

INSTRUCTIONS FOR USE

XRESIN MODEL - PHOTOPOLYMER RESIN FOR PERFECT 3D PRINTING



The new water-soluble xRESIN Model photopolymer resin is used for the high-precision creation of 3D printed models with low shrinkage, highest fineness and a very smooth surface.

- Impresses with rapid UV curing
- Low odour nuisance
- Washable with water
- Very good resolution
- Optimised for LCD displays, DLP and SLA printers
- Reduced printing time due to high flowability
- Highest fineness with a very smooth surface
- Available in grey, white and beige
- Made in Germany

1. Pack Size

1,000 ml bottle and as 5,000 ml container

The photopolymer resin impressed with its rapid UV curing and very high stability. It is optimized for the weak light of LCD displays. The efficiency is much higher than comparable resins on the market. This resin is recommended for LCD displays, but is also compatible with DLP or SLA printers. Due to the above-average flowability, the printing time is significantly reduced.

2. Print settings:

Exposure time first layer in seconds: 15 – 50 s

Normal exposure time in seconds: 5 – 20 s

3. Storage method:

Protect from light and store at room temperature (Sunshine can harden the photosensitive resin). It is recommended to store the resin at an ambient temperature of 15 to 35°C. The lower the temperature, the higher the viscosity of the resin. Sealed storage, excessive dust, or moisture can affect print quality.

4. Material-related characteristics

Technical details

Wavelength	405 nm
Shore Hardness (D)	84
Viscosity (25°C)	200 Mpa/s
Liquid Density	1.20 cm ³
Flexural Strength	58 Mpa
Extensibility	36 Mpa
Elongation Failure	8.0 %
Modulus of Elasticity	2200 Mpa
Shelf life	18 months

4. Use

Shake well before use. Avoid using resin in places with a lot of sunlight.

DO NOT rinse printed objects under the tap. Please make sure that these chemicals do not get into the environment! Use tubs / containers filled with water. Pour any unused resin back into the original resin bottle. Also avoid leaving the resin in the tub for too long without being used, as any resin contamination could affect future printing (without having poured the resin into airtight containers or sealed it with a plastic sheet).

5. Post processing:

1. Remove the model using the metal scraper and clean the model in the cleaning box with water to wash off the excess resin in less than 2 to 3 minutes.
2. Then place the model in another cleaning box and clean it with water to wash off the excess resins in less than 2 to 3 minutes. The model is finally cleaned in a water-filled ultrasound device in less than 1 to 2 minutes.
3. After cleaning, dry the model with a dust-free cloth or an air gun. Possibly cure the model in a curing box at 35°C.

Technical changes reserved. We reserve the right to make changes as a result of the continuous development of our products. Please find the current version of the instruction manual on our website: www.x-dentaldepot.com

This version replaces all previous versions.