



CE 221 is a high performance material with excellent strength, stiffness, and temperature resistance (231°C).

MATERIAL PROPERTIES Ref TDS for more info.

Tensile Modulus	3870 +/- 140 Mpa
Ultimate Tensile Strength	92 +/- 13 Mpa
Elongation at Break	3.3 +/- 0.8 %
Flexural Strength	131 +/- 27 Mpa
Impact Strength	15 +/- 1 J/m
Heat Deflection Temp	231°C
Shore Hardness	92, Shore D
Density	1.210 g/cm ³

STORAGE


Temperature	17 - 25°C (64 - 77 °F)
Packaging	375 ml cartridge

Notes

- Can be used immediately from storage.

RESIN DISPENSING & PRINTING

Supplemental information available.

Ratio	1:1	Burn off	10 ml new cartridge	Notes * CE 221 is also compatible with the retired green 1:1 mixing tip at speed 1 on Albion. With the white tip, use speed 2 on Albion or speed 1 on Cox.
Speed	1 or 2*	MMD	No	
Mixing tip	White*	Pot life	8 hours	
		Release film	Not recommended	

WASHING

Supplemental information available.

Solvent	50-50 Blend: <ul style="list-style-type: none"> • 99% Isopropanol • Propylene Glycol 	Manual Process	<ul style="list-style-type: none"> • Remove excess resin with compressed air (recommended), swabs (or wipes). • 1 min orbital shaker at 120 RPM. • Touch up with compressed air (recommended), swabs (or wipes). • 1-2 min spot clean with swabs (or wipes) or compressed air, as needed. • Finish with swabs (or wipes) to remove residual propylene glycol (oily).
Exposure	3 min max		
Part Washer	No		
Notes			
<ul style="list-style-type: none"> • Spinner not recommended. 			

CURING

Cure start	w/in 15 hrs of printing	UV	N/A	Compatible baking implements <ul style="list-style-type: none"> • Ceramic baking tray (clean) • Non-stick aluminum foil • Silicone sheets • Pan mesh
Salt bake	No	Thermal	<ul style="list-style-type: none"> • Program 1 - Pattern 1 • 12.5 hours ramped temperature 	