



STORAGE

Temperature	18 - 28°C (65 - 82 °F)
Packaging	910 mL bottle

Notes

- Can be used immediately from storage.
- Invert 5-6 times before use.

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

- Check the cassette.
- Pour required resin amount into cassette using preferred measuring technique.
- After printing, reuse, discard or save resin for later use.

Notes

- Make sure resin is well shaken before use.

WASHING

Supplemental information available.

Solvent	99% Isopropanol
Exposure	N/A
Part Washer	No
Part Washer Solvent	N/A

Notes

Washing Process

Part Washer

- N/A

Manual Washing

- Place parts into a Tupperware container and add IPA until parts are fully submerged.
- Wash parts for 3 minutes at 140 RPM on an orbital shaker table.
- Replace with fresh IPA and wash parts for an additional 2 minutes at 140 RPM on the orbital shaker table.
- Air dry for 30 min.

CURING

Cure Start	Recommended directly after printing
Thermal Salt bake	N/A
Dreve PCU LED (with Nitrogen)	8 min at 90% intensity, w/Nitrogen
Otoflash G171	2000 flashes/side under ambient air
Uvitron Intelliray 400W	150 seconds/side at 50% intensity on lowest rack under ambient air

Curing Process

- UV cure per UV oven specific doses (see left).
- Dreve PCU LED does not require flipping.
- Check part for tackiness with a clean glove.
- Move part to contamination free zone.

Notes

- No baking, safe for use after UV curing.
- Cross or splay bar removal is recommended after UV post-cure.