



## STORAGE

|             |                            |
|-------------|----------------------------|
| Temperature | 18 - 28° C<br>(64 - 82° F) |
| Packaging   | Bottle                     |

### Notes

- Ensure resin is at room temperature before using.

## RESIN DISPENSING & PRINTING

Supplemental information available.

|              |                              |
|--------------|------------------------------|
| Ratio        | 1 part                       |
| Speed        | N/A                          |
| Mixing tip   | N/A                          |
| Burn off     | N/A                          |
| MMD          | No                           |
| Pot life     | N/A   Reusable<br>(filtered) |
| Release film | Not required/<br>optional    |

### Dispensing Process

- Check the cassette.
- Pour required resin amount into cassette using preferred measuring technique.
- After printing, reuse, discard or filter and save resin for later use.
- Always check liquid resin for solids between prints.

### Notes

- Make sure resin is well shaken **1 hr** before use.
- Remove parts from platform shortly after printing to prevent deformation.

## WASHING

Supplemental information available.

|                     |                       |
|---------------------|-----------------------|
| Solvent             | 99% Isopropanol (IPA) |
| Exposure            | 10 min max.           |
| Part Washer         | No                    |
| Part Washer solvent | N/A                   |

### Notes

- Post treatments recommended immediately following a completed print.
- Washing should occur no later than **8 hrs** after print completion.

### Washing Process

#### Manual Washing

- Before removing parts from platform, remove supports from delicate features like clasps.
- Remove parts from platform.
- Remove remaining supports.
- Place parts in dedicated container of **fresh IPA**. Solvent should completely cover parts.
- Wash **5 min** on orbital shaker at **60 RPM** and remove parts from washtub.
- Empty container and fill with **fresh IPA**.
- Wash **additional 5 min** on orbital shaker at **60 RPM**.
- Remove parts from washtub and air dry for **30 min** or **use compressed air**.

## CURING

|                               |                                                                                                                        |
|-------------------------------|------------------------------------------------------------------------------------------------------------------------|
| Cure start                    | Recommended directly after parts have dried.                                                                           |
| Dreve PCU LED (with Nitrogen) | Cast program. (6 min at 80% intensity, under vacuum.)<br>Program Name: Castable<br>• Available in Configuration File 2 |
| Dreve PCU 90 (with Nitrogen)  | -                                                                                                                      |
| Otoflash G171 (with Nitrogen) | -                                                                                                                      |

### Curing Process

- Cure in UV post-cure unit (see left).
- Check part for tackiness with a clean glove after curing cycle is complete.
- Move part to contamination free zone.
- Part is ready for investment process.

### Notes

- Safe for handling after UV curing.