Prototype – Clear

Light-curing resin based on (meth)acrylate, for the generative fabrication of 3D-Objects.

IMPORTANT NOTES
- Only to use by trained specialist personnel
- Always keep the container tightly sealed, immediately close the container after use

PROCESSING
- Processing temperature 23°C +/- 2°C
- Please note the instructions on page 2

SAFETY NOTES
- Be sure to use personal protective equipment (protective gloves and protective glasses) during processing
- Avoid direct contact with the liquid material and the components prior to post-curing
- Irritating to skin and eyes (sensitization is possible)
- After contact with eyes rinse thoroughly with water immediately and consult a doctor
- After contact with skin wash immediately with water and soap

STORAGE
- This material is used to be stored dry at 15°C – 28°C
- Protect from light, minimal influence of light can already induce polymerisation

Manufacturing process

Construction process

Generation of a Print Job complying with machine and material parameters

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Post-processing

Post-processing should commence immediately following the construction process. After raising the platform, a drip time of approx. 10 minutes in recommended.

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Pre-cleaning

Remove construction components from the platform and clean in a separate vessel with isopropyl alcohol (purity >98%) for 3 min. in an ultrasonic bath.

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Cleaning

Then thoroughly clean the openings, cavities and gap areas, if necessary also with compressed air, and if applicable, remove the construction components carefully from the support structure.

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Main cleaning process

This process is performed in a separate vessel with isopropyl alcohol for 3 min. in a ultrasonic bath. Prior to drying, check the openings and additional holes for residues

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Drying

Heat the construction components for 30 min. to approx. 40°C to remove solvent residues.

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Post-exposure
The recommended Post-curing is done with a xenon Otoflash G171 with 2x2000 flashes. Rotate components in between.