

## Cubic Ink® Mold 210 VP

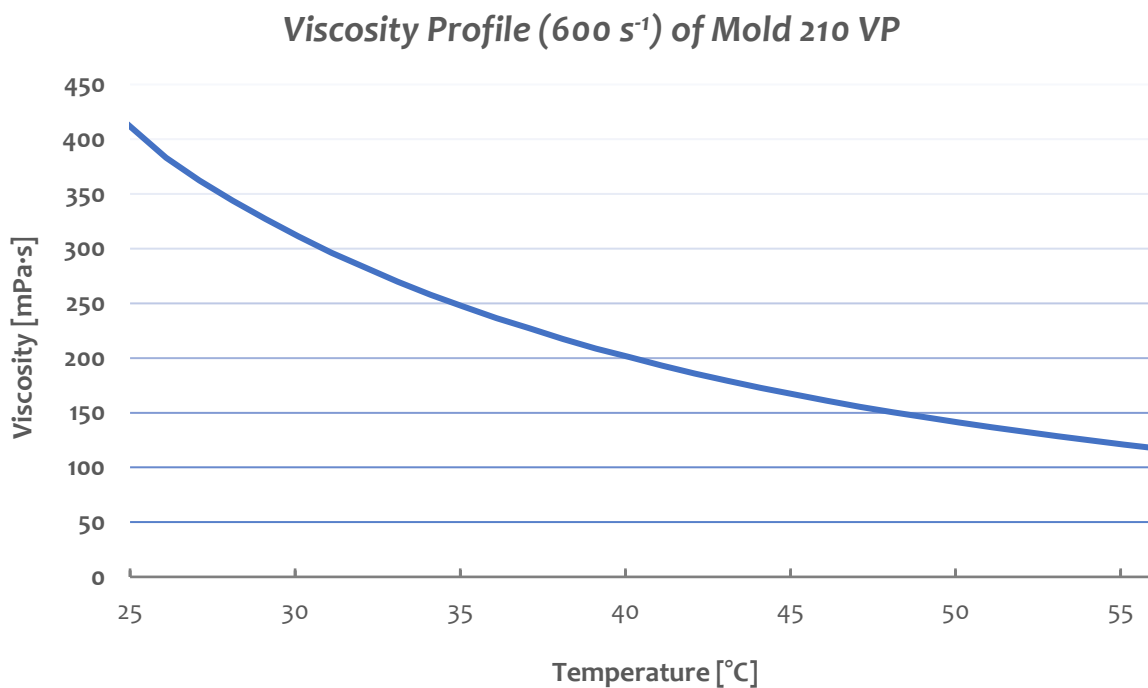
Water-breakable material for mold and (form-)casting applications

Liquid Properties	Value <sup>1</sup>	Unit
Viscosity @ 25 °C (DIN EN ISO 3219)	410	mPa·s
Density (DIN EN ISO 15212-1)	1.10	g/mL
Critical Energy (E <sub>c</sub> ) @405 nm	1.1	mJ/cm <sup>2</sup>
Depth of Penetration (D <sub>p</sub> ) @405 nm	0.18	mm
<b>Tensile Properties<sup>2</sup> (DIN EN ISO 527-5A)</b>		
Ultimate Tensile Strength	4	MPa
Tensile Modulus	80	MPa
Elongation at Break	7	%
<b>Hardness (DIN EN ISO 7619)</b>		
Shore Hardness	27	D
<b>Print Appearance/ Color</b>		
Natural color is translucent light yellow. More colors on request.		
<b>Availability and Storage</b>		
Batch sizes starting from 1 kg.		
Store at room temperature and protect from light.		
<sup>1</sup> Properties with post-processing – 10 min UV-post-cure. All material properties can vary with printer, print settings, object orientation, part geometry, post-processing and age of sample. <sup>2</sup> 5 mm/min.		

### Object-depending Removal<sup>1)</sup>

Removal	Complexity of Form Object		
	Simple	Medium	Complex
Mechanical	Yellow	Red	Red
15 min H <sub>2</sub> O, 23 °C	Green	Yellow	Red
15 min H <sub>2</sub> O, 50 °C	Green	Yellow	Yellow
15 min NaOH (1%), 23 °C	Green	Green	Green

<sup>1)</sup>Effort of the mold-removal process given by a color-code: **Green**: Simple removal with minimum effort, duration per part: <10 sec; **Yellow**: Medium effort, duration per part: up to 1 min; **Red**: Hardly possible, requires special treatment, risk of damaging the object, duration per part: > 1 min.



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