Version: 1.0
Last update 30-06-2025

Technical datasheet

Prusament Resin Impact65 Black



Impact65

Identification

Name	**Prusament Resin Impact65 Black**
Usage	**3D printing**
Manufacturer	**Prusa Polymers a.s., Prague, Czech Republic**

Basic material properties

Density of the liquid [g/cm3]	1.11
Density of the 3D printed model [g/cm3]	1.16
Color	Black
Odour	Low

Viscosity (25 °C) [mPa.s]	245	ISO 2431

Recommended printing settings for SL1S

Resin details		SL1S					
Type	Name	25 um [s]	First layers [s]	50 um [s]	First layers [s]	100 um [s]	First layers [s]
Impact65	Black	2.7	5	**3**	**6**	3.6	9

Recommended curing setting after print

Washing in isopropyl alcohol (>90%) [min]	10
Minimum curing time [min]	30
Optimal curing time [min]	60

Mechanical properties(1)

Property/print direction	**Cured XY (60 mins)**	**Method**
Tensile strength [MPa]	25 ± 3.0	ISO 527-1
Elongation [%]	30 ± 4.0	ISO 527-1
Tensile modulus [MPa]	617 ± 11.0	ISO 527-1
Impact strength Charpy [kJ/m2](2)	79 ± 13.0	ISO 179-1
Notched impact strength Charpy [kJ/m2](3)	9 ± 2.0	ISO 179-1
Izod impact strength [kJ/m2]	65	ISO 180
Notched Izod impact strength [kJ/m2]	9	ISO 180
Flexural strength [MPa]	NB*	ISO 178
Flexural modulus [GPa]	NB*	ISO 178
Hardness - Shore D	72	ISO 868

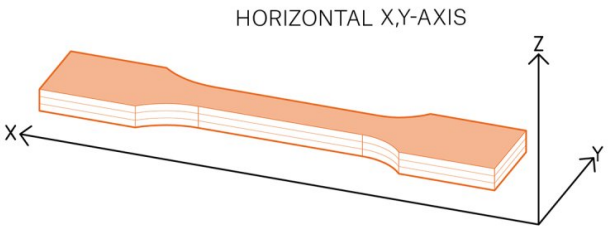
*NB (no break); The sample remained intact.

(1) The Original Prusa SL1S Speed 3D printer was used to make testing specimens. PrusaSlicer-2.8.0 was used to create G-codes with the following settings: Prusament Resin Impact65; layer 0,05mm; faded layers: 0; exposure times: 3s (SL1S), without supports and pad; other parameters were set to the default.

Dimensions of specimen: length: 75mm, width: 4mm, thickness: 1mm.

(2) Impact resistance Charpy - Edgewise direction of blow according to ISO 179-1.

(3) Notched impact resistance Charpy - Edgewise direction of blow according to ISO 179-1.



Basic safety information

- This resin is not meant for contact with food, drinks, or medical use on or in the human body. Always read the material safety data sheet thoroughly.
- Uncured resin is classified as a dangerous chemical and must be handled and disposed of properly in designated containers.

Manipulation instructions

- Shake the bottle with the resin or stir the resin thoroughly before use.
- Store at room temperature.
- Avoid direct sunlight to prevent premature polymerization and yellowness.
- Use protective equipment for manipulation.
- Do not pour the contents of the bottle into general waste. Dispose of empty bottles and unused resin at designated places.

Disclaimer

The results presented in this data sheet are just for your information and comparison. Values are significantly dependent on print settings, operator experiences, and surrounding conditions. Everyone has to consider the suitability and possible consequences of printed parts usage. Prusa Polymers corp. can not carry any responsibility for injuries or any loss caused by using Prusament Resin Impact65. Before the use of Prusamen Resin Impact65 material, read properly all the details in the available safety data sheet (SDS).