

Cubic Ink® Mold 2000 VP

Water-breakable cast material compatible with various (2K-)filling compounds.

| Liquid Properties | Value¹ | Unit |
|---|--------------------------|-------------------|
| Viscosity @ 25 °C (DIN EN ISO 3219) | 122 | mPa·s |
| Density (DIN EN ISO 15212-1) | 1.11 | g/mL |
| Tensile Properties² (DIN EN ISO 527-5A) | | |
| Ultimate Tensile Strength | 12 | MPa |
| Tensile Modulus | 322 | MPa |
| Elongation at Break | 46 | % |
| Flexural Properties² (DIN EN ISO 178) | | |
| Flexural Strength | 12 | MPa |
| Flexural Modulus | 444 | MPa |
| Deflection at Fracture | >10 | % |
| Impact Properties | | |
| Izod notched (DIN EN ISO 180) | 33 | J/m |
| Charpy notched (DIN EN ISO 179-1) | 3.5 | kJ/m ² |
| Hardness (DIN EN ISO 7619) | | |
| Shore Hardness | 59 | D |
| Chemical Resistance | | |
| 1% NaOH Solution Uptake, 24 h, 23 °C | 10 | % |
| Isopropanol Uptake, 24 h, 23 °C | 1.5 | % |

Print Appearance/ Color

Natural color is translucent light yellow. Also available in cyan, magenta, yellow, black, white and grey. More colors on request.

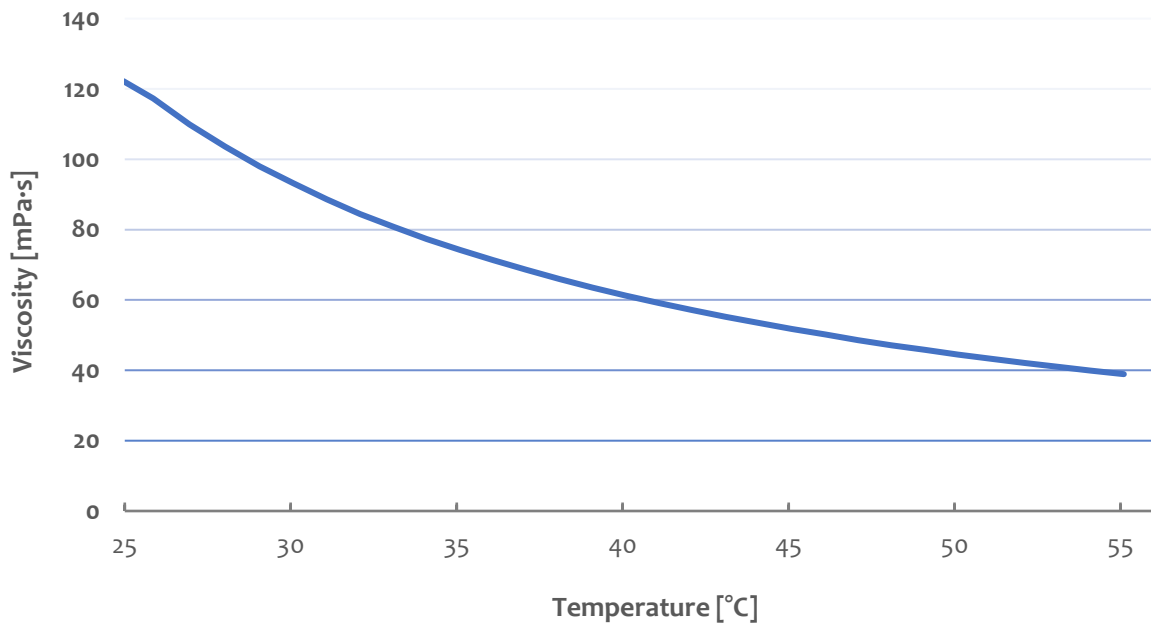
Availability and Storage

Batch size starting from 1 kg.

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

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

Viscosity Profile (600 s⁻¹) of Mold 2000 VP



Solvents for Mold Removal

Removability

| | |
|--------------------------|--------|
| Sodium Hydroxide (1%) | High |
| Plastic Cleaner (Tanex®) | High |
| Methyl Ethyl Ketone | High |
| Water | Medium |
| Nitric Acid (5%) | Medium |
| Hydrogen Peroxide (3%) | Medium |
| Ethanol | Medium |
| Super Gasoline | Medium |
| Acetone | Medium |

| | |
|---------------------------|--|
| Acetic Acid (5%) | |
| Hydrochloric Acid (1%) | |
| Sodium Hypochlorite (10%) | |
| Isopropyl Alcohol | |

¹Removability given by a color-code: **Green**: Good to very good removability, suitable for most geometries. **Yellow**: Moderate removability or tendency, suitable for rather easy geometries. **Red**: Hardly removable, mold is inert to this solvent.

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