

Produkt: **Raplasprint**

Date: **08.07.2014**

Properties/Material	Raplasprint
Colour	clear-transparent
Viskosity	1760 mPas
Green hardness	75 Shore D
Shore-D hardness	83 Shore D
Flexural strength	84 MPa
Penetration depth	Dp:6,9 mils
Critical exposure	Ec: 18,5 mJ/cm ²

The mechanic characteristics depend on the used build styles and build parameters of the Machine system, the cleaning and drying of the pieces (e.g. earmoulds or shells) and the characteristics of the used post-curing unit (Otoflasch 171).

Variations in the manufacturing process may lead to modified mechanic characteristics and colour variations.

Post-processing:

Pre-cleaning with Isopropanol for 3 min. in an ultrasonic bath; venting canals-cleaning with compressed air; main-cleaning with Isopropanol for 3 min. in an ultrasonic bath; blowing off the remaining isopropanol and drying for 30 min at approx. 40°C.

Post-curing:

The post-curing is performed with a xenon photoflash unit (Otoflash 171) with 2 times 2.000 flashes under inert gas conditions.