

Ultracur3D® RG 9400 B FR

Rigid | Flame-Retardant | Black

Extended TDS

**Complete Technical Documentation and
Testing Summary**

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Technical Data Sheet

Flame-retardant resin with UL 94 V-0 rating and superior HDT.

The data contained in this publication is based on our current knowledge and experience. In view of the many factors that may affect processing and application of our product, this data does not relieve processors from carrying out their own investigations and tests; neither does this data imply any guarantee of certain properties, nor the suitability of the product for a specific purpose.

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General Properties	Method	Typical Values (UV)
Appearance	-	Black
Viscosity, 25°C	Cone/Plate Rheometer ¹⁾	830 mPas
Viscosity, 30°C	Cone/Plate Rheometer ¹⁾	490 mPas
Density (Printed Part)	ASTM D792	1.32 g/cm³
Density (Liquid Resin)	ASTM D4052-18a	1.21 g/cm³

Tensile Properties ²⁾	Method	Typical Values	
		(UV)	(UV + Thermal ³⁾)
E Modulus	ASTM D638	3900 MPa	4200 MPa
Ultimate Tensile Strength	ASTM D638	78 MPa	74 MPa
Elongation at Break	ASTM D638	3%	2%

Flexural Properties	Method	Typical Values (UV)
Flexural Modulus	ASTM D790	3400 MPa
Flexural Strength	ASTM D790	115 MPa

Impact Properties	Method	Typical Values (UV)
Notched Izod (Machined), 23°C	ASTM D256	20 J/m
Unnotched Izod, 23°C	ASTM D4812	176 J/m
Notched Charpy (Machined), 23°C	ISO 179-1	0.9 kJ/m²

Thermal Properties	Method	Typical Values	
		(UV)	(UV + Thermal ³⁾)
HDT at 0.45 MPa	ASTM D648	255°C	280°C
HDT at 1.82 MPa	ASTM D648	86°C	152°C
Glass transition temperature (DMA, tan(d))	ASTM D4065	175°C	-
Degradation temperature (TGA, 5% mass loss, air)	ISO 11358	330°C	-

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Advanced Thermal Properties	Method	Typical Values (UV)
C.T.E. (-45°C to 0°C)	ASTM E831	49 µm/(m·K)
C.T.E. (0°C to 50°C)	ASTM E831	81 µm/(m·K)
C.T.E. (50°C to 100°C)	ASTM E831	137 µm/(m·K)
C.T.E. (100°C to 150°C)	ASTM E831	111 µm/(m·K)
Specific heat capacity, 23°C ⁴⁾	MTPS	1.22 J/(g·K)
Specific heat capacity, 200°C ⁴⁾	MTPS	1.99 J/(g·K)

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Fire, Smoke, Toxicity (FST) properties	Method	Typical Values (UV)
Flammability	UL 94	V-0 (3.0 mm) V-0 (2.5 mm) V-0 (2.0 mm) V-1 (1.5 mm) HB (1.0 mm)
Hot-Wire Ignition (HWI)	UL 746 A (2.0 mm)	PLC 0 ($\geq 120s$)
High Amp Arc Ignition (HAI)	UL 746 A (2.0 mm)	PLC 0 ($> 150s$)
Fire classification Railway (R22)	DIN EN 45545-2	compliant to HL1 (2.0 mm, 2.5 mm)
Fire classification Railway (R23, R24)	DIN EN 45545-2	compliant to HL2 (2.0 mm, 2.5 mm)
Smoke generation and density	ISO 5659-2	$D_s(4) < 600$ $VOF4 < 1200$ $D_s(\max) < 600$ (2.0 mm, 2.5 mm)
Limiting Oxygen Index	ISO 4589-2	LOI ≥ 28.0
Smoke gas toxicity	NF X70-100	CIT _{NLP} : 0.43
Glow-wire Test	IEC 60695-2-12/-13 (2.1 mm)	GWIT: 825°C GWFI: 960°C
Vertical flammability 12s ⁵⁾	FAR 25.853 App F, Part I (a)(1)(ii)-	PASS (2.0 mm)
Smoke density – Flaming ⁵⁾	FAR 25.853 App F, Part V	525 (2.0 mm)
Smoke toxicity – Flaming ⁵⁾	BSS 7239	PASS (2.0 mm)

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Dielectric/Electric Properties	Method	Typical Values (UV)
Dielectric Strength	DIN EN 60243-1	31 kV / mm
Volume resistivity	DIN EN 62631-3-1	2.20E+13 Ωcm
Surface resistivity	DIN EN 62631-3-2	4.50E+13 Ω
Comparative tracking index (CTI)	DIN EN 60112	PLC 0 (≥ 600 V)
RTI (Elec, Imp., Str.)	UL 746 B (generic value)	50°C
Dielectric constant, 1 MHz	IEC 62631-2-1	3.4
Dissipation factor, 1 MHz	IEC 62631-2-1	0.004

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Biocompatibility	Method	Typical Values (UV +Thermal ³⁾)
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Cytotoxicity – Neutral Red	EN ISO 10993-5 (2009)	PASS ⁶⁾
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Other	Method	Typical Values
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Hardness Shore D	ASTM D2240	88
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Volatile content, outgassing in vacuum (125°C, 24 hours)	ASTM E595-15	mass loss <0.2%
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Water Absorption, Short-Term (24 hours)	ASTM D570	0.65%
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Water Absorption, Long-Term (>1500 hours)	ASTM D570	>5%
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Mechanical properties overview

- 1) Determined with TA-Instrument DHR rheometer, cone/plate, diameter 60 mm, shear rate 100 s⁻¹. Samples were preheated 5h at 40°C to make sure no solid crystals are present.
- 2) Tensile type ASTM D638 type IV, Pulling speed 5 mm/min
- 3) Regular UV post-curing and additional thermal post-cure of 3h at 150°C, see [User Guideline](#) for more details.
- 4) Data at different temperatures are available on request
- 5) Different aerospace manufacturers and regulators use different names to refer to very similar or equivalent tests, please refer to the following table:

Test	FAR = JAR = CS	Airbus	Boeing
Vertical flammability 12s	FAR 25.853 App F, Part I (a)(1)(ii)	AITM 2.0002B	BSS 7230 F2
Smoke density	FAR 25.853 App F, Part V	AITM 2.0007A & B	BSS 7238
Smoke toxicity	-	AITM 3.0005	BSS 7239

- 6) For the statement on Biocompatibility data see Chapter: [Biocompatibility](#).
- 7) If not noted otherwise, all specimens are 3D printed. Samples were tested at room temperature, 23°C. ASTM sample size (L x W x H): ASTM D790 127 x 3.2 x 12.7 mm, ASTM D256 63 x 12.7 x 12 mm, ASTM D4812 63 x 12.7 x 12 mm, ASTM D648 127 x 3.2 x 13 mm, ISO 179-1 80 x 4 x 10 mm, UL 94 125 x 3 x 13 mm, IEC 60695-2-12/-13 60 x 21 x 60 mm.

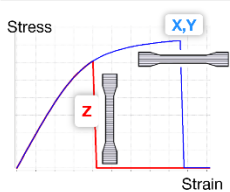
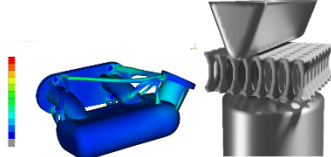
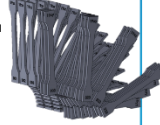
Printing Performance

The combination of 3D printer and material has a huge impact on the quality of the parts produced. The measured design characteristics as well as the printing speed can be found in the [Printing Evaluation Guideline of Ultracur3D® Resins](#).

Material Model & FEA Simulation

FEA simulation can be used to predict how different parameters such as temperature and mechanical stress affect the final printed parts. This information can be used to significantly expedite application development, and to optimize the part design to ensure all performance requirements for the application are met. In order to run simulations with a specific material, a material model is required. This model is generated based on a wide range of testing data under different loads and at different temperatures and other relevant conditions.

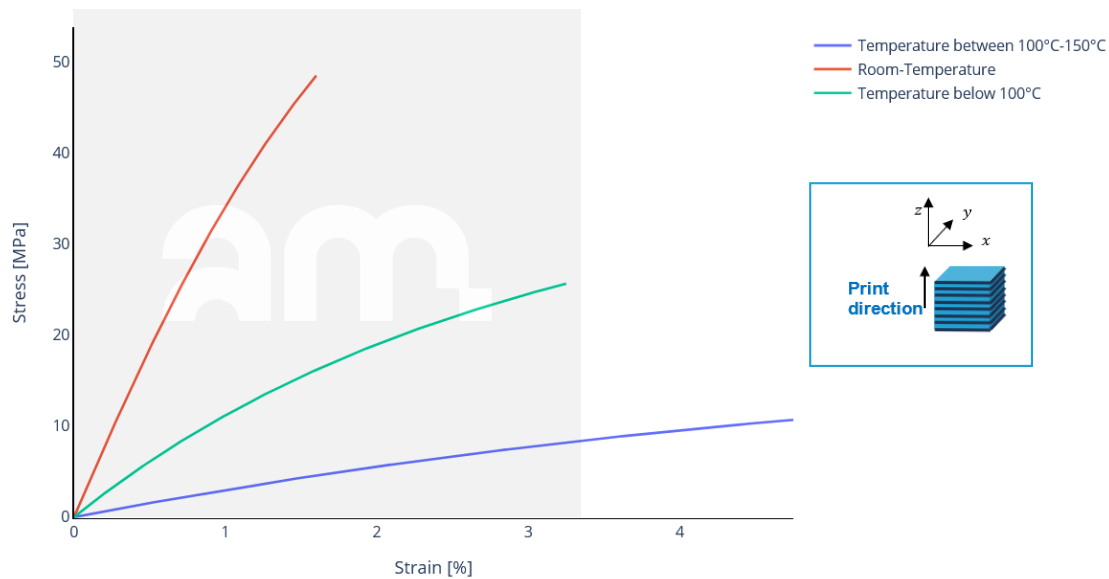
We can support you with 3D simulation in different ways, ranging from simply supplying you with raw test data, to doing the full simulation for you. These are the 3 options we offer:

Raw Material Data	3D Simulation	Material Model as a Service
Starter: Get the curves behind our TDS data to start basic simulation work. 	Premium: We run the simulation for you. We help you to speed up your engineering process and increases confidence in part performance using a digital twin of your part. 	Enterprise: Use our in-house developed material models for 3D-Printing incl. anisotropy of the process and FEA support of our experienced virtual engineers. - Anisotropic - Nonlinear - Strain-rate sensitive - Tensile-compression asymmetry - Failure modelling - Temperature dependent 

Specifically for Ultracur3D® RG 9400 B FR, below you can find some of the data (at specific temperatures / mechanical loads) we have available in our Ultrasim® Material Model or that we could provide to you for your own simulations. More information is available on request (sales@forward-am.com).

	Available temperatures			Strain rate / loads	
	Low	23°C	High	Quasi static	High speed
Ultracur3D® RG 9400 B FR		●	●	●	

- Validated, available as Material Data Set (can be converted into a Ultrasim® Material Model)
- Validated, available via Ultrasim® Material Model
- Preliminary



Stress-strain response of Ultracur3D® RG 9400 B FR under quasi static load, loaded in x direction, at different temperatures.

Warning: The description of polymer materials under large strains with standard hyperelastic material models (Mooney-Rivlin, Ogden, Polynomial type) offered by common FEM programs/solvers can lead to significant deviations from the experimentally observed mechanical response. To achieve realistic simulation results extended models have to be considered to account for effects like strain rate dependence, viscous behavior, strain softening (Mullins Effect) and permanent deformation. MAM has developed such models which are made available via Ultrasim® to support our customers with high confidence simulations.

Additional material data available on request		Quasi static Raw data (.csv/ASCII)	Request raw data for internal use via sales@forward-am.com or your key account See full material overview under: Material data overview For more information visit : Ultrasim® 3D Simulation (FEA) (forward-am.com)
		Low temperature performance	
		High temperature performance	
		Higher strain rate performance	
		Additional load cases (x,y,z,xy)	

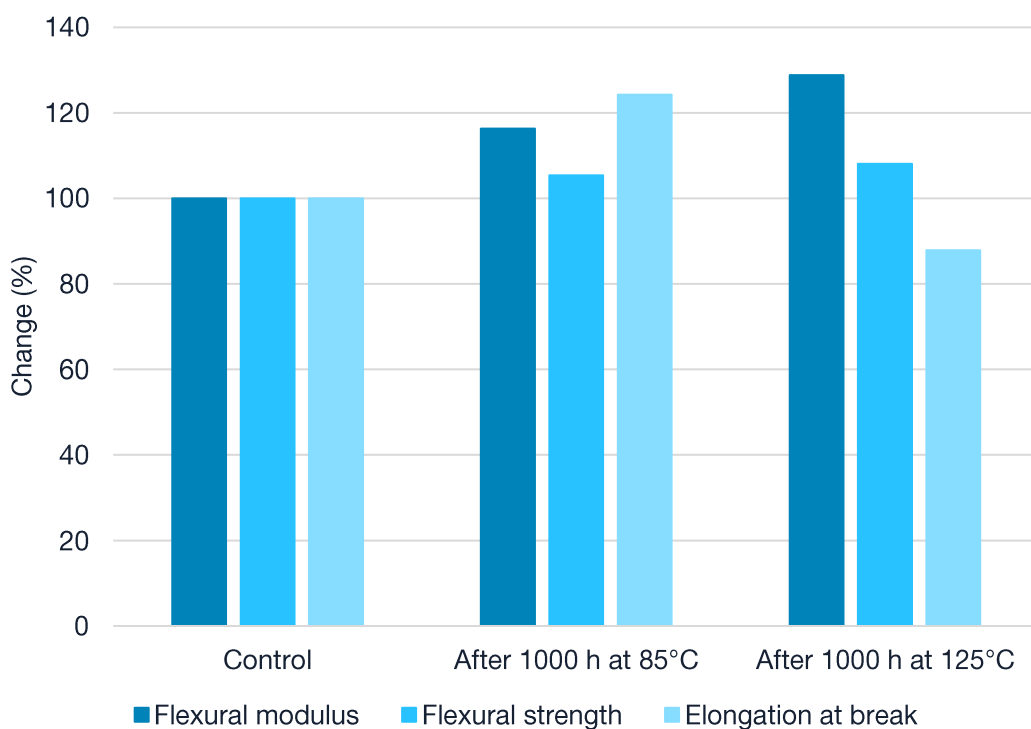
Heat Ageing

Long-time exposure to increased temperatures can have a substantial effect on material performance. Measuring these data can help to determine whether the material is suitable for applications that require it to maintain a certain performance after extended times at high temperatures.

Test Method and Specimens

Flexural bars were stored for 1000 h (+6 weeks) at two temperatures, 85°C and 125°C. After the temperature storage, samples were cooled down to room temperature and subsequently measured.

Mechanical Testing



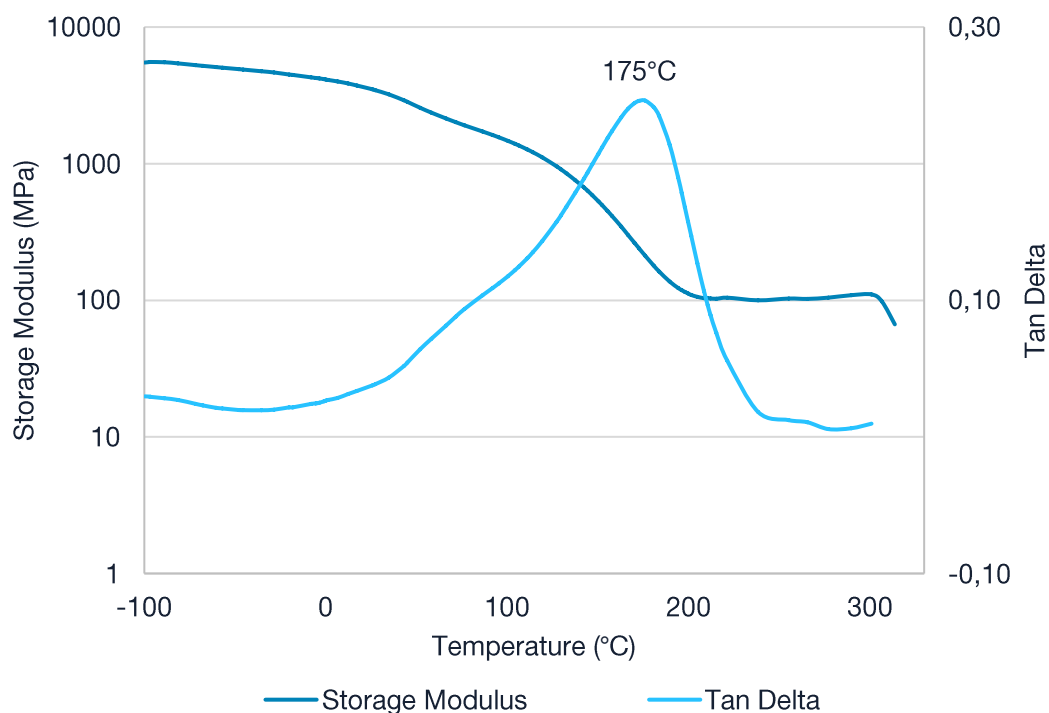
Change in mechanical properties after 1000 h

Dynamic Mechanical Analysis (DMA)

In this DMA measurement, a cyclic strain is applied to the sample, and the response of the sample is recorded as a function of temperature. This can give a good impression of the changes in material behavior, both at low and high temperatures. The measured Storage modulus is a good indication of the stiffness of the material. The maximum in Tan Delta gives the glass transition temperature.

	Setting
Measurement	Strain-controlled
Temperature sweep	1°C / min
Strain	0.023% (linear viscoelastic regime)
Type of loading	Dual cantilever
Frequency	1 Hz

Testing conditions DMA



DMA curve

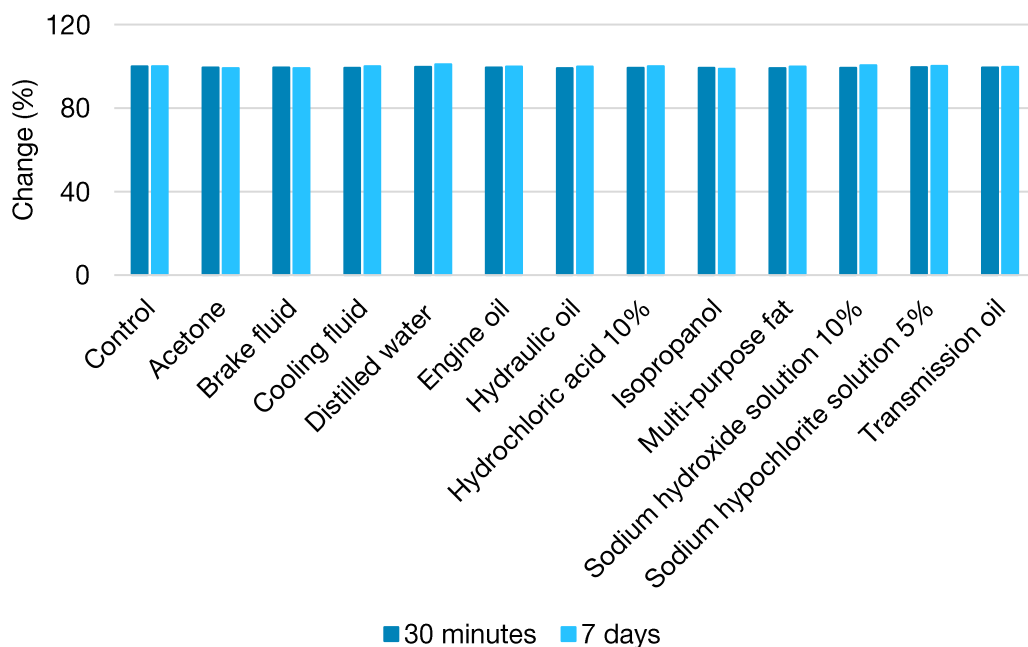
Industrial Chemical Resistance

The resistance of resin materials against chemicals, solvents and other contact substances is an important criterion of selection for many industrial applications. General chemical resistance depends on the period of exposure, the temperature, the quantity, the concentration and the type of the chemical substance. When exposed to industrial chemicals, the chemical bonds of photopolymers can break or degrade, causing a change in the mechanical properties.

Test Method and Specimens

ASTM D638 type IV tensile bars were soaked in each fluid at room temperature, one set for 30 minutes and one set for 7 days. Upon completion of the soaking time, the parts were removed from the test fluid and were dried, conditioned for 24 hours at 22°C before measuring the weight and the mechanical properties.

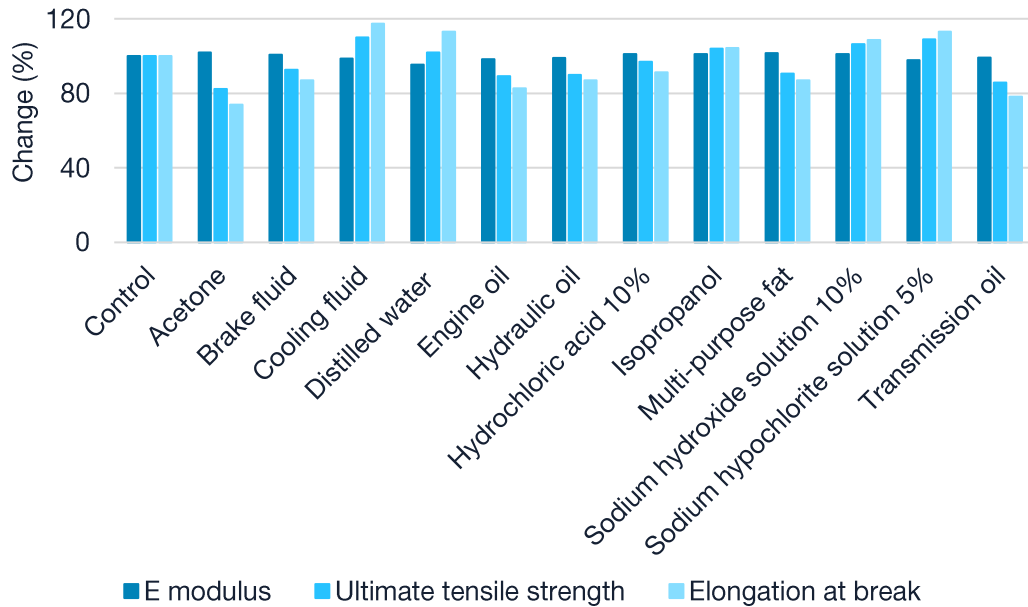
Weight Measurement



Change in weight after immersion time

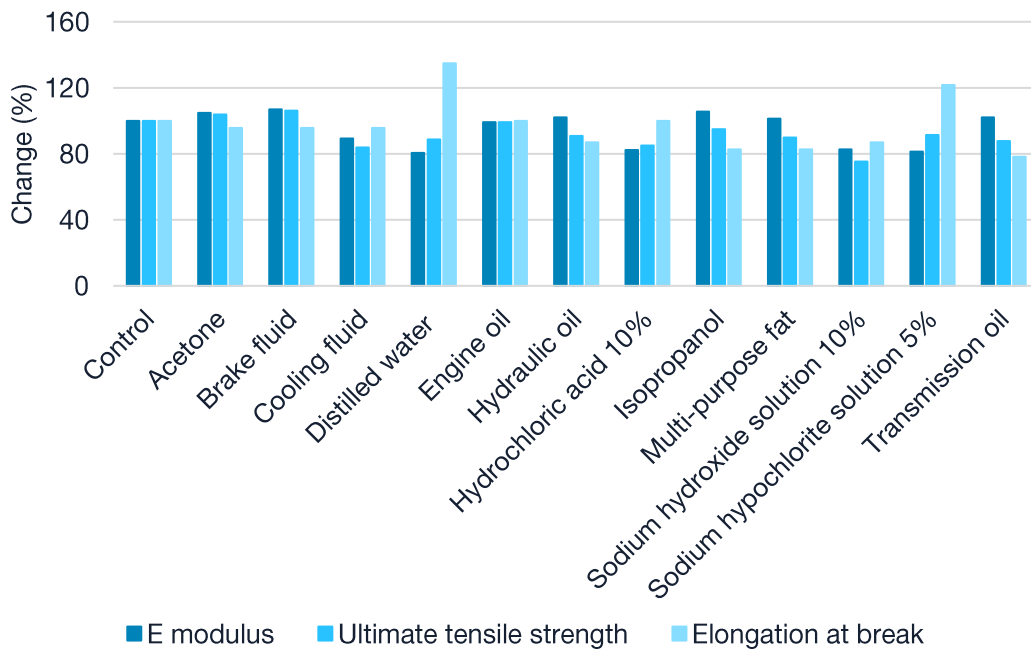
Mechanical Testing

30 minutes



Change in mechanical properties after 30 minutes immersion

7 days



Change in mechanical properties after 7 days immersion

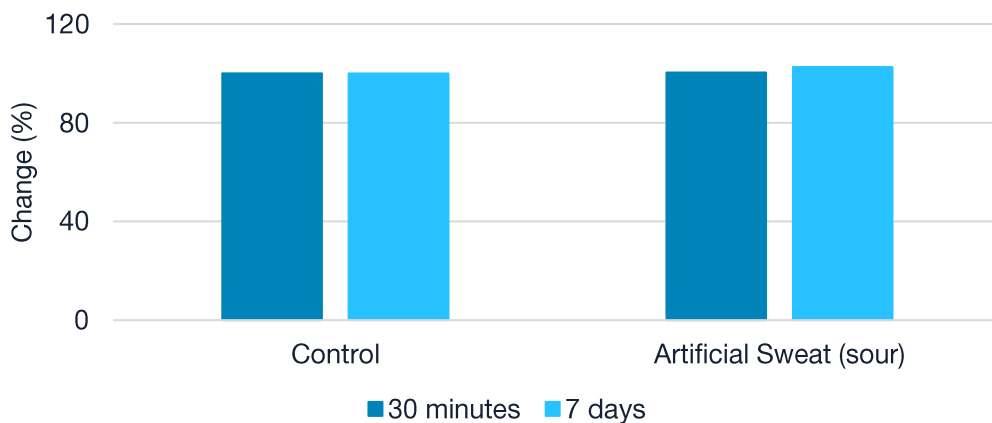
Consumer Chemical Resistance

Similar to the industrial sector, different consumer applications may also require resistance against various chemicals, solvents and other contact substances. Testing for these application-specific requirements helps to evaluate the suitability of photopolymers for the intended use.

Test Method and Specimens

ASTM D638 type IV tensile bars were soaked in each fluid at room temperature, one set for 30 minutes and one set for 7 days. Upon completion of the soaking time, the parts were removed from the test fluid and were dried to measure the weight and mechanical properties.

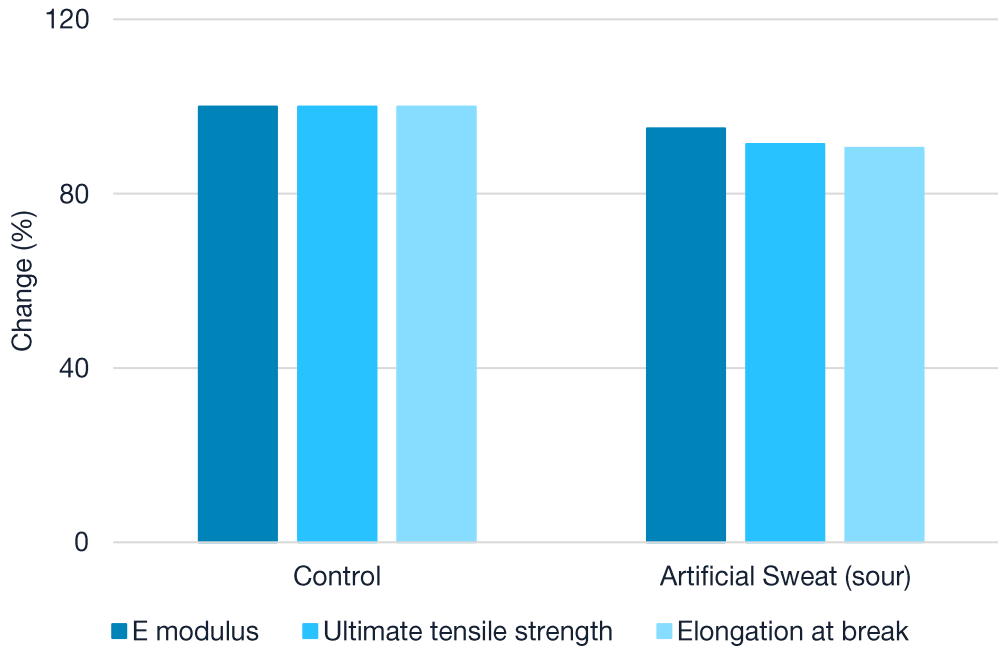
Weight Measurement



Change in weight after immersion time

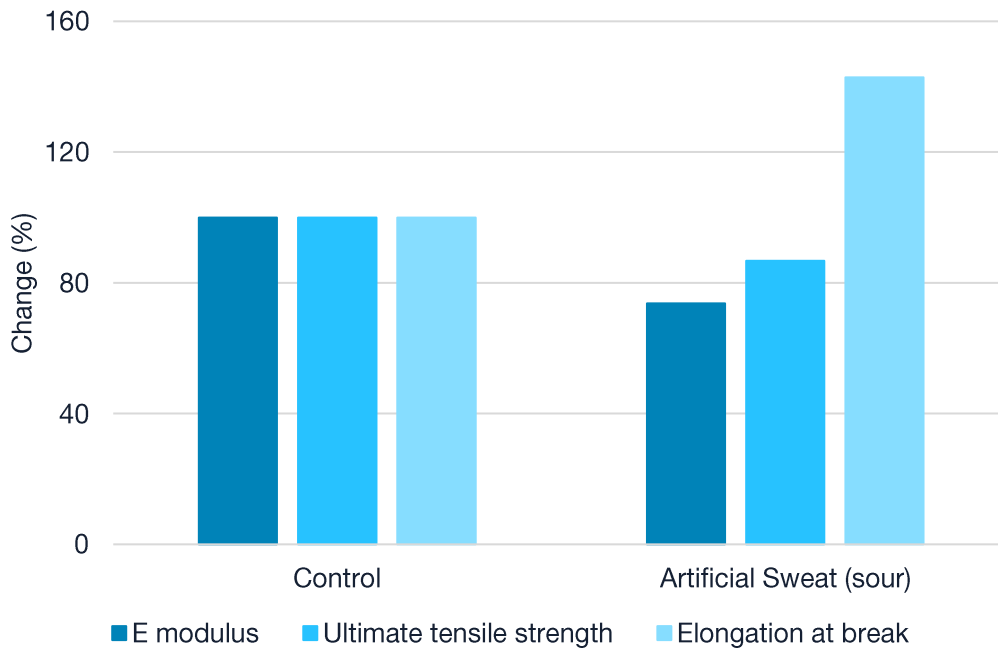
Mechanical Testing

30 minutes



Change in mechanical properties after 30 minutes immersion

7 days



Change in mechanical properties after 7 days immersion

Long-Term UV

Durability is a key feature for the components utilized within many industries, as they expect the materials used to withstand years of exposure to the elements. Through the effects of UV radiation, photopolymers can degrade over time. The aging can be caused by the influence of UV light, heat and water. The degree of ageing depends on duration and intensity.

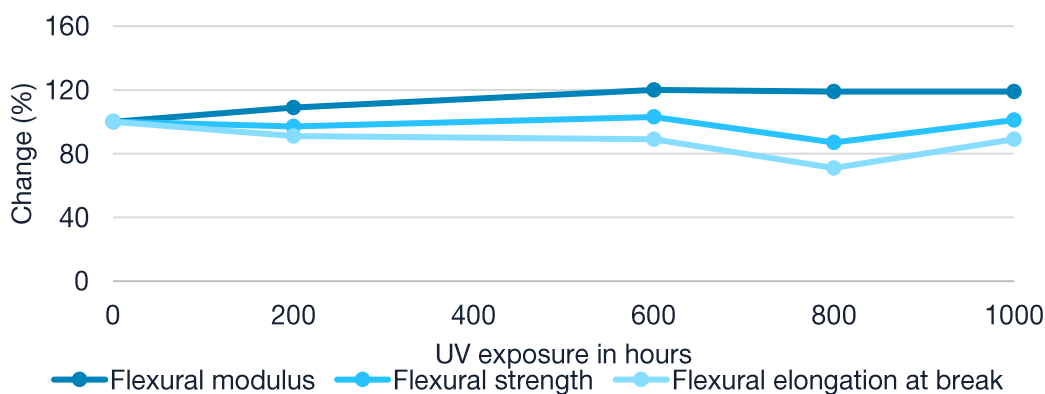
Test Method and Specimens

The ageing tests were performed with ASTM D638 type IV tensile bars and color plates as per ISO 4892-2:2013 method A, cycle 1. Exposed samples were always removed at the end of a dry cycle, and conditioned for 24 hours at 22°C before mechanical testing.

Cycle No.	Exposure period	Irradiance		Black standard temperature in °C	Chamber temperature in °C	Relative humidity in %
		Broadband (300 nm to 400 nm) in W/m ²	Narrowband (340 nm) in W/(m ² nm)			
1	102 min dry	60 ± 2	0.51 ± 0.02	65 ± 3	38 ± 3	50 ± 10
	18 min water spray	60 ± 2	0.51 ± 0.02	-	-	-

Testing conditions for ISO 4892-2 method A, cycle 1

Mechanical Testing



Change in mechanical properties after accelerated weathering

The final values after 1000 hours of long-term UV exposure can be found below.

Property	Before long-term UV exposure	After 1000 hours of UV exposure
Flexural modulus	3400 MPa	4030 MPa
Flexural strength	115 MPa	116 MPa
Flexural elongation at break	3.5%	3.1%

Mechanical properties before and after 1000 hours of UV exposure as per ISO 4892:2 method A

Coloration

After being exposed up to 1000 hours, there was no visual change or additional yellowing compared to the reference sample.



Effect of UV exposure on color of the specimens

Flammability Testing

In addition to mechanical properties and color, also UL94 flammability was evaluated after long-term UV exposure. Samples (2mm thickness) exposed for respectively 400h and 1000h were tested, and both obtained the V-0 flammability rating. So it appears the UV weathering did not affect the flame retardant properties of the material.

Biocompatibility

Product: Ultracur3D® RG 9400 B FR

Revision: 10th of June 2024

3D printed test items of the above stated product have fulfilled the requirements of tests as stated below:

Cytotoxicity Testing- Neutral Red:

(EN ISO 10993-5 (2009))

Additionally

Parts underwent an additional thermal post curing as described in the User Guideline for this material.

The biocompatibility tests were recorded on test specimen of the referenced product to show compatibility of the material in general. The biocompatibility tests listed are not part of any continuous production protocol. The test assessments reflect only the test specimen and have to be retested on the final product. It remains the responsibility of the device manufacturers and /or end-users to determine the suitability of all printed parts for their respective application.

For notice:

We give no warranties, expressed or implied, concerning the suitability of mentioned product for use in any medical device and pharmaceutical applications.

All information contained in this document is given in good faith and is based on sources believed to be reliable and accurate at the date of publication of this document.

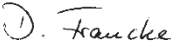
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Flammability UL 94 Data

Formblatt MA4.5_F003, Revision: 3.4, gültig ab: 05.01.2021



TEST REPORT according to ISO/IEC 17025 No. AVS: 2304644 Date: 2024-01-31 File: 2304644_3DPS_V_EN.DOCX		 DAKKS Deutsche Akkreditierungsstelle D-PL-14121-04-00	
Testing laboratory BASF SE RBU Performance Materials Europe Materials and Parts Testing PMD/EX-H201 67056 Ludwigshafen Deutschland		Contact at laboratory Name: Daniel Francke Phone: +49 621 60 46167 E-Mail: daniel.francke@basf.com Position: Team lead Signature: 	
Client Company: BASF 3D Printing Solutions GmbH Speyerer Strasse 4 69115 Heidelberg Germany		Contact at client Name: Joshua Schell Phone: +49 62216741712 E-Mail: atlas@basf-3dps.com	
Test specimen / Material A2023_5688 ULTRACUR3D RG 9400 B FR		Test methods (Standard and publication date) - IEC 60695-11-10:2014 vertical (equivalent to UL94:2024)	
Order received on: 2023-10-23 Specimen received on: 2023-10-24 Tests conducted on: 2023-10-24, 2023-11-02		This report contains: Pages: 3 Diagrams: 0 Tables: 2 Photos: 0 Attachments: 2	

Decision rule

Compliance with flame class V-0.

Result

Test specimen in nominal thickness 2 and 2.5 mm were subjected to vertical flammability testing according to DIN EN 60695-11-10:2014 (equivalent to UL94:2024). The test result is class V-0.

The test results of this report are only valid for the specimens tested and only describe the results achieved by the application of the particular tests methods to these specimens. They do not imply any guarantee nor any agreement on a contractual quality or a suitability of the product for a specific purpose. In view of the many factors that may affect processing and application of the product, the test results do not relieve processor from carrying out own investigations and tests. The report does not imply any recommendation for a product. The report shall only be reproduced and passed on in full.

The testing laboratory is accredited by DAkkS Deutsche Akkreditierungsstelle GmbH (German Accreditation Body) according to ISO 17025 for mechanical, thermal, physical-chemical and flammability tests. The accreditation is valid only for the scope of accreditation listed in the Annex to the accreditation certificate (Registration No. D-PL-14121-04-00).

Page 1 of 3



We create chemistry

TEST REPORT

BASF SE, PMD/EX - H202, D-67056 Ludwigshafen
Tester: Miriam Miedreich

Page 1 of 1

Order no.: 0 -E039/GK SAP: 40357409
Customer: Knopf Giulia / Ott Christian

Date of order: 2023-10-24
AVS no.: 2304644
PDF no.: 379

Product: 3 A2023_5688 ULTRACUR3D RG 9400 B FR
ZXY D_2MM 40009143_LFS

Preparation: As received
Conditioning:
Comments:

***** Flame testing *****
Flammability V acc. to UL 94 : 2023

Information about test procedure and test specimens

M 0 0323			Measurements & observations										Classification
Dimensions of test specimens 127 * 12,7 * d mm²			1st flame application, 10 s				2nd flame application, 10 s				Total Afterflame time t1 + t2 [s]		
			After- flame time t1 [s]	Cotton indicator ignited?	Burning up to holding clamp?	Observations	After- flame time t2 [s]	Cotton indicator ignited?	Burning up to holding clamp?	Observations		Afterflame & Afterglow time t2 + t3 [s]	
Requirements			≤ 10 ≤ 30 ≤ 30	no no yes	no no no	--- --- ---	≤ 10 ≤ 30 ≤ 30	no no yes	no no no	--- --- ---	≤ 30 ≤ 60 ≤ 60	≤ 50 ≤ 250 ≤ 250	= V-0 = V-1 = V-2
Pre-conditioning	Spec no.	Thickn [mm]	Abbrev.: A=dripping parts, K=edge-burning, T=dripping parts, R=rolls up										V-0
Conditioning chamber (2d / 23°C / 50%)	1	2.01	10	No	No		1	No	No		1		
	2	1.99	1	No	No		4	No	No		4		
	3	2.00	2	No	No		4	No	No		4		
	4	2.00	1	No	No		3	No	No		3		
	5	1.96	0	No	No		5	No	No		5	31	
			First test 2023-10-24 9:54 - 2023-10-24 9:59										
Drying oven (7d / 70°C)	1	2.01	1	No	No		4	No	No		4		
	2	1.99	1	No	No		2	No	No		2		
	3	2.01	1	No	No		1	No	No		1		
	4	1.98	11	No	No		4	No	No		4		
	5	2.01	1	No	No		4	No	No		4	30	
			First test 2023-11-02 14:40 - 2023-11-02 14:46										
Conditioning chamber (2d / 23°C / 50%)	1												
	2												
	3												
	4												
	5												
			Repeated test -										
Drying oven (7d / 70°C)	1	2.05	1	No	No		3	No	No		3		
	2	1.98	1	No	No		3	No	No		3		
	3	2.10	1	No	No		2	No	No		2		
	4	1.99	1	No	No		3	No	No		3		
	5	1.98	1	No	No		3	No	No		3	19	
			Repeated test 2023-11-02 14:46 - 2023-11-02 14:51										
			V-0 @2.0mm										

Date of report: 2023-11-02

Page 2 of 3



We create chemistry

TEST REPORT

BASF SE, PMD/EX - H202, D-67056 Ludwigshafen
Tester: Miriam Miedreich

Page 1 of 1

Order no.: 0 -E039/GK SAP: 40357409
Customer: Knopf Giulia / Ott Christian

Date of order: 2023-10-24
AVS no.: 2304644
PDF no.: 380

Product: 4 A2023_5688 ULTRACUR3D RG 9400 B FR
ZXY D_2,5MM 40009143_LFS

Preparation: As received
Conditioning:
Comments:

***** Flame testing *****
Flammability V acc. to UL 94 : 2023

Information about test procedure and test specimens

M 0 0323			Measurements & observations										Classification
Dimensions of test specimens 127 * 12,7 * d mm²			1st flame application, 10 s				2nd flame application, 10 s				Total Afterflame time t1 + t2 [s]		
			After- flame time t1 [s]	Cotton indicator ignited?	Burning up to holding clamp?	Observations	After- flame time t2 [s]	Cotton indicator ignited?	Burning up to holding clamp?	Observations			Afterflame & Afterglow time t2 + t3 [s]
Requirements			≤ 10 ≤ 30 ≤ 30	no no yes	no no no	--- --- ---	≤ 10 ≤ 30 ≤ 30	no no yes	no no no	--- --- ---	≤ 30 ≤ 60 ≤ 60	≤ 50 ≤ 250 ≤ 250	= V-0 = V-1 = V-2
Pre-conditioning	Spec no.	Thickn [mm]	Abbrev.: A=dripping parts, K=edge-burning, T=dripping parts, R=rolls up										V-0
Conditioning chamber (2d / 23°C / 50%)	1	2.49	1	No	No		3	No	No		3		
	2	2.49	1	No	No		3	No	No		3		
	3	2.50	1	No	No		1	No	No		1		
	4	2.48	1	No	No		2	No	No		2		
	5	2.50	1	No	No		2	No	No		2	16	
			First test 2023-10-24 10:00 - 2023-10-24 10:29										V-0
Drying oven (7d / 70°C)	1	2.48	1	No	No		1	No	No		1		
	2	2.46	1	No	No		1	No	No		1		
	3	2.47	1	No	No		1	No	No		1		
	4	2.50	1	No	No		1	No	No		1		
	5	2.45	1	No	No		1	No	No		1	10	
			First test 2023-11-02 14:55 - 2023-11-02 15:01										
Conditioning chamber (2d / 23°C / 50%)	1												
	2												
	3												
	4												
	5												
			Repeated test -										
Drying oven (7d / 70°C)	1												
	2												
	3												
	4												
	5												
			Repeated test -										V-0 @2.5mm

Date of report: 2023-11-02

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Formblatt MA4.5 F003, Revision: 3.4, gültig ab: 05.01.2021



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TEST REPORT according to ISO/IEC 17025 No. AVS: 2303493 Date: 2023-10-11 File: 2303493_3DPS_V_EN.DOCX		 DAKKS Deutsche Akkreditierungsstelle D-PL-14121-04-00	
Testing laboratory BASF SE RBU Performance Materials Europe Materials and Parts Testing PMD/EX-H201 67056 Ludwigshafen Deutschland		Contact at laboratory Name: Daniel Francke Phone: +49 621 60 46167 E-Mail: daniel.francke@basf.com Position: Team lead Signature: 	
Client Company: BASF 3D Printing Solutions GmbH Speyerer Strasse 4 69115 Heidelberg Germany		Contact at client Name: Giulia Knopf Phone: +49 152 56449881 E-Mail: atlas@basf-3dps.com	
Test specimen / Material A2023_5323 Ultracur3D RG 9400 B FR A2023_5507 Ultracur3D RG 9400 B FR		Test methods (Standard and publication date) - IEC 60695-11-10:2014 vertical (equivalent to UL94:2023)	
Order received on: 2023-07-31 Specimen received on: 2023-07-31 Tests conducted on: 2023-08-08, 2023-09-07		This report contains: Pages: 3 Diagrams: 0 Tables: 2 Photos: 0 Attachments: 2	

Decision rule

Compliance with flame class V-0.

Result

Test specimen of three materials in nominal thickness 3 mm were subjected to vertical flammability testing according to DIN EN 60695-11-10:2014 (equivalent to UL94:2023). The test result is class V-0.

The test results of this report are only valid for the specimens tested and only describe the results achieved by the application of the particular tests methods to these specimens. They do not imply any guarantee nor any agreement on a contractual quality or a suitability of the product for a specific purpose. In view of the many factors that may affect processing and application of the product, the test results do not relieve processor from carrying out own investigations and tests. The report does not imply any recommendation for a product. The report shall only be reproduced and passed on in full.

The testing laboratory is accredited by DAkkS Deutsche Akkreditierungsstelle GmbH (German Accreditation Body) according to ISO 17025 for mechanical, thermal, physical-chemical and flammability tests. The accreditation is valid only for the scope of accreditation listed in the Annex to the accreditation certificate (Registration No. D-PL-14121-04-00).

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We create chemistry

TEST REPORT

BASF SE, PMD/EX - H202, D-67056 Ludwigshafen
Tester: Ilona Hiebl

Page 1 of 1

Order no.: 0 -E030/GK SAP: 40357409
Customer: Knopf Giulia / Pitz Andreas
Product: 1 A2023_5323_3MM RG9400_B_FR BLACK
40010605_LFS
Preparation: 3D-Printing
Conditioning:
Comments: Samples were post-processed with regular UV post-curing.

Date of order: 2023-07-31
AVS no.: 2303493
PDF no.: 295

***** Flame testing *****
Flammability V acc. to UL 94 : 2023

Information about test procedure and test specimens

M 0 0324			Measurements & observations										Classification
Dimensions of test specimens 127 * 12,7 * d mm²			1st flame application, 10 s				2nd flame application, 10 s				Total		
			After- flame time t1 [s]	Cotton indicator ignited?	Burning up to holding clamp?	Observations	After- flame time t2 [s]	Cotton indicator ignited?	Burning up to holding clamp?	Observations	Afterflame & Afterglow time t2 + t3 [s]	Afterflame time t1 + t2 [s]	
Requirements			≤ 10	no	no	---	≤ 10	no	no	---	≤ 30	≤ 50	= V-0
			≤ 30	no	no	---	≤ 30	no	no	---	≤ 60	≤ 250	= V-1
			≤ 30	yes	no	---	≤ 30	yes	no	---	≤ 60	≤ 250	= V-2
Pre-conditioning	Spec no.	Thickn [mm]	Abbrev : A=dripping parts, K=edge-burning, T=dripping parts, R=rolls up										
Conditioning chamber (2d / 23°C / 50%)	1	3.04	1	No	No		1	No	No		1		V-0
	2	3.08	1	No	No		1	No	No		1		
	3	3.02	1	No	No		1	No	No		1		
	4	3.03	1	No	No		1	No	No		1		
	5	3.04	1	No	No		1	No	No		1	10	
			First test 2023-08-03 14:23 - 2023-08-03 14:26										
Drying oven (7d / 70°C)	1	3.03	2	No	No		3	No	No		3		V-0
	2	3.04	1	No	No		2	No	No		2		
	3	3.02	1	No	No		3	No	No		3		
	4	3.03	1	No	No		1	No	No		1		
	5	3.04	1	No	No		2	No	No		2	17	
			First test 2023-08-08 10:09 - 2023-08-08 10:15										
Conditioning chamber (2d / 23°C / 50%)	1												V-0 @3.0mm
	2												
	3												
	4												
	5												
			Repeated test -										
Drying oven (7d / 70°C)	1												V-0 @3.0mm
	2												
	3												
	4												
	5												
			Repeated test -										

Comment MT:

Date of report: 2023-08-08

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Hiebl



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TEST REPORT

BASF SE, PMD/EX - H202, D-67056 Ludwigshafen

Page 1 of 1

Tester: Miriam Miedreich

Date of order: 2023-08-31

Order no.: 0 -E035/GK SAP: 40357409

AVS no.: 2303955

Customer: Knopf Giulia / Pitz Andreas

PDF no.: 14

Product: 1 A2023_5507 U_CUR3D_RG9400 SCHWARZ

EKO_0257_3MM 40010805_LFS

Preparation: 3D-Printing

Comments: Samples were post-processed with regular UV post-curing and additional thermal post-cure of 3h at 150°C.

***** Flame testing *****

Flammability V acc. to UL 94 : 2023

Information about test procedure and test specimens

M 0 0323			Measurements & observations										Classification	
Dimensions of test specimens 127 * 12,7 * d mm²			1st flame application, 10 s				2nd flame application, 10 s				Total Afterflame time t1 + t2 [s]			
			After- flame time t1 [s]	Cotton indicator ignited?	Burning up to holding clamp?	Observa- tions	After- flame time t2 [s]	Cotton indicator ignited?	Burning up to holding clamp?	Observa- tions		Afterflame & Afterglow time t2 + t3 [s]		
Requirements			≤ 10	no	no	---	≤ 10	no	no	---	≤ 30	≤ 50	= V-0	
			≤ 30	no	no	---	≤ 30	no	no	---	≤ 60	≤ 250	= V-1	
			≤ 30	yes	no	---	≤ 30	yes	no	---	≤ 60	≤ 250	= V-2	
Pre-conditioning			Spec no.	Thickn [mm]	Abbrev.: A=dripping parts, K=edge-burning, T=dripping parts, R=rolls up									
Conditioning chamber (2d / 23°C / 50%)			1	3.01	1	No	No		1	No	No		1	V-0
			2	3.00	1	No	No		1	No	No		1	
			3	2.99	1	No	No		1	No	No		1	
			4	3.03	1	No	No		2	No	No		1	
			5	2.95	1	No	No		1	No	No		1	
			11											
			First test 2023-09-05 14:35 - 2023-09-05 14:40											
Drying oven (7d / 70°C)			1	3.01	1	No	No		2	No	No		2	V-0
			2	3.03	1	No	No		1	No	No		1	
			3	2.96	1	No	No		1	No	No		1	
			4	2.99	1	No	No		1	No	No		1	
			5	2.98	1	No	No		1	No	No		1	
			11											
			First test 2023-09-07 10:14 - 2023-09-07 10:26											
Conditioning chamber (2d / 23°C / 50%)			1											
			2											
			3											
			4											
			5											
			Repeated test -											
Drying oven (7d / 70°C)			1											
			2											
			3											
			4											
			5											
			Repeated test -											
			Repeated test -											
			V-0 @3.0mm											

Date of report: 2023-09-07

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Smoke Optical Density Data

BASF – Fire Safety Technology



Test Report No.: 15247 / 56181

Date: 15.11.2023

BASF SE
Brandschutztechnik
E-CPB/EG - A521
D-67056 Ludwigshafen

Test according to

ISO 5659 Part 2 : 2017-05

Plastics - Smoke generation - Part 2: Determination of optical density by a single-chamber test

Client:
BASF 3D Printing Solutions GmbH
Speyerer Straße 4
69115 Heidelberg

The results refer exclusively to the tested samples.

As an accredited Test Laboratory, the BASF SE Fire Safety Technology Test Centre is authorized to conduct fire tests in accordance with DIN EN ISO/IEC 17025 : 2018.
DAkkS-Register-No.: D-PL-14121-07-00



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Test report according to DIN EN ISO/IEC 17025 : 2018

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BASF – Fire Safety Technology

Test according to ISO 5659 Part 2 : 2017-05
Plastics - Smoke generation - Part 2: Determination of optical density by a single-chamber test

Test Report No.: 15247 / 56181

Receipt of order: 06.10.2023
Receipt of samples: 17.10.2023
Date of test: 15.11.2023

1. Material: (information supplied by client)

Ultracur 3D RG 9400 B FR
Order number: ATLaS-2023-5657

Colour:

End use application:

2. Summary of results and classification:

Mean value of specific optical density at 4 min	D _s (4)	538
Cumulative value of spec. optical dens. in the first 4 min.	VOF4	836
Mean value of maximum specific optical density	D _s (max)	574
Classification according to DIN EN 45545-2:2016-02, set of requirements R22, with respect to test method ISO 5659-2, at 25 kW/m², with pilot flame		HL1
Classification according to DIN EN 45545-2:2016-02, set of requirements R23, with respect to test method ISO 5659-2, at 25 kW/m², with pilot flame		HL2

Remarks: For a final classification, additional tests are required.

Any conclusions we draw about the fire safety of the materials we test are based exclusively on the results of the test under the conditions described. The extent to which such conclusions can be applied to non-tested material under non-standard conditions is the sole responsibility of the customer and is done so at his own risk. - Decision rule acc. to DIN EN ISO/IEC 17025: Wherever statements of conformity are made, no measurement uncertainty is taken into account.

BASF Fire Safety Technology

Ludwigshafen, 15.11.2023

Dr. Houssin
Head of Laboratory

Hammann
Technician

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Test report according to DIN EN ISO/IEC 17025 : 2018

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BASF – Fire Safety Technology

Test according to ISO 5659 Part 2 : 2017-05
Plastics - Smoke generation - Part 2: Determination of optical density by a single-chamber test

Test Report No.: 15247 / 56181

3. Material:

Information supplied by client

Ultracur 3D RG 9400 B FR

Sample design:

RG9400 B FR Printed on MiiCraft 385.2 Preheated 5h at 40 °C before printing 100um 4mW 2,5s 3min
Cleaner+3min IPA 30 min at 40°C 900sDpS (2mm) / XZY

Order number: ATLaS-2023-5657

Additional details from testing laboratory

The tested specimen behaved like an intumescent material. The thickness of the charred residue was >10 mm. Therefore, the distance between the lower rim of the radiator cone shade junction was adjusted to 50 mm above the upper surface of the specimen holder. Calibration of the cone heater was done by a heat flux meter placed in position of the specimen with a distance of 50 mm and adjusting the temperature to resulting heat flux of 25 kW/m² to the surface of the specimen.

4. Samples:

Sample size (determined by BASF test laboratory):

Length:	74,92 [mm]	Weight:	14,35 [g]
Width:	74,65 [mm]	Weight per unit area:	2,56 [kg/m²]
Thickness:	2,00 [mm]	Density:	1282,90 [kg/m³]

Pre-conditioning:

	Conditions	Duration days
Client: (information supplied by client)	Standard 23/50 ISO 554	
Test Laboratory:	Standard 23/50 ISO 554	29

Sample preparation: Specimen tested as received (no sampling by test laboratory).

Exposed surface : Identical surfaces

5. Test equipment:

Test apparatus	PE 0020
Sliding gauge	MB 0038
Balance	MW 0009

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Test report according to DIN EN ISO/IEC 17025: 2018

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BASF – Fire Safety Technology

Test according to ISO 5659 Part 2 : 2017-05
Plastics - Smoke generation - Part 2: Determination of optical density by a single-chamber test

Test Report No.: 15247 / 56181

6. Test results:

Test mode		1		
Irradiance	[kW/m²]	25 kW		
Distance between sample and cone heater	[mm]	50 mm		
Flame mode		Flaming		
Test duration	[min]	10		
Sample		1	2	3
Wire grid used	yes/no	no	no	no
Thickness	[mm]	2,0	2,0	2,0
C _f		8,75	8,75	8,75
Clear beam correction factor	Dc	45,85	34,79	41,36
Specific optical density at 4 min	Ds4	594	498	522
Mean value of specific optical density at 4 min	Ds4	537,8		
Specific optical density at 10 min	Ds10	367	308	331
Mean value of specific optical density at 10 min	Ds10	335,2		
Specific optical density (maximum)	Ds _(max)	646	498	579
Mean value of specific optical density (maximum)	Ds _(max)	574,4		
Obscuration value in 4 min	VOF4	946	632	930
Mean obscuration value in 4 min	VOF4	836		
Ignition	[s]	90	105	83
Extinguishment	[s]	225	266	235
Thickness of the charred residue:	[mm]	20	21	15

Observations:

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Test report according to DIN EN ISO/IEC 17025: 2018

BASF – Fire Safety Technology

Test according to ISO 5659 Part 2 : 2017-05
Plastics - Smoke generation - Part 2: Determination of optical density by a single-chamber test

Test Report No.: 15247 / 56181

7. Requirements:

**DIN EN 45545-2:2016-02 (equivalent to EN 45545-2:2013 + A1:2015) and
DIN EN 45545-2:2020-10**

Set of requiremt.	Reference	kW/m ²	Parameter	HL1	HL2	HL3
R1, R2, R6, R11, R12	T10.01	50 w/o fl.	D _s (4)	600	300	150
	T10.02		VOF4	1200	600	300
	T11.01		CIT _G ·	1,2	0,9	0,75
R3	T10.01	50 w/o fl.	D _s (4)	---	480	240
	T10.02		VOF4	---	960	480
	T11.01		CIT _G ·	1,2	0,9	0,75
R5	T10.03	25 w. fl.	D _s (max)	300	250	200
	T11.02		CIT _G ·	1,2	0,9	0,75
R7	T10.04	50 w/o fl.	D _s (max)	---	600	300
	T11.01		CIT _G ·	---	1,8	1,5
R8, R9	T10.03	25 w. fl.	D _s (max)	---	600	300
	T11.02		CIT _G ·	---	1,8	1,5
R10	T10.03	25 w. fl.	D _s (max)	600	300	150
	T11.02		CIT _G ·	1,2	0,9	0,75
R17	T10.04	50 w/o fl.	D _s (max)	---	600	300
	T11.01		CIT _G ·	---	1,8	1,5
R20	T10.03	25 w. fl.	D _s (max)	200	200	200
	T11.02		CIT _G ·	0,75	0,75	0,75
R21	T10.03	25 w. fl.	D _s (max)	300	300	200
	T11.02		CIT _G ·	1,2	0,9	0,75
R22	T10.03	25 w. fl. 600°C	D _s (max)	600	300	150
	T12 **		CIT _{T(NLP)}	1,2	0,9	0,75
R23	T10.03	25 w. fl. 600°C	D _s (max)	---	600	300
	T12 **		CIT _{T(NLP)}	---	1,8	1,5

* after 4 or 8 minutes, whichever is higher
** NF X 70-100-1 &-2

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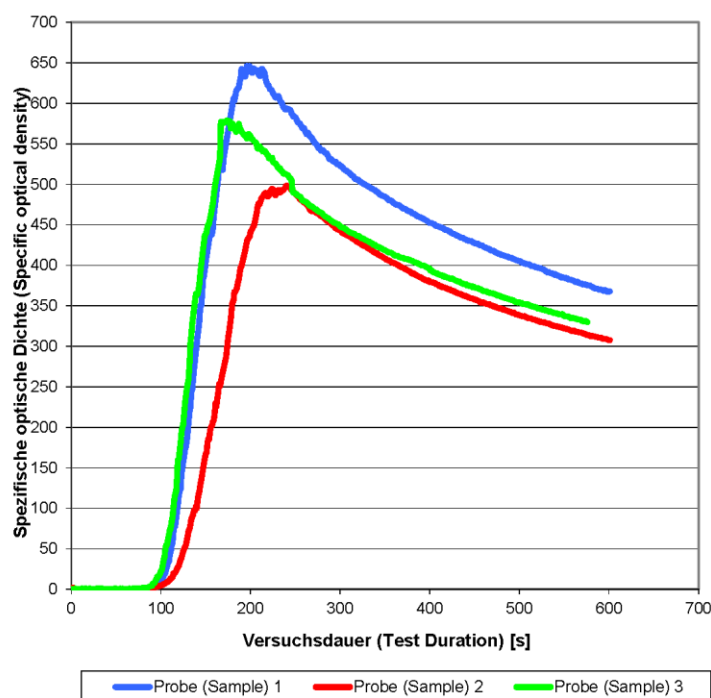
BASF – Fire Safety Technology

Test according to ISO 5659 Part 2 : 2017-05
Plastics - Smoke generation - Part 2: Determination of optical density by a single-chamber test

Test Report No.: 15247 / 56181

8. Charts:

Spezifische optische Dichte (Specific optical density)



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Test according to ISO 5659 Part 2 : 2017-05
Plastics - Smoke generation - Part 2: Determination of optical density by a single-chamber test

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9. Pictures:

Tested samples



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BASF – Fire Safety Technology



Test Report No.: 15247 / 56180

Date: 15.11.2023

BASF SE
Brandschutztechnik
E-CPB/EG - A521
D-67056 Ludwigshafen

Test according to

ISO 5659 Part 2 : 2017-05

Plastics - Smoke generation - Part 2: Determination of optical density by a single-chamber test

Client:

BASF 3D Printing Solutions GmbH

Speyerer Straße 4

69115 Heidelberg

The results refer exclusively to the tested samples.

As an accredited Test Laboratory, the BASF SE Fire Safety Technology Test Centre is authorized to conduct fire tests in accordance with DIN EN ISO/IEC 17025 : 2018.
DAkkS-Register-No.: D-PL-14121-07-00



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Test report according to DIN EN ISO/IEC 17025 : 2018

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BASF – Fire Safety Technology

Test according to ISO 5659 Part 2 : 2017-05
Plastics - Smoke generation - Part 2: Determination of optical density by a single-chamber test

Test Report No.: 15247 / 56180

Receipt of order: 06.10.2023
Receipt of samples: 17.10.2023
Date of test: 15.11.2023

1. Material: (information supplied by client)

Ultracur 3D RG 9400 B FR
Order number: ATLaS-2023-5656

Colour:

End use application:

2. Summary of results and classification:

Mean value of specific optical density at 4 min	D _s (4)	566
Cumulative value of spec. optical dens. in the first 4 min.	VOF4	577
Mean value of maximum specific optical density	D _s (max)	588
Classification according to DIN EN 45545-2:2020-10, set of requirements R22, with respect to test method ISO 5659-2, at 25 kW/m², with pilot flame		HL1
Classification according to DIN EN 45545-2:2020-10, set of requirements R23, with respect to test method ISO 5659-2, at 25 kW/m², with pilot flame		HL2

Remarks: For a final classification, additional tests are required.

Any conclusions we draw about the fire safety of the materials we test are based exclusively on the results of the test under the conditions described. The extent to which such conclusions can be applied to non-tested material under non-standard conditions is the sole responsibility of the customer and is done so at his own risk. - Decision rule acc. to DIN EN ISO/IEC 17025: Wherever statements of conformity are made, no measurement uncertainty is taken into account.

BASF Fire Safety Technology

Ludwigshafen, 15.11.2023

Dr. Houssin
Head of Laboratory

Hammann
Technician

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Test report according to DIN EN ISO/IEC 17025 : 2018

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BASF – Fire Safety Technology

Test according to ISO 5659 Part 2 : 2017-05
Plastics - Smoke generation - Part 2: Determination of optical density by a single-chamber test

Test Report No.: 15247 / 56180

3. Material:

Information supplied by client

Ultracur 3D RG 9400 B FR

Sample design:

RG9400 B FR Printed on MiiCraft 385.2 Preheated 5h at 40 °C before printing 100um 4mW 2,5s 3min

Cleaner+3min IPA 30 min at 40°C 900sDpS (2,5mm) / XZY

Order number: ATLaS-2023-5656

Additional details from testing laboratory

The tested specimen behaved like an intumescent material. The thickness of the charred residue was >10 mm. Therefore, the distance between the lower rim of the radiator cone shade junction was adjusted to 50 mm above the upper surface of the specimen holder. Calibration of the cone heater was done by a heat flux meter placed in position of the specimen with a distance of 50 mm and adjusting the temperature to resulting heat flux of 25 kW/m² to the surface of the specimen.

4. Samples:

Sample size (determined by BASF test laboratory):

Length:	74,95 [mm]	Weight:	18,09 [g]
Width:	74,64 [mm]	Weight per unit area:	3,23 [kg/m²]
Thickness:	2,51 [mm]	Density:	1288,31 [kg/m³]

Pre-conditioning:

	Conditions	Duration days
Client: (information supplied by client)	Standard 23/50 ISO 554	
Test Laboratory:	Standard 23/50 ISO 554	29

Sample preparation: Specimen tested as received (no sampling by test laboratory).

Exposed surface : Identical surfaces

5. Test equipment:

Test apparatus	PE 0020
Sliding gauge	MB 0038
Balance	MW 0009

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Test report according to DIN EN ISO/IEC 17025: 2018

BASF – Fire Safety Technology

Test according to ISO 5659 Part 2 : 2017-05
Plastics - Smoke generation - Part 2: Determination of optical density by a single-chamber test

Test Report No.: 15247 / 56180

6. Test results:

Test mode		1		
Irradiance	[kW/m²]	25		
Distance between sample and cone heater	[mm]	50 mm		
Flame mode		Flaming		
Test duration	[min]	10		
Sample		1	2	3
Wire grid used	yes/no	no	no	no
Thickness	[mm]	2,5	2,5	2,5
C _r		8,75	8,75	8,75
Clear beam correction factor	Dc	46,92	39,97	35,55
Specific optical density at 4 min	Ds4	590	578	528
Mean value of specific optical density at 4 min	Ds4	565,7		
Specific optical density at 10 min	Ds10	374	375	345
Mean value of specific optical density at 10 min	Ds10	365,0		
Specific optical density (maximum)	Ds(max)	604	602	556
Mean value of specific optical density (maximum)	Ds(max)	587,5		
Obscuration value in 4 min	VOF4	667	582	482
Mean obscuration value in 4 min	VOF4	577		
Ignition	[s]	94	104	112
Extinguishment	[s]	299	314	346
Thickness of the charred residue:	[mm]	31	21	18

Observations:

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Test report according to DIN EN ISO/IEC 17025 : 2018

BASF – Fire Safety Technology

Test according to ISO 5659 Part 2 : 2017-05
Plastics - Smoke generation - Part 2: Determination of optical density by a single-chamber test

Test Report No.: 15247 / 56180

7. Requirements:

**DIN EN 45545-2:2016-02 (equivalent to EN 45545-2:2013 + A1:2015) and
DIN EN 45545-2:2020-10**

Set of requiremt.	Reference	kW/m ²	Parameter	HL1	HL2	HL3
R1, R2, R6, R11, R12	T10.01	50 w/o fl.	D _s (4)	600	300	150
	T10.02		VOF4	1200	600	300
	T11.01		CIT _G ·	1,2	0,9	0,75
R3	T10.01	50 w/o fl.	D _s (4)	---	480	240
	T10.02		VOF4	---	960	480
	T11.01		CIT _G ·	1,2	0,9	0,75
R5	T10.03	25 w. fl.	D _s (max)	300	250	200
	T11.02		CIT _G ·	1,2	0,9	0,75
R7	T10.04	50 w/o fl.	D _s (max)	---	600	300
	T11.01		CIT _G ·	---	1,8	1,5
R8, R9	T10.03	25 w. fl.	D _s (max)	---	600	300
	T11.02		CIT _G ·	---	1,8	1,5
R10	T10.03	25 w. fl.	D _s (max)	600	300	150
	T11.02		CIT _G ·	1,2	0,9	0,75
R17	T10.04	50 w/o fl.	D _s (max)	---	600	300
	T11.01		CIT _G ·	---	1,8	1,5
R20	T10.03	25 w. fl.	D _s (max)	200	200	200
	T11.02		CIT _G ·	0,75	0,75	0,75
R21	T10.03	25 w. fl.	D _s (max)	300	300	200
	T11.02		CIT _G ·	1,2	0,9	0,75
R22	T10.03	25 w. fl. 600°C	D _s (max)	600	300	150
	T12 **		CIT _{T(NLP)}	1,2	0,9	0,75
R23	T10.03	25 w. fl. 600°C	D _s (max)	---	600	300
	T12 **		CIT _{T(NLP)}	---	1,8	1,5

* after 4 or 8 minutes, whichever is higher
** NF X 70-100-1 &-2

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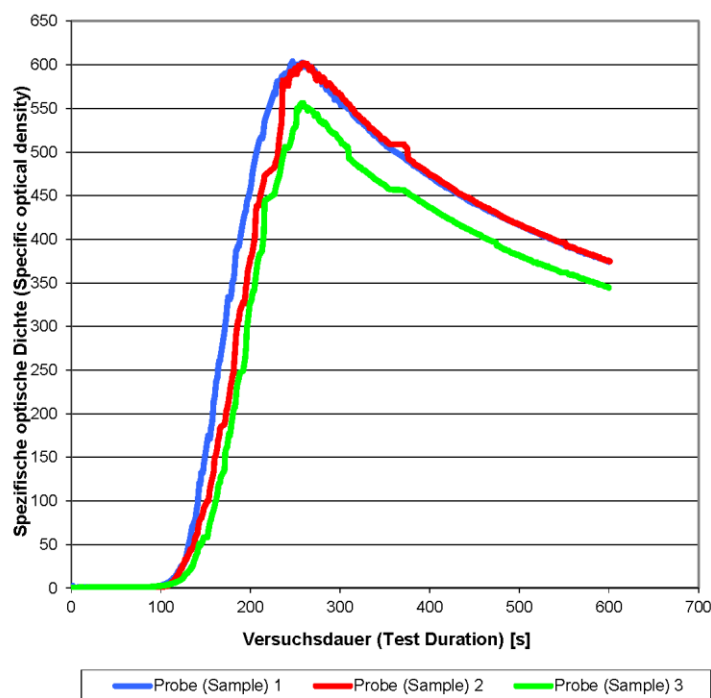
BASF – Fire Safety Technology

Test according to ISO 5659 Part 2 : 2017-05
Plastics - Smoke generation - Part 2: Determination of optical density by a single-chamber test

Test Report No.: 15247 / 56180

8. Charts:

Spezifische optische Dichte (Specific optical density)



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Test according to ISO 5659 Part 2 : 2017-05
Plastics - Smoke generation - Part 2: Determination of optical density by a single-chamber test

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9. Pictures:

Tested samples



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Limiting Oxygen Index Data

BASF – Fire Safety Technology



Test Report No.: 15311 / 56484

Date: 02.02.2024

BASF SE
Brandschutztechnik
E-CPB/EG - A521
D-67056 Ludwigshafen

Test according to

DIN EN ISO 4589 Part 2 Short procedure : 2017-11

Plastics - Determination of burning behaviour by oxygen index, Part 2: Ambient-temperature test
Chapter 10 Comparison with a specified minimum value of the oxygen index (short procedure)

Client:
BASF 3D Printing Solutions GmbH
Speyerer Straße 4
69115 Heidelberg

The results refer exclusively to the tested samples.

As an accredited Test Laboratory, the BASF SE Fire Safety Technology Test Centre is authorized to conduct fire tests in accordance with DIN EN ISO/IEC 17025 : 2018.
DAkkS-Register-No.: D-PL-14121-07-00



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Test report according to DIN EN ISO/IEC 17025 : 2018

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BASF – Fire Safety Technology

Test according to DIN EN ISO 4589 Part 2 Short procedure : 2017-11
Plastics - Determination of burning behaviour by oxygen index, Part 2: Ambient-temperature test
Chapter 10 Comparison with a specified minimum value of the oxygen index (short procedure)

Test report No.: 15311 / 56484

Receipt of order: 23.01.2024

Receipt of samples: 31.01.2024

Date of test: 02.02.2024

1. Material: (information supplied by client)

Ultracur 3D RG 9400 B FR

Colour:

End use application:

2. Summary of results and classification:

Limiting Oxygen Index (LOI)	[% O ₂]	≥ 28.0
Classification according to DIN EN 45545-2:2020-10, R22, R23, R24, with respect to test acc. to EN ISO 4589-2	HL 1+2	

Remarks:

For a final classification, additional tests are required.

Any conclusions we draw about the fire safety of the materials we test are based exclusively on the results of the test under the conditions described.
The extent to which such conclusions can be applied to non-tested material under non-standard conditions is the sole responsibility of the customer and is done so at his own risk.
Decision rule acc. to DIN EN ISO/IEC 17025:2018: Wherever statements of conformity are made, no measurement uncertainty is taken into account.

BASF Fire Safety Technology

Ludwigshafen, 02.02.2024

Dr. Houssin
Head of Laboratory


Hammann
Technician

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Test report according to DIN EN ISO/IEC 17025 : 2018

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BASF – Fire Safety Technology

Test according to DIN EN ISO 4589 Part 2 Short procedure : 2017-11
Plastics - Determination of burning behaviour by oxygen index, Part 2: Ambient-temperature test
Chapter 10 Comparison with a specified minimum value of the oxygen index (short procedure)

Test report No.: 15311 / 56484

3. Material:

Information supplied by client

Ultracur 3D RG 9400 B FR
Order number: ATLaS-2024-5927
Composition: RG9400 B FR Printed on MiiCraft 385.2 Preheated 5h at 40 °C before printing 100um 4mW
2,5s 3min Cleaner+3min IPA 30 min at 40°C 900sDpS (2,5mm)

Additional details from test laboratory

Colour: Black

4. Samples:

Sample size (determined by BASF test laboratory):

Length:	79,64 [mm]	Weight (upon receipt)	4,17 [g]
Width:	10,05 [mm]	Weight (after precond.):	4,19 [g]
Thickness:	4,04 [mm]	Weight loss:	[%]
Outer diameter:	[mm]	Weight per unit area:	5,23 [kg/m²]
Inner diameter:	[mm]	Density:	1295,79 [kg/m³]
Remarks:			

Pre-conditioning:

	Conditions	Duration days
Client: (information supplied by client)	Standard 23/50 ISO 554	-----
Test laboratory:	Standard 23/50 ISO 554	2

Sample preparation: Specimen tested as received (no sampling by test laboratory).

Exposed surface: Identical surfaces

Test gas temperature: 25°C
(start of test)

Remarks:

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BASF – Fire Safety Technology

Test according to DIN EN ISO 4589 Part 2 Short procedure : 2017-11
Plastics - Determination of burning behaviour by oxygen index, Part 2: Ambient-temperature test
Chapter 10 Comparison with a specified minimum value of the oxygen index (short procedure)

Test report No.: 15311 / 56484

5. Test results:

Sample type: I - For moulding materials
Procedure (Ignition method) A - Top surface ignition

Oxygen [Vol. %]	32,0	32,0	28,0	28,0	28,0	
Duration of burning [s]	>180	>180	45	31	27	
Burning distance [mm]	37	35	3	3	2	
Event (X or O)	X	X	O	O	O	

Observations:

6. Test equipment:

Test apparatus	PK 0023
Caliper gauge	MB 0038
Balance	MW 0009
Stop watch	MU 0059

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BASF – Fire Safety Technology

Test according to DIN EN ISO 4589 Part 2 Short procedure : 2017-11
Plastics - Determination of burning behaviour by oxygen index, Part 2: Ambient-temperature test
Chapter 10 Comparison with a specified minimum value of the oxygen index (short procedure)

Test report No.: 15311 / 56484

7. Requirements:

Standard ISO 4589 Part 2 does not define any requirements.

Requirements by other standards:

Standard	Criteria	Requirements
DIN EN 45545-2: 2016-02 and 2020-10	Set of requirements R22, R23, R24	HL 1 and 2 LOI ≥ 28%
		HL 3 LOI ≥ 32%
DIN 5510 – 2:2009-05, section 5.2.2.4	Small electrical parts with a combustible material mass of 50 or 300 g (accessible / not accessible by passengers), which are arranged with a spacing of ≤ 20 cm behind, next to or above one another	LOI ≥ 28%
	Materials used in electrical equipment that is not accessible to passengers	LOI ≥ 30%
NF F 16-101, section 6.1.3	„I“ classification (in conjunction with test acc. to IEC 60695-2-10)	I 0 LOI ≥ 70%
		I 1 LOI ≥ 45%
		I 2 LOI ≥ 32%
		I 3 LOI ≥ 28%
		I 4 LOI ≥ 20%
BS 6853	Tables 7 + 8	Vehicle category Ia and Ib LOI ≥ 34 %
		Vehicle category II LOI ≥ 28 %
TSI Freight waggon (2006)*	Section 4.2.7.2.2.4. Material requirement	LOI ≥ 26 %

*from edition 2013-04, no more requirements regarding LOI

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Test report according to DIN EN ISO/IEC 17025 : 2018

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Smoke Gas Toxicity Data

BASF – Fire Safety Technology



Test Report No.: 15311 / 56485

Date: 23.02.2024

BASF SE
Brandschutztechnik
E-CPB/EG - A521
D-67056 Ludwigshafen

Test according to

NF X 70-100 Partie 1+2 : 2006-04

Fire tests - Analysis of gaseous effluents - Part 1 : methods for analysing gases stemming from thermal degradation Calculation of CIT-NLP according to DIN EN 45545:2016

Client:

BASF 3D Printing Solutions GmbH

Speyerer Straße 4

69115 Heidelberg

The results refer exclusively to the tested samples.

As an accredited Test Laboratory, the BASF SE Fire Safety Technology Test Centre is authorized to conduct fire tests in accordance with DIN EN ISO/IEC 17025 : 2018.
DAkks-Register-No.: D-PL-14121-07-00



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Test report according to DIN EN ISO/IEC 17025 : 2018

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BASF – Fire Safety Technology

Test according to NF X 70-100 Partie 1+2 : 2006-04
Fire tests - Analysis of gaseous effluents - Part 1 : methods for analysing gases stemming from thermal degradation
Calculation of CIT-NLP according to DIN EN 45545:2016

Test report No.: 15311 / 56485

Receipt of order: 23.01.2024

Receipt of samples: 31.01.2024

Date of test: 08.02.2024

1. Material: (information supplied by client)

Ultracur 3D RG 9400 B FR

Colour:

End use application:

2. Summary of results and classification:

Conventional Index of Toxicity	CIT _{NLP}	0,43
Classification with respect to Smoke Gas Toxicity determination for "Non Listed Products" according to DIN EN 45545-2:2016-02, set of requirements	R22 / R23	HL3

Remarks:

For a final classification, additional tests are required.

Any conclusions we draw about the fire safety of the materials we test are based exclusively on the results of the test under the conditions described. The extent to which such conclusions can be applied to non-tested material under non-standard conditions is the sole responsibility of the customer and is done so at his own risk. - Decision rule acc. to DIN EN ISO/IEC 17025: Wherever statements of conformity are made, no measurement uncertainty is taken into account.

BASF Fire Safety Technology

Ludwigshafen, 23.02.2024

Dr. Houssin
Head of Laboratory

Hammann
Technician

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BASF – Fire Safety Technology

Test according to NF X 70-100 Partie 1+2 : 2006-04
Fire tests - Analysis of gaseous effluents - Part 1 : methods for analysing gases stemming from thermal degradation
Calculation of CIT-NLP according to DIN EN 45545:2016

Test report No.: 15311 / 56485

3. Material:

Information supplied by client

Ultracur 3D RG 9400 B FR
Order number: ATLaS-2024-5927
Composition: RG9400 B FR Printed on MiiCraft 385.2 Preheated 5h at 40 °C before printing 100um 4mW 2,5s 3min Cleaner+3min IPA 30 min at 40°C 900sDpS (2,5mm)

Additional description by laboratory

4. Samples:

Dimensions (determined by BASF test laboratory):

Length:	75,15 [mm]	Weight:	22,34 [g]
Width:	74,67 [mm]	Weight per unit area:	3,98 [kg/m²]
Thickness:	3,06 [mm]	Density:	1301,02 [kg/m³]
Outer diameter:	[mm]	Remarks:	
Inner diameter:	[mm]		

Pre-conditioning:

	Conditions	Duration
		days
Client: (information supplied by client)	Standard 23/50 ISO 554	---
Laboratory:	Standard 23/50 ISO 554	8

Sample preparation: Specimen cut out from moulded parts.

Remarks:

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BASF – Fire Safety Technology

Test according to NF X 70-100 Partie 1+2 : 2006-04
Fire tests - Analysis of gaseous effluents - Part 1 : methods for analysing gases stemming from thermal degradation
Calculation of CIT-NLP according to DIN EN 45545:2016

Test report No.: 15311 / 56485

5. Test results:

Test of smoke gas toxicity at a temperature of 600 °C

$$CIT_{NLP} = \frac{450 \text{ g}}{150 \text{ m}^3 \times N} \times \sum_{i=1}^{i=8} \frac{c_i \text{ mg g}^{-1}}{C_i \text{ mg m}^{-3}} \quad \text{With } N^* = 3: \quad CIT_{NLP} = \sum_{i=1}^{i=8} \frac{c_i}{C_i} \quad (*\text{correction factor})$$

Sample No.	Concentration, c_i [mg/g]				Reference value, C_i [mg/m ³]	c_i / C_i
	1	2	3	Avg.		
Init. weight [g]	1,00	1,00	1,00	1,00		
CO ₂	989	1032	987	1003	72000	0,01
CO	192	194	189	192	1380	0,14
HF ^{*)}	0,26	0,26	0,26	0,26	25	0,01
HCl ^{*)}	0,26	0,26	0,26	0,26	75	0,00
HBr ^{*)}	0,25	0,25	0,25	0,25	99	0,00
HCN ^{*)}	13,24	13,50	13,50	13,42	55	0,24
NO _x ^{*)}	0,44	0,44	0,44	0,44	38	0,01
SO ₂ ^{*)}	0,37	0,37	0,37	0,37	262	0,00
^{*)} Wet analysis carried out by BASF Central Analytics, DAkKS accreditation No. D-PL-14121-02-00. nd = not detected					CIT_{NLP}: 0,43	

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BASF – Fire Safety Technology

Test according to NF X 70-100 Partie 1+2 : 2006-04
Fire tests - Analysis of gaseous effluents - Part 1 : methods for analysing gases stemming from thermal degradation
Calculation of CIT-NLP according to DIN EN 45545:2016

Test report No.: 15311 / 56485

Observations:

6. Test equipment:

Test apparatus	PV 0006
Data acquisition	MC 0005
Analyzer	MA 0009
Balance	MW 0009

7. Requirements:

DIN EN 45545-2:2016-02 (equivalent to EN 45545-2:2013 + A1:2015)

Method	Standard	Parameter	HL1	HL2	HL3
Set of requirements: R22					
T12	NF X 70-100-1 & 2	CIT _{NLP} (Max.)	1,2	0,9	0,75
Set of requirements: R23					
T12	NF X 70-100-1 & 2	CIT _{NLP} (Max.)	---	1,8	1,5

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