

Indications for Use: The KeyPrint[®] KeySplint Soft[™] Clear for Carbon[®] Printers is indicated for the fabrication of orthodontic and dental appliances such as bite planes, mouthguards, nightguards, snoring appliances, splints and repositioners.

Product Description: KeyPrint[®] KeySplint Soft[™] Clear for Carbon[®] Printers is a light-curing resin for the 3D printing of flexible biocompatible dental devices for use with Carbon[®] M-series printers.

CHARACTERISTICS	
Color	Clear/transparent
Density	1.0-1.1 g/cm ³
Viscosity	600-800 cP

	TESTED PROPERTY	STANDARD/METHOD	PASSING CRITERIA	RESULT
ASTM	Flexural Strength	ASTM D790	> 30 MPa**	38-44 MPa
	Flexural Modulus	ASTM D790	750-1,500 MPa**	1,000-1,200 MPa
	Elongation at Break	ASTM D638	> 40%**	> 110%
	Hardness	ASTM D2240	> 75 MPa**	80-85 Shore D
	IZOD Impact (Notched)	ASTM D256	> 35 J/m**	45-48 J/m
ISO	Ultimate Flexural Strength	ISO 20795-2	> 2.0 MPa**	2.6-4.5 MPa
	Flexural Modulus	ISO 20795-2	> 100 MPa**	100-200 MPa
	Solubility	ISO 20795-2	< 32 ug/mm ³	PASS
	Sorption	ISO 20795-2	< 1.6 ug/mm ³	PASS
	Free Monomer Extraction	ISO 20795-2	< 2.2%	PASS
BIOCOMPATIBILITY	Cytotoxicity	ISO 10993		PASS
	Irritation	ISO 10993		PASS
	Sensitization	ISO 10993		PASS

**Denotes Keystone determined passing criteria based on design requirements

These data are typical values and were determined through testing on Carbon printers which are validated for use with select Keyprint products. Mechanical properties will vary based on machine, part orientation, machine type, machine power, post curing of the printed parts, and cleaning. See product guide for post-processing procedure and best practices. Improper use or failure to adhere to the product guide may result in variations of color and mechanical properties. This product is suitable for the manufacturing of flexible dental appliances such as splints, mouthguards and nightguards. Keystone Industries reserves the right to change material characteristics, and formulation without prior notification.

Composition: methacrylate, photo-initiator, inhibitor, and pigments

Validated Post Cure Units: NK Optik Otofash G171, Dreve PCU-LED, Dreve PCU-90.

These data were determined in accordance with ISO and ASTM standards and are pursuant to Keystone Industries quality system. This document is valid without signature.