



Customer Information Bulletin

CIB

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Status: Non-confidential

Subject: Tips & Information for part building with Accura[®] 48HTR plastic material

Thermal Post curing: Parts built in Accura 48HTR material may be thermally post cured to achieve enhanced thermal resistance. This is particularly beneficial for higher temperature applications. In order to thermally post cure a part made in Accura 48HTR material, the part should be treated as follows:

- Clean and UV post cure as normal.
- Place the part in a programmable thermal oven with sufficient support material (typically vermiculite or sand) to prevent sagging.
- Slowly raise the oven temperature to 160° C (320° F) over a period of approximately 2 hours.
- Hold the temperature for at least 2 hours, depending on the thickness of the part. Thin parts, those around 3mm (~0.125"), require only 2 hours at elevated temperature. Thicker parts will require more. Your goal is to have the entire part mass reach equilibrium.
- Shut off the oven, and slowly return the temperature to room temperature, over approximately 4-8 hours. It is important not to cool parts rapidly as thermal shocking may occur and result in cracks in the part.

