Precision Model Resin

Technical Data Sheet

The molding precision is high, the resolution is high, the surface of the printed product is smooth, the printing details are clearly visible.

Material Status	Mass Production	
Characteristics	• Low settlement • High hardness • High precision	• High resolution • Smooth print surface
Applications	• Figure • Jewelry	• Education • Garnish
Appearance	• Multiple Colors	
Form	• Resins	
Processing method	• (surface exposure molding) LCD	

	Testing method	Typical value
Physical Properties		
Density	GB/T 4472	1.13-1.16 g/cm³
Viscosity	GB/T 22235	170-270 mPa•s
Hardness	ASTM D2240	81-86 Shore D
Mechanical Properties		
Tensile Strength	ASTM D638	36-62 MPa
Elongation at Break	ASTM D638	25-40 %
Flexural Strength	ASTM D790	39-63 MPa
IZOD Impact Strength	ASTM D638	30-40 J/m
Thermal Properties		
Heat distortion Temperature	GB/T 1634	N/A °C

Wuhan University Building A403-I,A901,No.6 Yuexing 2 Road,Nanshan District,Shenzhen,Guangdong

China

Tel +86 755 86581960
fax +86 755 26031982
Email: bright@brightcn.net

www.esun3d.net

Recommended printing parameters

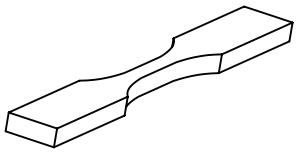
Settings	Machine Type Low Light Intensity	Medium Light Intensity	High Light Intensity (Monochrome LCDScreen)
Representative Machine	AnyCubic Photon	eSUN LCD 3.0 Nova Bene 4 Creality LD-002R	Anycubic MONO X ELEGOO Saturn Phrozen Sonic Mini
Exposure Time/s	9-15	6-9	Not recommended
Bottom Layer Count		3-5	
Bottom Exposure Time	50-70	30-50	Not recommended
Lifting Distance/mm	5.5&6-inch screen：5-6or Higher	8.9&13.3-inch screen：8-12 or Higher	
Lift Speed/mm•min-1	90-150	90-120	Not recommended
Retract Speed/mm•min-1		150-200	

1. The above parameters are for reference only. The performance of the cured material will be affected by factors such as equipment, environment, parameter settings, post-processing methods, detection methods, etc., which will cause big differences. Please contact us if necessary;2. Shake the resin well before use; please recycle the resin in time after printing; avoid prolonged soaking of the molded parts in the cleaning agent;3. It is not recommended to add other ingredients or mix them to the resin to avoid molding failure or other problems;4. The resin should be stored in a cool, dark place, and sealed with an opaque container;5. The photopolymer resin is made of chemicals, which has a certain odor and skin irritation. Pay attention to protection during transportation and use. If the resin accidentally touches your skin or eyes, please rinse with plenty of water, and the skin can be cleaned with detergent, decontamination powder, etc.; if the allergic reaction is severe or even enters the mouth or nasal cavity, please seek medical attention immediately;6. The model should be printed at a room temperature of 25-35 degrees. IF is recommended to turn on the air conditioner for printing.

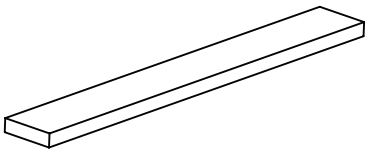
Matters needing attention

High-precision resin could be easier to settle, shake it well before printing.

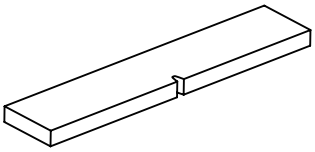
Mechanical Properties



Tensile testing specimen ASTM D638



Flexural testing specimen ASTM D790



IZOD Impact Strength ASTM D638

The physical properties, mechanical properties, and thermal properties of the resin are obtained based on the printing spline test.

Notice

All information supplied by or on behalf of eSUN in relation to this product, whether in the nature of data, recommendations or otherwise, is supported by research and, in good faith, believed reliable, but the product is sold “as is”. eSUN assumes no liability and makes no representations or warranties, express or implied, of merchantability, fitness for a particular purpose, or of any other nature with respect to information or the product to which information refers and nothing herein waives any of the seller's conditions of sale.

Wuhan University Building A403-I,A901,No.6 Yuexing 2 Road,Nanshan District,Shenzhen,Guangdong

China

Tel +86 755 86581960
fax +86 755 26031982
Email: bright@brightcn.net

www.esun3d.net