

Cubic Ink® Mold 2000 VP

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

Liquid Properties	Value ¹	Unit
Viscosity @25 °C (DIN EN ISO 3219)	70	mPa·s
Density (DIN EN ISO 15212-1)	1.11	g/mL
Critical Energy (E _c) @385 nm	1.1	mJ/cm ²
Depth of Penetration (D _p) @385 nm	0.12	mm
Tensile Properties² (DIN EN ISO 527-5A)		
Ultimate Tensile Strength	38	MPa
Yield Strength	37	MPa
Tensile Modulus	1800	MPa
Elongation at Break	45	%
Hardness (DIN EN ISO 7619)		
Shore Hardness	82	D
Print Appearance/ Color		
Natural color is 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.		
¹ Properties may vary with post-processing – 30 min UV-post-cure. All material properties can vary with printer, print settings, object orientation, part geometry, post-processing and age of sample. ² 5 mm/min.		

Compatible filling materials¹

2K Silicone

2K Epoxide

2K Polyester

Low-melting metals and alloys

Composites (e.g. Epoxide / Glass Fiber)

¹The compatibility strongly depends on the geometry of the final part.



Figure 1: Examples of printed mold and final object, shown for a glass fiber-filled 2K epoxide (left) and the 'Fieldsche Metal' as low-melting alloy (right)

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