xFLEX402-Black

xFLEX402-Black is a single component elastomer material with high elongation and high resilience, excellent tensile strength and high energy return while also not requiring thermal post processing.

Part Properties

Measurement	Unit	Value	Test Method
Tensile Stress at Break	MPa	5.5	ASTM D638
Young's Modulus	MPa	42	ASTM D638
Elongation at Break	%	230	ASTM D638
Energy Return	%	30 – 35	Proprietary
Shore Hardness	A	73	ASTM D648
Water Absorption	%	3.15	ASTM D570

*"All specimen are printed unless otherwise specified." ASTM Methods: D638 Type IV, 50mm/min, , 2mm/min, D624, D570-98 24-hour water immersion, specimen 50.8mm diameter, 3.2mm thick, D412 Type C

Workflow

Validated workflows need to be followed to achieve properties as provided in the TDS. Examples of validated workflow steps are listed below. Users should defer to the most current workflow information for best results which can be found at support.nexa3d.com.

Printer Settings

xFLEX402-Black is formulated to print optimally on Nexa3D industrial and desktop printers. Read the safety data sheet carefully to get details about health and safety instructions. Shake resin bottle well before usage.

Post Processing

Nexa3D xFLEX402-Black requires post processing to achieve specified properties. Prior to post curing, support structures should be removed from the printed part, and the part should then be washed. Nexa3D recommends using xClean followed by IPA. Parts should not be submerged in either washing fluid for more than 5 minutes.

Post Curing

Nexa3D xFLEX402-Black requires post curing to achieve specified properties. It is recommended that either an LED or wide spectrum lamp be used to post cure parts. Nexa3D recommends using the XiP Wash+Cure station or xCure for best results.

Additional methods can be found by contacting us at www.nexa3d.com.

Note: The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Nexa3D is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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