

Cubic Ink® Mold 3000 VP

Water-breakable cast material for injection molding applications

Liquid Properties	Value ¹	Unit
Viscosity @ 25 °C (DIN EN ISO 3219)	40	mPa·s
Density (DIN EN ISO 15212-1)	1.11	g/mL
Critical Energy (E _c) @385 nm	0.8	mJ/cm ²
Depth of Penetration (D _p) @385 nm	0.12	mm
Tensile Properties² (DIN EN ISO 527-5A)		
Ultimate Tensile Strength	46	MPa
Tensile Modulus	2100	MPa
Elongation at Break	13	%
Hardness (DIN EN ISO 7619)		
Shore Hardness	82	D
Injection Molding Conditions		
Max. Temperature at Injection Nozzle	320	°C
Max. Injection Pressure	800	bar
Min. Thickness Filling Material	1.00	mm
Compatible Filling Materials³		
Polyethylene		
Polypropylene (with up to 30% Glass Fiber Filling)		
Polyamide-6 (with up to 18% Glass Fiber Filling)		
Polycarbonate		

Print Appearance/ Color

Natural color is translucent light yellow. More colors on request.

Availability and Storage

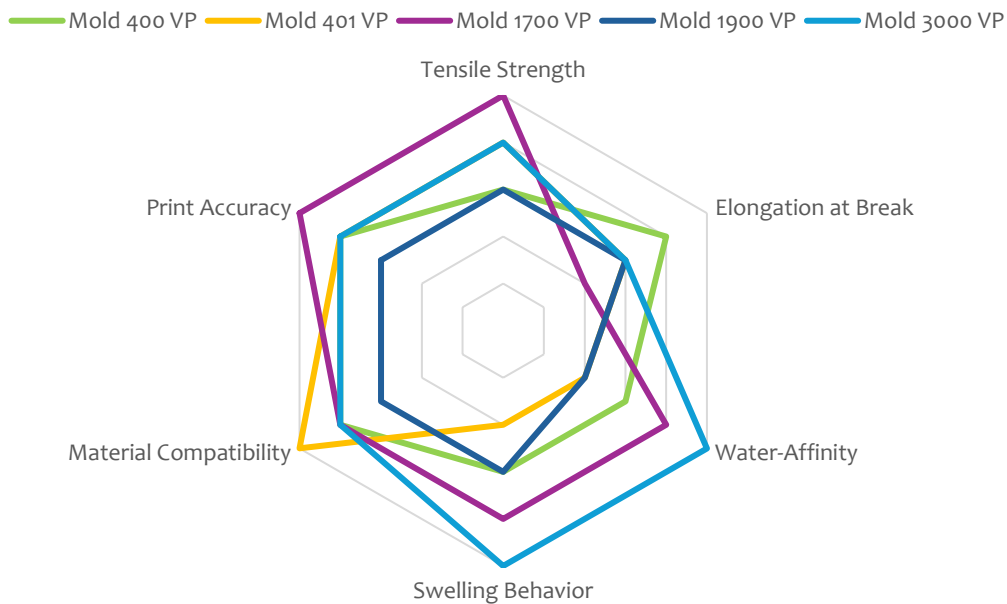
Batch size starting from 1 kg.

Store at room temperature and protect from light. Stir prior to use.

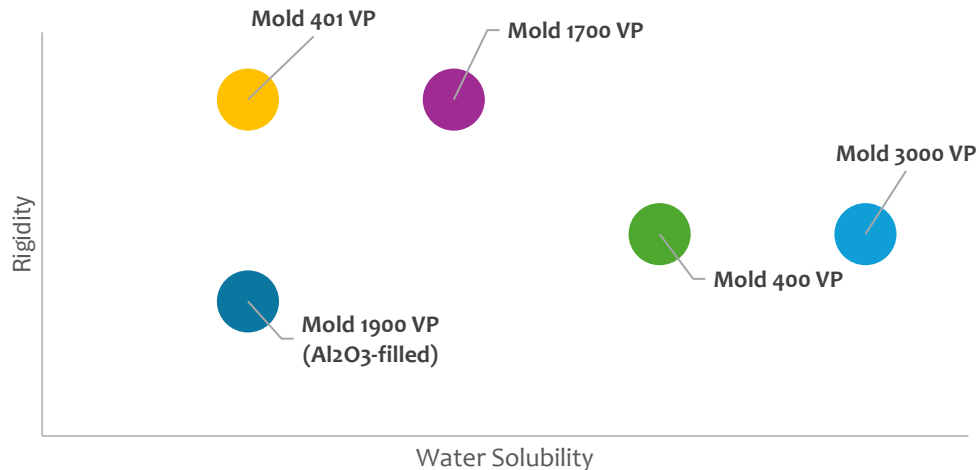
¹Properties may vary with post-processing – 2 x 30 min UV-post-cure. All material properties can vary with printer, print settings, object orientation, part geometry, post-processing and age of sample. ²5 mm/min;

³The compatibility strongly depends on the geometry of the final part.

Mold Performance Indicators



Mold Water Solubility vs Rigidity



Cubic Ink®
ALTANA New Technologies GmbH

located at

ACTEGA Terra GmbH
Mielestraße 13
31275 Lehrte
GERMANY

Tel +49 (0)5132 5009-600

cubic.ink@altana.com
www.altana.com

Learn more about Cubic Ink® materials

www.altana.com/cubic-ink
www.altana.de/cubic-ink

Disclaimer

The information contained herein is based on our current knowledge and experience. No warranties, guarantees and/or assurances of any kind, either express or implied, including warranties of merchantability or fitness for a particular purpose, are made regarding any products mentioned herein and data or information set forth, or that such products, data or information may be used without infringing intellectual property rights of third parties. Any information about suitability, use or application of the products is non-binding and does not constitute a commitment regarding the products' properties, use or application. Contractual terms and conditions, in particular agreed product specifications, always take precedence. We recommend that you test our products in preliminary trials to determine their suitability for your intended purpose prior to use. We reserve the right to make any changes and to update the information herein without notice.

Follow us – ALTANA New Technologies GmbH – Cubic Ink®

