

# FDM Materials Chemical Compatibility



This document is provided as a guide to better understand the general performance you can expect when exposing Stratasys FDM® (fused deposition modeling) materials to various chemicals. Stratasys always recommends conducting your own testing on materials prior to using them for your particular application. These ratings are relative and are not based on any specific testing.

## Chemical Resistance Ratings

1 = Excellent chemical resistance: The solvent is unlikely to degrade the thermoplastic during prolonged exposure and moderate environmental conditions (room temperature and normal atmospheric pressure).

2 = Good chemical resistance: The solvent is unlikely to degrade the thermoplastic during short-term exposure and moderate environmental conditions (room temperature and normal atmospheric pressure).

3 = Limited chemical resistance: The solvent will likely degrade the thermoplastic during short-term exposure. 4 = Poor resistance: The solvent will likely attack and aggressively degrade the thermoplastic when exposed.

FDM Materials									
Chemical	ABS-M30™	ASA	PC-ABS	PC	ULTEM™ 9085 Resin	FDM Nylon 12™	PPSF	ULTEM 1010 Resin	Antero™ 800NA
Aliphatic hydrocarbons (e.g., methane, propane, butane)	2	2	3	3	2	1	1	2	1
Aromatic hydrocarbons (e.g., benzene)	3	3	3	3	2	1	2	1	2
Halogenated hydrocarbons (e.g., CFCs)	4	4	4	4	4	4	3	3	1
Ketones (e.g., MEK, acetone)	4	4	4	4	3	2	3	3	2
Alcohol/ethanol	2	2	2	2	2	4	2	2	1
Phenols	4	4	4	4	4	4	4	4	1
Esters	3	3	4	3	2	1	2	2	1
1 = Excellent chemical resistance      2 = Good chemical resistance      3 = Limited chemical resistance      4 = Poor resistance									

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Chemical	ABS-M30	ASA	PC-ABS	PC	ULTEM 9085 Resin	FDM Nylon 12	PPSF	ULTEM 1010 Resin	Antero 800NA
Transmission fluid	3	3	3	3	3	1	2	2	1
Windshield washer fluid	2	2	2	2	1	1	1	1	1
Brake fluid	3	3	3	3	3	1	2	2	1
Antifreeze/ engine coolant	2	2	2	3	2	1	1	1	1
Motor oil	3	3	3	3	2	1	2	2	1
Petroleum greases	2	2	2	3	2	1	1	2	1
Silicone greases/oils	4	4	4	4	2	2	2	2	1
Petroleum fuels	2	2	3	3	1	1	2	1	1
Weak acids (pH 3-6)	1	1	1	2	2	2	1	2	1
Strong acids (pH <3)	3	3	3	4	3	4	2	3	2
Weak bases (pH 8-10)	1	1	2	2	1	1	1	1	1
Strong bases (pH >10)	1	1	2	3	2	1	1	2	2
Deionized water	1	1	1	2	1	1	1	1	1

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## Stratasys Headquarters

7665 Commerce Way,  
Eden Prairie, MN 55344  
+1 800 801 6491 (US Toll Free)  
+1 952 937-3000 (Intl)  
+1 952 937-0070 (Fax)

stratasys.com  
ISO 9001:2008 Certified

1 Holtzman St., Science Park,  
PO Box 2496  
Rehovot 76124, Israel  
+972 74 745 4000  
+972 74 745 5000 (Fax)

