

4D PARTS DIRECT

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3D PARTS... FAST!

MATERIAL	ABS-PLUS	POLYJET BLACK/WHITE	POLYJET BLUE	POLYJET CLEAR	POLYJET HIGH-TEMP	POLYJET ENDUR	POLYJET DURUS	COLORJET
TYPE	Industrial Plastic	Acrylic Photopolymer	Acrylic Photopolymer	Acrylic Photopolymer	Acrylic Photopolymer	Polypropylene-like	Polypropylene-like	Plaster-like Composite
PROCESS	FDM	Polyjet	Polyjet	Polyjet	Polyjet	Polyjet	Polyjet	Full-Color 3D Printing
COLORS	Ivory, White, Black, Gray, Blue, Olive Green, Yellow, Nectarine, Red, Custom	White, Black, Gray	Blue	Transparent	White	White	Translucent White	White, Full-Color
MAXIMUM PRINT SIZE	8" x 8" x 6"	7.5" x 11.5" x 5.8"	7.5" x 11.5" x 5.8"	7.5" x 11.5" x 5.8"	7.5" x 11.5" x 5.8"	7.5" x 11.5" x 5.8"	7.5" x 11.5" x 5.8"	10" x 14" x 8"
LAYER THICKNESS	.010"	.001" (28 microns)	.001" (28 microns)	.001" (28 microns)	.001" (28 microns)	.001" (28 microns)	.001" (28 microns)	.004"
TENSILE STRENGTH	5,200 psi	7,250-9,450 psi	7,250-8,700 psi	7,250-9,450 psi	10,000-11,500 psi	5,800-6,500 psi	2,900-4,350 psi	2,060-3,829 psi
ELONGATION	4%	10-25%	15-25%	10-25%	10-15%	20-35%	40-50%	0.23%
MODULUS OF ELASTICITY	329,500 psi	290,000-435,000 psi	290,000-435,000 psi	290,000-435,000 psi	465,000-510,000 psi	246,000-305,000 psi	145,000-175,000 psi	1,370,000-1,822,000 psi
FLEXURAL STRENGTH	7,604 psi	11,000-16,000 psi	8,700-10,200 psi	11,000-16,000 psi	16,000-19,000 psi	7,500-8,500 psi	4,350-5,800 psi	1,900-6,400 psi
FLEXURAL MODULUS	319,737 psi	320,000-465,000 psi	265,000-365,000 psi	320,000-465,000 psi	450,000-510,000 psi	217,000-246,000 psi	175,000-230,000 psi	1,040,000-1,550,000 psi
HDT @ 0.45MPa	204 F	113-122 F	113-122 F	113-122 F	145-163 F (167-176 F after thermal post-treatment)	120-129 F	99-108 F	250 F (infusion resin dependent)
HDT @ 1.82MPa	180 F	113-122 F	113-122 F	113-122 F	131-135 F	113-122 F	90-93 F	220 F
IZOD NOTCHED IMPACT	1.8 ft. lb./in.	.375-.562 ft. lb./in.	.375-.562 ft. lb./in.	.375-.562 ft. lb./in.	.262-.300 ft. lb./in.	.561-.656 ft. lb./in.	.749-.937 ft. lb./in.	no data
WATER ABSORPTION	no data	1.1-1.5%	1.5-2.2%	1.1-1.5%	1.2-1.4%	1.5-1.9%	1.5-1.9%	no data
Tg	no data	126-129 F	118-122 F	126-129 F	144-149 F	118-126 F	95-99 F	no data
SHORE HARDNESS	no data	83-86 D	83-86 D	83-86 D	87-88 D	80-84 D	74-78 D	no data
ROCKWELL HARDNESS	no data	73-76 M	73-76 M	73-76 M	78-83 M	58-62 M	no data	no data
DENSITY	1.04 g/cm3	1.17-1.18 g/cm3	1.18-1.19 g/cm3	1.18-1.19 g/cm3	1.17-1.18 g/cm3	1.20-1.21 g/cm3	1.15-1.17 g/cm3	1.60 g/cm3
ASH CONTENT	no data	.23-.26% (White/Gray) .01-.02% (Black)	.21-.22%	.02-.06	.38-.42%	.30-.40%	.10-.12%	40%