

Technical Data Sheet - 3D Printing Resin

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#6 HEAT RESISTANT RESIN

- Viscosity (@25°C): 350±30cps
- Liquid Density (@25°C): 1.1~1.15g/cm³
- Bending Strength: 95MPa
- Tensile Strength: 50-60MPa
- Hardness (Shore): 85D
- Wavelength: 405nm
- Volume Shrinkage: 1.0~1.3%
- Elongation: 103~105%
- Resistance: 230°C
- Best Printing Temperature: 25~28°C
- Storage Temperature: 5~30°C



Setting parameters for 405nm LCD printer

Layer Height (mm)	Bottom Layer Count	Exposure Time (s)	Bottom Exposure time(s)	Lift distance (mm)	Lifting speed (mm/min)	Retract Speed (mm/min)	Cleaning Liquid
0.05	6~8	4~6	60~90	5	45	60	IPA

General Recommended

PRINTER	LAYER HEIGHT	LAYER EXPOSURE (S)	# OF INITIAL LAYERS	EXPOSURE FOR INIT LAYERS
RGB LCD	0.03mm	6~8	5~7	50~80
MONO LCD	0.025~0.4mm	2~4	6~8	20~40
DLP	0.025~0.4mm	2~4	6~8	20~40

* Note: Room temperature 24-28°C