



## Resin Information

To receive correct results after printing it is important to know how to take care about materials such as resins.

To prevent from failures:

### 1) Keep the resin in Room Temperature (24-30°C)

Make sure to preserve resin at room temperature. Store in dark and ventilated conditions. Ideally the temperature should be around 24-30°C. If the temperature is lower (around 18-24°C) increase exposure time by 20%.

### 2) Shake well the resin bottle before printing

Before pouring resin into the resin vat, make sure to shake evenly for approximately 30 seconds to a minute. This is because resin is made up of several components including color pigments, which tend to settle at the bottom of the bottle.

As resin is shaken, the sediments will distribute evenly, meaning that you can create successful 3D prints more easily.

If you don't shake resin before pouring it into the resin vat, it will cure unevenly, and your prints may fail.

When pouring resin, make sure it does not exceed half the height of the resin vat. This prevents resin from overflowing during the printing process which could cause damage to the LCD screen.

### 3) After printing keep used resins in a closed & opaque bottle.

When you finish printing, keep the resin in a dark place, and in room temperature conditions. Avoid mixing used resin with new resin because that can have impact on the next printing process.

### 4) Keep resin away from kids and away from direct sunlight exposure.

It is important to keep the bottle away from kids because of the safety rules. Please remember that direct sunlight exposure can change the properties of the resin. If the resin is not stored properly (not in dark and closed bottle) can start to cure on the sunlight.

- 5) Wear gloves and masks when using resins. If this chemical contacts the skin or eye, wash with plenty of water.**

Always remember to wear gloves during having contact with the resin. The material can irritate the skin. For more information, please take a look at the Safty Data Sheet Document.

- 6) DO NOT dump resin. Please cure it and treat it as general plastic garbage.**

Never remove the liquid resin to trashes. Before throwing the resin away, please cure it and then as a solid print you can throw it away as a normal plastic item.

### **Tips**

You can refill the resin vat while printing, but you need to follow the instructions:

- DO NOT pause the printing process
- Remove/open the case/chamber
- Slowly pour resin into the vat as the building plate moves up
- Make sure the UV lights are turned off while doing so
- Once the resin vat has been filled, place/close the case back onto your 3D printer
- Resume printing

### **Note:**

DO NOT overfill the resin vat as this may cause spillage, which could damage your device.

After each print, use the plastic scraper to remove any cured resin left on the building plate and the FEP film.