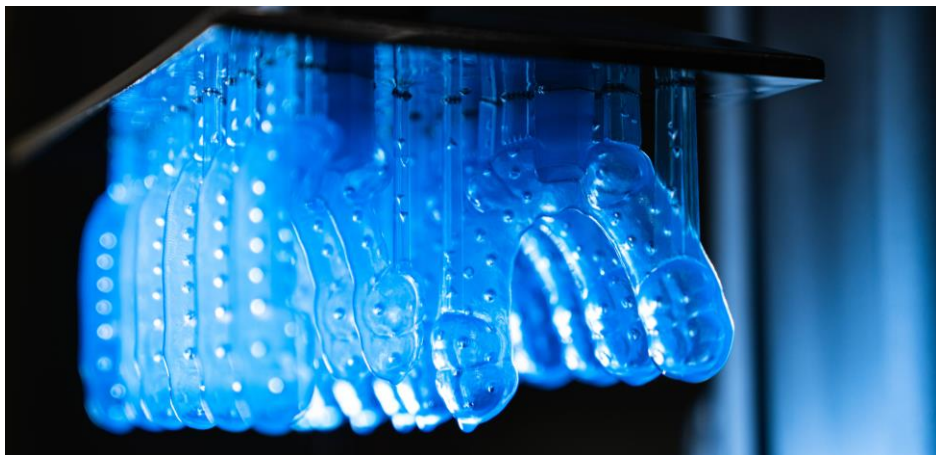




STORAGE

Temperature	20 - 25° C (68 - 77° 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 (filtered)
Release film	Not required/ optional

Dispensing Process

1. Before dispensing the resin from the bottle, use plastic spatula to stir the bottom of the bottle for 1 minute before dispensing or mix using an automated bottle roller for 10 minutes.
2. Check the cassette.
3. Pour required resin amount into cassette using preferred measuring technique.
4. After printing, reuse, discard or filter and save resin for later use.
5. Always check liquid resin for solids between prints.

Notes

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

WASHING

Supplemental information available.

Solvent	99% Isopropanol (IPA)
Exposure	Do not exceed 4 hours
Part Washer	No
Part Washer solvent	N/A

Notes

- Post treatments recommended immediately following a completed print.
- Wash parts in dedicated container (only for cleaning parts printed in Rodin Bite Tray).

Washing Process

1. Remove parts from platform. Remove supports.
2. Place parts in dedicated container of **fresh IPA**. Solvent should cover $\frac{3}{4}$ of tallest parts.
3. **5 min** orbital shaker at **140 RPM** and remove parts from washtub.
4. Place parts in second dedicated container of **fresh IPA** and wash **additional 5 min** on orbital shaker at **140 RPM**.
5. Transfer to paper towel lined tray.
6. Wipe entire intaglio surface of each part with IPA-dipped swab.
7. Air dry for **30 min or use compressed air**.
8. If glossy areas remain, repeat swabbing and drying.

CURING

Cure start	Recommended directly after parts have dried.
Dreve PCU LED	Use Pac Tray Program: 30 minutes, 80% intensity Nitrogen not required
Dreve PCU 90	Use control knob to select 10 min per side - Nitrogen not required

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.

Notes

- Safe for handling after UV curing.
- After curing, polish/finish as needed.