

nexa3D®



2024 Material Guide for Industrial Resin 3D Printing

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Introduction

In the rapidly evolving landscape of 3D printing, the pivotal role of speed continues to redefine the game, and as we step into 2024, this truth holds even greater significance. Harnessing a strategic blend of advanced modeling and engineering materials, including applications in dentistry and freeform injection molding, the capacity to generate flawless prototypes within minutes and entire batches of production parts in just hours has become the norm.

This guide delves into an extensive array of materials, serving as the foundation for crafting robust, impeccable, heat-resistant, ESD-compliant, flexible, and various other specialized parts. Furthermore, it explores the cutting-edge technologies propelling ultrafast, high-throughput 3D printing, providing a comprehensive overview of the latest advancements.

Resin 3D Printing

featuring LSPc® Technology

Resin 3D printers are well known for their capabilities – producing high detail parts with exceptional surface finish, but today’s resin 3D printers go far beyond just pretty parts. With a growing landscape of high performance materials, and advanced technologies like Nexa3D’s Lubricant Sublayer Photo-curing Technology – resin parts can outperform even some of the best known manufacturing polymers, and can be produced at unparalleled speeds.



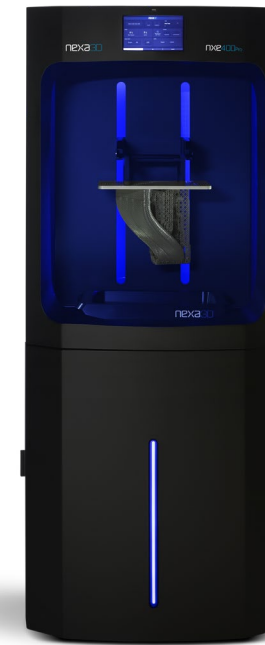
XiP

XiP brings ultrafast 3D printing to the desktop. Utilizing the industrial light engine and proprietary LSPc membrane technology of the NX Pro Series, XiP is capable of printing production grade parts at lightning speeds - all in a compact and easy to use package.



XiP Pro

XiP Pro provides unmatched throughput for industrial and dental applications. With 19.5 liters of build volume and incredible 7K resolution, you can mass produce hundreds of small nested and large single parts in hours, not days.



NXE 400 Pro

For labs, workshops, and production facilities, **NXE 400 Pro** offers a large build volume, great accuracy and fast printing thanks to our proprietary LSPc® technology.

General Purpose Resins

General purpose resins are commonly used for prototyping. They tend to produce a high level of detail, smooth surface finish, and optimal color or clarity. In many cases these also tend to be some of the fastest printing resins making them ideal for iterative design and testing.



[Gentle Giant Studios](#)

Gentle Giant Studios took their expertise to new heights with help of the ultrafast XiP desktop 3D printer. With its cutting-edge resin 3D printing technology, Gentle Giant has been able to produce incredibly detailed character models for Disney's Elemental movie promotion on an extremely tight timeline.

x45

A tough material that is ideal for models and functional prototypes requiring high strength and durability. Capable of much higher print speeds than current materials, x45 features excellent out-of-printer properties with robust print styles to ensure high first-time build success. Supporting a wide variety of applications with short processing times, x45 draft build mode offers companies greater flexibility within their manufacturing processes.

Colors

Natural

Manufacturing Partner

BASF Forward AM

Characteristics

- Draft build mode enables remarkable build speed
- Robust print styles ensure high first-time build success
- Excellent out-of-printer properties and multiple colors support a wide variety of modeling and prototyping applications

Uses

- Fast turnaround modeling and prototyping
- Models and prototypes requiring good optical clarity or matte black finish
- Functional prototypes requiring good strength and toughness



Property	Clear
Tensile Modulus (ASTM D638)	1600 MPa
Ultimate Tensile Strength (ASTM D638)	52 MPa
Tensile Elongation at Break (ASTM D638)	12 %
Flex Modulus (ASTM D790)	2100 MPa
Flex Strength (ASTM D790)	95 MPa
Notched Izod (ASTM D256)	20 J/m
Water Absorption (ASTM D570)	6 %
Hardness Shore D (ASTM D2240)	85

xMODEL15

xMODEL15 is an economical modeling material that yields superb speed, productivity, and great surface finish quality. Those looking for next level finishes will be glad to know that the xMODEL15 is suitable for polishing, painting, and even plating. Most importantly, xMODEL15 is derived from plant-based materials, has low odor, and can be cleaned easily with water and soft brushing.

Colors

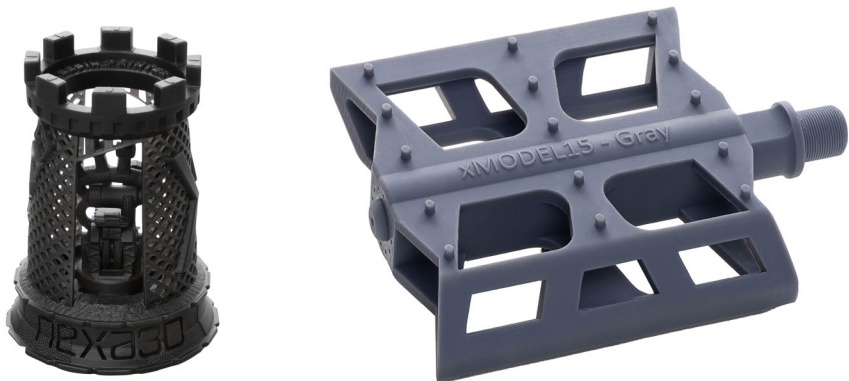
Black | Gray

Characteristics

- Fine feature detail
- Smooth surface finish
- Economical

Uses

- Visual models and prototypes
- Multi-iteration prototyping



Property	Black	Gray
Ultimate Tensile Strength (ASTM D638)	48 MPa	48 MPa
Tensile Elongation at Break (ASTM D638)	28 %	28 %
Flex Strength (ASTM D790)	49 MPa	49 MPa
Notched Izod (ASTM D256)	36 J/m	36 J/m

xMODEL17-Clear

xMODEL17-Clear is a rigid and durable modeling material with enhanced clarity, perfect for prototyping applications that require fine feature details and high-quality translucent or transparent surface finishes.

Colors

Clear

Characteristics

- Finishes to high optical clarity
- Fine feature detail
- Smooth surface finish
- Economical

Uses

- Lighting
- Optics prototyping



Property	Clear
Tensile Modulus (ASTM D638)	1213 MPa
Ultimate Tensile Strength (ASTM D638)	30 MPa
Tensile Elongation at Break (ASTM D638)	22 %
Flex Modulus (ASTM D790)	1467 MPa
Flex Strength (ASTM D790)	57 MPa
HDT @0.45 MPa (ASTM D648)	47 °C
Notched Izod (ASTM D256)	47 J/m
Water Absorption (ASTM D570)	0.24 %

PRO9499 White

PRO9499 White from Henkel® is a cost-effective modeling material that delivers superb feature resolution and accuracy. It maintains a brilliant matte white finish even after post-curing, making it perfect for a wide variety of modeling applications. With exceptional detail and high-quality surface finish, it’s designed for great first-time print success.

Colors

White

Manufacturing Partner

Henkel

Characteristics

- Superb feature resolution
- Brilliant matte finish
- Excellent accuracy and detail
- First-time print success

Uses

- Prototyping
- Modeling applications
- Models where accuracy and resolution are critical



Property	Black
Tensile Modulus (ASTM D638)	1841 MPa
Ultimate Tensile Strength (ASTM D638)	52 MPa
Tensile Elongation at Break (ASTM D638)	50 MPa
HDT @ 0.45 MPa (ASTM D648)	72 °C
Notched Izod (ASTM D256)	28.7 J/m
Water Absorption (ASTM D570)	0.21 %
Shore Hardness (ASTM D2240)	77

Engineering Resins

Engineering resins have seen a major improvement over the last couple of years. Specialty resins are available for applications ranging from high temp molding tools, to versatile ABS-like production materials, to ESDs, and some unbelievably flexible rubber-like elastomers. These high-performance resins are enabling true-manufacturing with resin 3D printers.



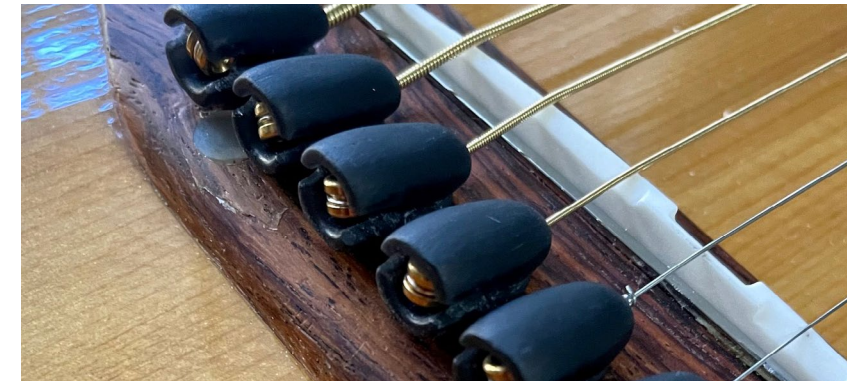
Alstom

Alstom is a French-based rolling stock manufacturer that manufactures train cars for some of the world's largest rail agencies. They were able to manufacture hundreds of passenger footrests to replace designs that were no longer available from suppliers using xABS3843 resin with their NXE 400 3D printer.



PepsiCo

PepsiCo was able to reduce their bottle production costs by 96% by switching to 3D printed blow mold tooling. For the blowmold tools they 3D print the xPEEK147 resin on their NXE 400 3D printers - a complete mold set can be ready in just 12 hours compared to several weeks for a machined tool.



Liquid Sound Technologies

Liquid Sound Technologies is a manufacturer of acoustic accessories. With the xCE resin and their XiP desktop 3D printer, they were able to reduce production costs 90% and go from a 9 month lead time with 10,000 minimum order size, to one day lead time with no minimum order size. The xCE is replacing machined brass parts and needs to withstand high force loads.

xPRO1100-Black

xPRO1100-Black sets a new standard for rigid resin, offering exceptional stiffness and temperature resistance. This cutting-edge polyurethane-based engineering grade resin is engineered to deliver mechanical properties on par with widely adopted injection molding grade plastics found in demanding industries like automotive and industrial products.

Colors

Black

Manufacturing Partner

BASF Forward AM

Characteristics

- Exceptional stiffness for structural integrity
- High-heat deflection temperature
- Excellent chemical resistance
- Low water absorption

Uses

- Ideal for connectors, brackets, and housings
- Durable prototypes
- Consumer products



Property	Black
Tensile Modulus (ASTM D638)	1310 MPa
Tensile Strength at break (ASTM D638)	71 MPa
Elongation (ASTM D638)	4 %
Flex Modulus (ASTM D790)	2790 MPa
Flex Strength (ASTM D790)	125 MPa
HDT @0.45 MPa (ASTM D648)	112 °C
Notched Izod (ASTM D256)	21 J/m
Water Absorption (24hr) (ASTM D570)	0.14 %
Hardness Shore D (ASTM D2240)	84

xPP405

A tough, impact-resistant material with a modulus similar to molded unfilled polypropylene. Exhibits excellent weathering characteristics and UV stability making it suitable for end-use part applications.

Colors

Black

Manufacturing Partner

Henkel

Characteristics

- Tough, impact-resistant material with a modulus similar to molded unfilled polypropylene
- Good weathering
- Smooth black surface finish

Uses

- Design verification models
- Functional prototypes
- End-use parts including packaging, piping, and consumer and industrial applications, including large housings and enclosures



Property	Black
Tensile Modulus (ASTM D638)	1300 MPa
Ultimate Tensile Strength (ASTM D638)	35 MPa
Tensile Elongation at Break (ASTM D638)	100 %
Flex Modulus (ASTM D790)	1300 MPa
Flex Strength (ASTM D790)	45 MPa
HDT @0.45 MPa (ASTM D648)	53 °C
Notched Izod (ASTM D256)	62 J/m
Water Absorption (ASTM D570)	1 %
Hardness Shore D (ASTM D2240)	80

xABS3843

Tough and durable material with the aesthetics of injection molded black ABS. High performance, high modulus material boasting excellent flexural and tensile physical properties with a relatively high degree of elongation. It displays high green strength and good heat deflection temperature enabling it to print accurately and function in a wide variety of applications. It has been tested in QUV exterior weathering conditions (ASTM G-154) for 800 hours with less than a 15% change in Tensile and IZOD Impact properties.

Colors

Black

Manufacturing Partner

Henkel

Characteristics

- ABS-like stiffness
- Tough & durable
- Great feature detail

Uses

- Design verification models
- Functional prototypes
- Snap fits
- Jigs and fixtures
- Patterns
- End use parts
- Good weathering performance



Property	Black
Tensile Modulus (ASTM D638)	1400 MPa
Ultimate Tensile Strength (ASTM D638)	32 MPa
Tensile Elongation at Break (ASTM D638)	50 %
Flex Modulus (ASTM D790)	1400 MPa
Flex Strength (ASTM D790)	30 MPa
HDT @0.45 MPa (ASTM D648)	56 °C
Notched Izod (ASTM D256)	54 J/m
Water Absorption (ASTM D570)	2.3 %
Hardness Shore D (ASTM D2240)	86

xPEEK147

A stiff, heat-resistant material with a HDT of 230°C similar to many PAEK thermoplastics like PEEK. Exhibits excellent long-term stability at temperatures exceeding 100°C making it suitable for prototypes and end-use parts subjected to high temperatures and fast tooling for plastic molding.

Colors

Black

Manufacturing Partner

Henkel

Characteristics

- High heat deflection temperature
- High stiffness with good dimensional stability
- Good surface finish

Uses

- High performance prototypes or end use parts requiring high temperature capability and long-term thermal stability
- Tools and molds requiring good surface and long-term thermal stability >125°C



Property	Black
Tensile Modulus (ASTM D638)	3190 MPa
Ultimate Tensile Strength (ASTM D638)	75 MPa
Tensile Elongation at Break (ASTM D638)	3 %
Flex Modulus (ASTM D790)	3170 MPa
Flex Strength (ASTM D790)	130 MPa
HDT @0.45 MPa (ASTM D648)	238 °C
Notched Izod (ASTM D256)	15 J/m
Water Absorption (ASTM D570)	0.2 %
Hardness Shore D (ASTM D2240)	94

xCERAMIC3280

xCERAMIC3280 is a ceramic composite resin that produces rigid parts with high heat deflection temperature and excellent tensile modulus at some of the highest speeds of any material class. The new xCERAMIC3280 resin is a perfect choice for tooling applications, wind tunnel testing models, and products that require a ceramic look and feel.

Colors

White

Manufacturing Partner

BASF Forward AM

Characteristics

- High heat deflection
- High speed printing
- Very high rigidity
- Ceramic look and feel

Uses

- Tooling
- Wind tunnel models



Property	White
Tensile Modulus (ASTM D638)	9410 MPa
Ultimate Tensile Strength (ASTM D638)	40 MPa
Tensile Elongation at Break (ASTM D638)	0.5 %
HDT @0.45 MPa (ASTM D648)	280 °C
Water Absorption (ASTM D570)	0.29 %
Hardness Shore D (ASTM D2240)	96

xESD

xESD is a rigid photoplastic with a stable carbon nanotube dispersion that delivers optimal static-dissipative performance and isotropic mechanical properties required by the electronics manufacturing industry. The xESD resin allows users to create custom jigs, fixtures, grippers, assembly aides, and enclosures in hours without the risk of ESD damage to high-value electronic components.

Colors

Black

Characteristics

- Electronic static dissipative
- High rigidity
- Above average heat deflection

Uses

- Electronics housings
- Jigs and fixtures for electronics handling and assembly



Property	Black
Tensile Modulus (ASTM D638)	2600 MPa
Ultimate Tensile Strength (ASTM D638)	68.1 MPa
Tensile Elongation at Break (ASTM D638)	3.8 %
Flex Modulus (ASTM D790)	1800 MPa
Flex Strength (ASTM D790)	97.4 MPa
HDT @0.45 MPa (ASTM D648)	91.3 °C
Notched Izod (ASTM D256)	24 J/m
Hardness Shore D (ASTM D2240)	87

xPRO9400-FR

xPRO9400-FR, produced in partnership with BASF ForwardAM, sets a new standard in flame retardant 3D printing materials. This rigid material with a UL 94 V-0 rating is halogen-free and features an exceptionally high heat deflection temperature (HDT) above 250°C. Ideal for production automotive and aerospace parts, electronics, custom jigs & fixtures, and more, it stands out with its low viscosity, ease of handling, and exceptional temperature resistance.

Colors

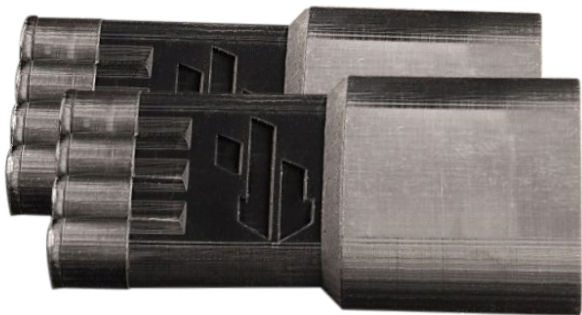
Black

Characteristics

- High-throughput flame retardant
- High-heat deflection temperature
- Halogen-free composition

Uses

- Automotive and aerospace parts
- Jigs and fixtures for electronics handling and assembly
- High-temp environments



Property	Black
Tensile Modulus (ASTM D638)	3470 MPa
Ultimate Tensile Strength (ASTM D638)	71 MPa
Tensile Elongation at Break (ASTM D638)	3.1 %
Flex Modulus (ASTM D790)	3400 MPa
Flex Strength (ASTM D790)	115 MPa
HDT @ 0.45 MPa (ASTM D648)	>174 °C
Notched Izod (ASTM D256)	20 J/m
Hardness Shore D (ASTM D2240)	88

xFLEX402

xFLEX402 is a flexible material with firmer shore 76A durometer, high elongation at break and excellent tensile strength, ideal for functional prototyping applications of elastomeric components and production parts.

Colors

Black

Manufacturing Partner

Henkel

Characteristics

- Firm rubber-like
- High elongation at break

Uses

- Functional prototypes
- Rubber-like production parts



Property	Black
Tensile Modulus (ASTM D638)	42 MPa
Tensile Elongation at Break (ASTM D638)	230 %
Water Absorption (ASTM D570)	3.15 %
Hardness Shore A (ASTM D2240)	73
Energy Return	35 %

xFLEX475

A medium soft rubber-like material that cures to a soft, elastomeric finish. Customers can use this industrial strength material in applications that require resilience, snap back, and tear resistance, such as pipes and manifolds, handles and grips, seals and gaskets, or sportswear and footwear midsoles. This material also boasts an impressive 150 percent elongation at break, an excellent energy return of up to 50 percent, and resistance to most solvents.

Colors
Black | White

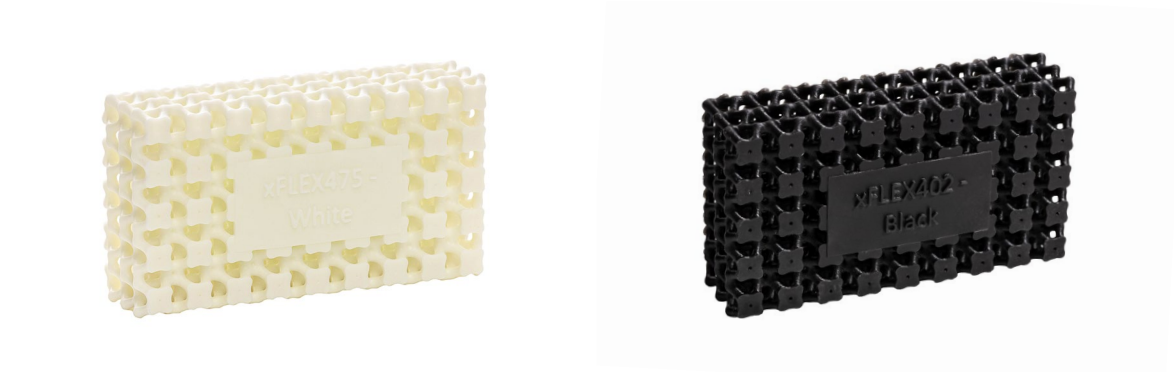
Manufacturing Partner
Henkel

Characteristics

- Soft elastic
- Single component with low viscosity

Uses

- Resilience, snap back and tear resistance elastomeric application



Property	Black	White
Tensile Modulus (ASTM D638)	3.7 MPa	4.6 MPa
Ultimate Tensile Strength (ASTM D638)	2.5 MPa	3.8 MPa
Tensile Elongation at Break (ASTM D638)	150 %	159 %
Hardness Shore A (ASTM D2240)	44	55
Energy Return	47 %	39 %
Tear Strength (ASTM D624)	7.3 kN/m	11.7 kN/m

xMOLD

xMOLD is a high-performance dissolvable resin developed for Freeform Injection Molding (FIM). The resin is optimal prototyping injection molding parts without the hassle of complex mold design.

Characteristics

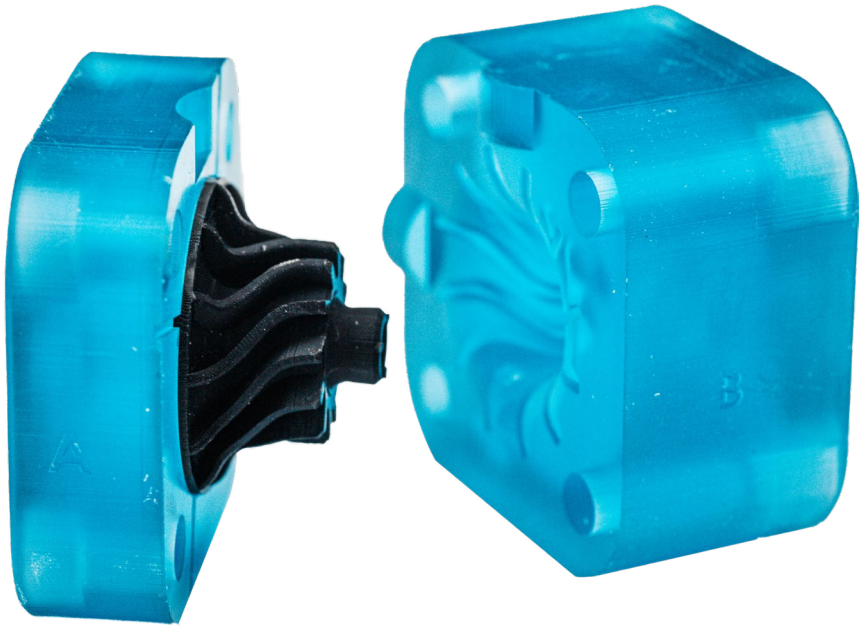
- Rapid prototyping with FIM
- Compatibility with diverse materials
- Final-grade production parts in hours
- Invaluable product development

Uses

- For rapid tooling and production parts
- Accelerated product development
- Efficient iteration and validation

What is freeform injection molding (FIM)?

The patented FIM process uses ultrafast Nexa3D printers and xMOLD resin to print injection molding tools that are compatible with thousands of off-the-shelf injection molding materials, including reinforced high-performance feedstocks. The ability to design, iterate, and validate using final grade production materials in hours versus weeks is invaluable in any product development process.



Property	xMOLD
Tensile Modulus (ASTM D638)	4.6 MPa
Ultimate Tensile Strength (ASTM D638)	3.8 MPa
Tensile Elongation at Break (ASTM D638)	159 %
Hardness Shore A (ASTM D2240)	55
Energy Return	39 %
Tear Strength (ASTM D624)	11.7 kN/m

Dental Resins

3D printing has become an invaluable tool in the dental and orthodontic industries due to the need for customized pieces. This demand has driven a range of highly productive dental resins capable of producing everything from models to guards, from guides to aligners.



[Excel Orthodontics](#)

Excel Orthodontics produce 150 - 200 orthodontic models per day using the KeyModel Ultra resin on their Nexa3D printer. The process trades messy in-office ortho impressions, for quick and easy scans. From the scans 20 models can be printed in about 30 minutes.

xDENT201

xDENT201 is a high-resolution material designed for ultrafast production of orthodontic models. Showcasing great accuracy and dimensional stability, xDENT201 is your material of choice when printing models in high volumes for aligner manufacturing or other orthodontic modeling needs. This resin provides excellent fine feature details, and you can print a full build of flat models in 20 minutes.

Colors

Gray | Beige

Characteristics

- High resolution
- Strong and rigid

Uses

- Orthodontic Models
- Other model applications



Property	
Tensile Modulus (ASTM D638)	2300 MPa
Ultimate Tensile Strength (ASTM D638)	55 MPa
Tensile Elongation at Break (ASTM D638)	4%
Hardness Shore D (ASTM D2240)	86

xDENT341-Beige

xDENT341-Beige is a high-resolution material designed for 3D printing removable die models with incredible accuracy and great dimensional stability. For this application, proper fit is key and with xDENT341-Beige, you can easily print removable die models exhibiting precise margins and contacts to deliver highly-accurate custom prosthodontic treatments like crowns, bridges, and other implants.

Colors

Beige

Characteristics

- High resolution
- Excellent accuracy
- Strong and rigid

Uses

- Removable die models for crowns, bridges, and other implants
- Other model applications



Property	Beige
Tensile Modulus (ASTM D638)	1860 MPa
Ultimate Tensile Strength (ASTM D638)	40 MPa
Tensile Elongation at Break (ASTM D638)	2.69%
Hardness Shore D (ASTM D2240)	84

KeyModel Ultra™

KeyModel Ultra is a material designed for 3D printing of dental and orthodontic models.

Colors

Ivory

Manufacturing Partner

Keystone

Characteristics

- Accurate
- Easy thermoforming release
- Flawless detail
- Carve-able without chipping

Uses

- Dental thermoforming application (100µm)
- Dental removal die and model application (50µm)



Property	Ivory
Tensile Modulus (ASTM D638)	3.7 MPa
Ultimate Tensile Strength (ASTM D638)	2.5 MPa
Tensile Elongation at Break (ASTM D638)	150 %
Flex Modulus (ASTM D790)	44
Flex Strength (ASTM D790)	47 %
Hardness Shore D (ASTM D2240)	85

KeySplint Hard®

KeySplint Hard is a splint material that performs equal to the lab processed Lucitone 199 with excellent wear resistance without tearing or cracking, and excellent resistance to fatigue failure.

Colors

Clear

Manufacturing Partner

Keystone

Characteristics

- Biocompatible
- Strong
- Easy to Polish
- Easily cleaned
- Abrasion resistant

Uses

- Rigid dental splints
- Night guards



Property	Clear
Tensile Elongation at Break (ASTM D638)	9 %
Flex Modulus (ASTM D790)	1600 MPa
Flex Strength (ASTM D790)	65 MPa
Water Absorption (ISO 20795-2)	18 µg/mm ³
Biocompatibility (ISO 10993-5)	Pass

KeySplint Soft®

KeySplint Soft is a strong material for splints, night guards and bleaching trays.

Colors

Clear

Manufacturing Partner

Keystone

Characteristics

- Biocompatible
- Strong
- Flexible
- Easy to Polish
- Easily Cleaned

Uses

- Splints
- Night Guards
- Bleaching Trays (100µm)

510K Compliance

- This material has been validated as *Keystone Compatible* by Keystone Industries.
- Its specific workflows have been validated as compliant with Keystone Industries 510K filings and Keystone Industries guarantees that customers can produce safe and effective medical devices with a Nexa3D printer if the approved workflow is followed.
- See [here](#) for more information.



Property	Clear
Tensile Elongation at Break (ASTM D638)	110 %
Flex Modulus (ASTM D790)	1400 MPa
Flex Strength (ASTM D790)	47 MPa
Hardness (ASTM D2240)	85
Cytotoxicity (ISO 10993)	Pass
Irritation (ISO 10993)	Pass
Sensitization (ISO 10993)	Pass

KeyGuide®

KeyGuide is ideal for fabricating transparent surgical guides, allowing doctors to place implants at a precise angle and depth.

Colors

Translucent

Characteristics

- Biocompatible
- Strong
- Easy to polish
- Autoclavable

Uses

- Surgical guides (100µm)

510K Compliance

- This material has been validated as *Keystone Compatible* by Keystone Industries.
- Its specific workflows have been validated as compliant with Keystone Industries 510K filings and Keystone Industries guarantees that customers can produce safe and effective medical devices with a Nexa3D printer if the approved workflow is followed.
- See [here](#) for more information.



Property	Translucent
Flex Modulus (ASTM D790)	2400 MPa
Flex Strength (ASTM D790)	106 MPa
Biocompatibility (ISO 10993-5)	Pass
Biocompatibility (ISO 10993-10)	Pass

KeyTray™

KeyTray is a strong, biocompatible (Class I) 3D printing resin designed to create customized, individual impression trays quickly and with precision. The material is strong and durable to withstand the forces of taking a patient impression and removing the tray from the oral cavity. It is compatible with all types of impression material.

Colors

Lavender

Manufacturing Partner

Keystone

Characteristics

- Biocompatible
- Strong
- No preliminary casting required
- Improved impression accuracy
- Compound waxes and border molding materials will adhere to tray

Uses

- Customized impression trays (100µm)

510K Compliance

- This material has been validated as *Keystone Compatible* by Keystone Industries.
- Its specific workflows have been validated as compliant with Keystone Industries 510K filings and Keystone Industries guarantees that customers can produce safe and effective medical devices with a Nexa3D printer if the approved workflow is followed.
- See [here](#) for more information.



Property	Lavender
Tensile Modulus (ASTM D638)	2056 MPa
Ultimate Tensile Strength (ASTM D638)	62 MPa
Tensile Elongation at Break (ASTM D638)	26 %
Flex Modulus (ASTM D790)	1913 MPa
Hardness Shore D (ASTM D2240)	86

KeyOrtho IBT™

KeyOrtho IBT combines the strength and precision to accurately set brackets, with the flexibility and non-stick formula needed for easy release.

Biocompatible, tasteless, and odorless, KeyOrtho IBT is ideal for manufacturing indirect bonding trays. Drastically reduce chair time and increase patient comfort during the orthodontic bracket setting process.

Colors

Translucent

Manufacturing Partner

Keystone

Characteristics

- Biocompatible
- Tasteless
- Odorless
- Easy release
- Good strength

Uses

- Indirect bonding trays manufacturing



Property	White
Tensile Modulus (ASTM D638)	10.5 MPa
Ultimate Tensile Strength (ASTM D638)	31 MPa
Tensile Elongation at Break (ASTM D638)	130 %
Biocompatibility (ISO 10993-5)	Pass
Viscosity @ 25°C (cP)	< 1000
Orthodontic Adhesive Release	Pass

We have an ultrafast 3D printer for your ultrafast application.

Want to know which Nexa3D printer best matches your needs?

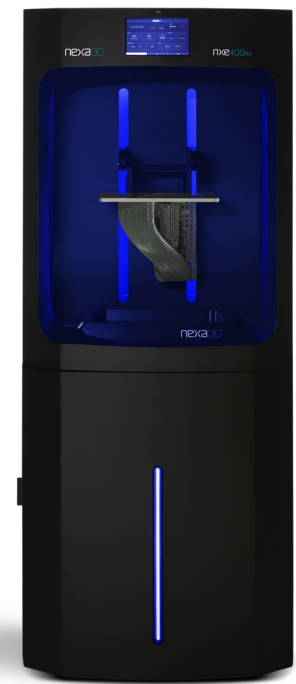
[Talk to an Expert](#)



XiP



XiP Pro



NXE400 Pro

nexa3D[®]

nexa3d.com