

Standard Resin

FEATURES	APPLICATIONS
<p>Standard Photopolymer Resin: Suitable for beginners and model/figurine printing. Features easy molding, high precision, low odor, high hardness, fast curing speed, excellent storage stability, and wide application range.</p> <p>Colors: Dark Gray, Light Gray, Black, Transparent, White, Skin Tone, etc.</p>	<p>Suitable for rigid model printing: engineering prototypes, ornaments, toys, accessories, figurines, etc.</p>

Properties	ASTM/ISO	Test Condition	S.I. Units	Typical Values
Mechanical				
Tensile Strength	ISO 527	50mm/min	MPa	45
Elongation at break	ISO 527	50mm/min	%	13.5
Flexural Strength	ISO 178	10mm/min	MPa	57
Flexural Modulus	ISO 178	10mm/min	MPa	1478
IZOD Impact Notched	ISO 179	4mm, 23°C	J/m	40
Thermal				
Heat Deflection (HDT)	ISO 75	0.45MPa	°C	55
Glass Transition(Tg)	ISO 11357-2	10°C/min	°C	52
Melting Point	ISO 11357-1	10°C/min	°C	201
@5%Decomposition Temp.	ASTM E2402	20°C/min	°C	345.25
Coefficient of Thermal Exp.	ASTM E831	/	μm (m.°C)	101×10 ⁻⁶
Others				
Lishao hardness	ISO868	23°C	D	86
Mold Shrinkage	ISO294	23°C	%	8.9
Basic physical properties of resin				
Item	Parameters/Methods			
Curing wavelength (nm)	365—405			
liquid density (g/cm ³)	1.1073±0.05			
Solid density (g/cm ³)	1.2156±0.03			
Resin viscosity (mPa.s/°C)	300-600			
Storage condition	15-35°C , <60%RH Light-shielded sealed storage			
validity period	2 years			
Cleaning method	Use 95% or higher purity ethanol or isopropanol for ultrasonic cleaning for 5-6 minutes. Brushing with a brush can enhance the cleaning effect further.			

Post-curing mode	After cleaning, use a secondary curing box to cure for 3-5 minutes.
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[1] Typical values are laboratory average data and are provided for reference only. They are not to be considered as product standards.

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Suggested print parameters and instructions

Item	Explain
Print optimum ambient temperature (°C)	25—30°C/ < 60%RH
Recommended print layer thickness (mm)	0.1mm
Bottom number	5-10
Bottom exposure time (S)	RGB LCD Screen 20-70s; Monochrome LCD Screen 10-50s
Layer exposure time (S)	RGB LCD Screen 4-15s; Monochrome LCD Screen 1.5-3.5s
Lifting height (mm)	6-10 mm (7-inch or larger machines: lifting height recommended >8. 10-inch or larger machines: lifting height recommended >10.)
Lifting speedt (mm/min)	60-120
Return/descent speed (mm/min)	120-180
Extinguishing delay time (S)	0.5-1

The above values are for printer reference only, and can be adjusted according to different models, different models and product requirements.

Safety and Handling Precaution

A Material Safety Data Sheet (SDS) for this product is available from your local Sunlu office. The SDS provides customers with information on material handling, safety and disposal, as well as the requirements of applicable local health and safety regulations. The following are general precautions and apply only to the resins supplied.

This product is not for oral consumption, keep out of reach of children, avoid eye contact, and in case of accidental contact, rinse with plenty of water immediately. If discomfort persists, seek medical attention promptly.

Follow proper operating procedures; ensure good ventilation in the printing area. Before using resin, shake well and wear gloves and a mask. It is recommended to store in a light-shielded place at a temperature of 15°C-35°C and humidity

resin viscosity. Optimal printing conditions are at 25°C-30°C, with humidity below 60%. Before printing, wait for the bubbles to disappear completely. In most cases, good general ventilation equipment is sufficient. Local exhaust ventilation should be used when necessary.

Seal and store to avoid environments with excessive dust or moisture, which may affect printing quality. Store in a light-shielded area to prevent direct sunlight exposure, as sunlight contains a large amount of ultraviolet rays that

Users are advised to investigate the final use of their product beforehand to ensure the correct use of Sunlu products. To prevent misuse or incorrect use of Sunlu products, it is advisable to contact the Sunlu R&D department or the marketing



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