Values
Flexural Modulus	ASTM D790	1600 MPa
Flexural Strength	ASTM D790	70 MPa

Impact Properties	Norm	Typical Values
Notched Izod (Machined), 23 °C	ASTM D256	46 J/m
Unnotched Izod, 23 °C	ASTM D256	1004 J/m
Charpy notched, 23 °C	ISO 179-1	3.6 kJ/m^2

Thermal Properties	Norm	Typical Values
HDT at 0.45 MPa	ASTM D648	54 °C
HDT at 1.82 MPa	ASTM D648	43 °C
Flammability	UL 94 3 mm	HB

Hardness	Norm	Typical Values
Shore D	ASTM D2240	78

1) Determined with TA-Instrument DHR rheometer, cone/plate, diameter 60 mm, shear rate 100 s^{-1}

Version 1.1

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