



## #1 STANDARD RIGID RESIN

- Viscosity (@25°C): 360±30cps
- Liquid Density (@25°C): 1.05~1.25g/cm³
- Bending Strength: 35~55MPa
- Tensile Strength: 70~85MPa
- Hardness (Shore): 95D
- Wavelength: 405nm
- Volume Shrinkage: 1.6~2%
- Elongation: 102~105%
- Resistance: 70~80°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	2~4	40~60	6	120	120	Ethanol

### General Recommended

PRINTER	LAYER HEIGHT	LAYER EXPOSURE (S)	#OF INITIAL LAYERS	EXPOSURE FOR INIT LAYERS
RGB LCD	0.025~0.05mm	6~9	5~7	60~100
MONO LCD	0.025~0.1mm	2.5~5	5~7	30~70
DLP	0.025~0.1mm	2.5~5	5~7	30~70

\* Note: Room temperature 20-28°C

### Standard Resin Feature





## #2 ABS-LIKE RESIN

- Viscosity (@25°C): 380±30cps
- Liquid Density (@25°C): 1.05~1.25g/cm³
- Bending Strength: 50~70MPa
- Tensile Strength: 50~65MPa
- Hardness (Shore): 90D
- Wavelength: 405nm
- Volume Shrinkage: 1.5~1.8%
- Elongation: 105~110%
- Resistance: 50~60°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	2~4	40~60	6	120	120	Ethanol

### ABS-LIKE Resin Series Recommended

PRINTER	LAYER HEIGHT	LAYER EXPOSURE (S)	# OF INITIAL LAYERS	EXPOSURE FOR INIT LAYERS
RGB LCD	0.025~0.05mm	6~9	5~7	60~100
MONO LCD	0.03~0.05mm	1.5~4	5~7	25~40
DLP	0.03~0.05mm	1.5~4	5~7	05~40

Note: Room temperature 20-28°C

### ABS-Like Resin Feature





### #3 WASHABLE RIGID RESIN

- Viscosity (@25°C): 380±30cps
- Liquid Density (@25°C): 1.05~1.25g/cm³
- Bending Strength: 35~55MPa
- Tensile Strength: 60~75MPa
- Hardness (Shore): 90D
- Wavelength: 405nm
- Volume Shrinkage: 1~1.3%
- Elongation: 103~106%
- Resistance: 60°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	2~4	40~60	6	90	120	Water / Ethanol

#### General Recommended

PRINTER	LAYER HEIGHT	LAYER EXPOSURE (S)	# OF INITIAL LAYERS	EXPOSURE FOR INIT LAYERS (S)
RGB LCD	0.03mm	6~10	5~7	90~120
MONO LCD	0.03~0.05mm	2~5	5~7	50~80
DLP	0.03~0.05mm	2~5	5~7	50~80

Note: Room temperature 20-28°C





#### #4 WASHABLE TOUGH RESIN

- Viscosity (@25°C): 380±30cps
- Liquid Density (@25°C): 1.05~1.25g/cm³
- Bending Strength: 35~55MPa
- Tensile Strength: 50~65MPa
- Hardness (Shore): 80D
- Wavelength: 405nm
- Volume Shrinkage: 1~1.3%
- Elongation: 103~106%
- Resistance: 60°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	2~4	40~60	6	90	120	Water / Ethanol

#### General Recommended

PRINTER	LAYER HEIGHT	LAYER EXPOSURE (S)	# OF INITIAL LAYERS	EXPOSURE FOR INIT LAYERS (S)
RGB LCD	0.03mm	6~10	5~7	90~120
MONO LCD	0.03~0.05mm	2~5	5~7	50~80
DLP	0.03~0.05mm	2~5	5~7	50~80

Note: Room temperature 20-28°C







## #5 SPECIAL ENGINEERING RESIN

- Viscosity (@25°C): 430±30cps
- Liquid Density (@25°C): 1.05~1.25g/cm³
- Bending Strength: 60-85MPa
- Tensile Strength: 60-75MPa
- Hardness (Shore): 85D
- Wavelength: 405nm
- Volume Shrinkage: 2.0~2.4%
- Elongation: 105~110%
- Resistance: 150°C
- Best Printing Temperature: 25~28°C
- Storage Temperature: 5~30°C

### Setting parameters for 405nm LCD printer

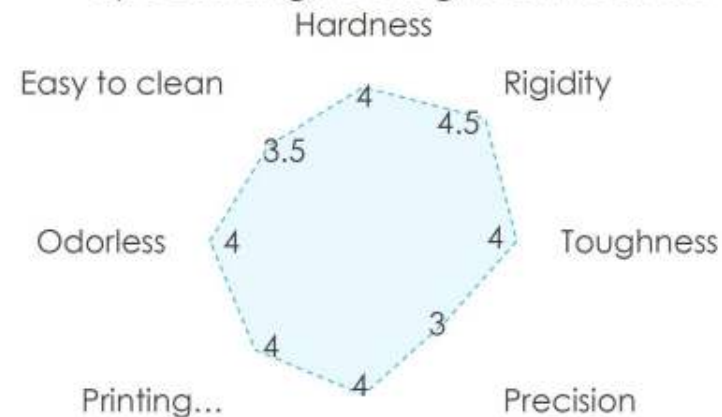
Layer Height (mm)	Bottom Layer Count	Exposure Time (s)	Bottom Exposure time(s)	Lift distance (mm)	Lifting speed (mm/min)	Retract Speed (mm/min)	Cleaning Liquid
0.04	6~8	3~5	50~80	7	60	90	IPA

### General Recommended

PRINTER	LAYER HEIGHT	LAYER EXPOSURE (S)	# OF INITIAL LAYERS	EXPOSURE FOR INIT LAYERS
RGB LCD	0.03mm	9~13	5~7	100~130
MONO LCD	0.03~0.04mm	2.5~4	5~7	50~80
DLP	0.03~0.05mm	2.5~4	5~7	50~80

\* Note: Room temperature 20-28°C

### Special Engineering Resin Feature





## #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 20-28°C



## #7 RUBBER LIKE RESIN

- Shore Hardness: 60~75A
- Tear Strength: 47.2KN/m
- Tensile Strength: 7.9MPa
- Elastic Modulus: 2.0MPa
- Elongation at Break: 255.1%
- Viscosity(25°C): 980mpa.s

### 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	3	3.9	45	8	60	150	IPA

\* Note: Room temperature 20-28°C



## #8 PC-LIKE RESIN

- Viscosity (@25°C): 380±30cps
- Liquid Density (@25°C): 1.05~1.25g/cm³
- Bending Strength: 60-85MPa
- Tensile Strength: 60-75MPa
- Hardness (Shore): 85D
- Wavelength: 405nm
- Volume Shrinkage: 1.6~2.0%
- Elongation: 110~120%
- Resistance: 75°C
- Best Printing Temperature: 25~28°C
- Storage Temperature: 5~30°C

### Setting parameters for 405nm LCD printer

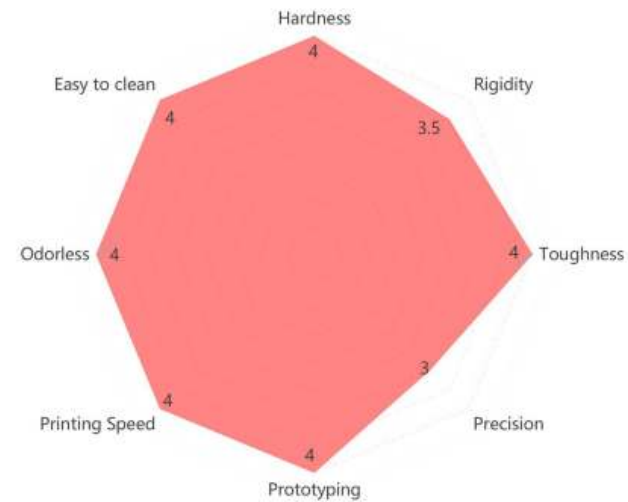
Layer Height (mm)	Bottom Layer Count	Exposure Time (s)	Bottom Exposure time(s)	Lift distance (mm)	Lifting speed (mm/min)	Retract Speed (mm/min)	Cleaning Liquid
0.05	6~8	2~4	50~80	7	90	120	IPA

### General Recommended

PRINTER	LAYER HEIGHT	LAYER EXPOSURE (S)	# OF INITIAL LAYERS	EXPOSURE FOR INIT LAYERS
RGB LCD	0.03mm	7~10	5~7	70~100
MONO LCD	0.03~0.05mm	2.5~4	5~7	50~80
DLP	0.03~0.05mm	2.5~4	5~7	50~80

Note: Room temperature 20-28°C

### PC-Like Resin Feature







## #9 NYLON-LIKE RESIN

- Viscosity (@25°C): 480±30cps
- Liquid Density (@25°C): 1.05~1.25g/cm³
- Bending Strength: 80-120MPa
- Tensile Strength: 50-70MPa
- Hardness (Shore): 75D
- Wavelength: 405nm
- Volume Shrinkage: 3.0~4.0%
- Elongation: 120~130%
- Resistance: 40~50°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
0.03	6~8	4~6	60~90	8	45	90	IPA

### General Recommended

PRINTER	LAYER HEIGHT	LAYER EXPOSURE (S)	# OF INITIAL LAYERS	EXPOSURE FOR INIT LAYERS (S)
RGB LCD	0.03mm	10~16	5~7	100~140
MONO LCD	0.03mm	6-10	5~7	60~90
DLP	0.03mm	6~8	5~7	60~90

\* Note: Room temperature 20-28°C

### Nylon-Like Resin Feature





## #10 HIGH TRANSPARENT ACRYLIC RESIN

- Viscosity (@25°C): 380±30cps
- Liquid Density (@25°C): 1.05~1.25g/cm³
- Bending Strength: 40-80MPa
- Tensile Strength: 50-65MPa
- Hardness (Shore): 85D
- Wavelength: 405nm
- Volume Shrinkage: 1.6~2.0%
- Elongation: 105~110%
- Resistance: 80°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
0.03	6~8	4~6	60~90	8	45	90	IPA

### General Recommended

PRINTER	LAYER HEIGHT	LAYER EXPOSURE (S)	# OF INITIAL LAYERS	EXPOSURE FOR INIT LAYERS (S)
RGB LCD	0.03mm	10~16	5~7	100~140
MONO LCD	0.03mm	6-10	5~7	60~90
DLP	0.03mm	6~8	5~7	60~90

\* Note: Room temperature 20-28°C

