MSLA Castable – Cyan
(MSP-C001CN)

Check

- Vat and LCD screen are clean
- Shake well (60 sec) before pouring
- Vat and platform are tightened properly

Setting Recommendation Chart

MSLA Castable

Recommended Setting Parameters
(50 um layer thickness for fine structure)

Printer	Normal Layer Time (sec)	Bottom (Burn-In) Layers	Bottom (Burn-In) Time (sec)	Lifting Speed (mm/min)
Shuffle	12	6	40	60
Shuffle XL	12	6	40	60
Sonic	2.5	6	7	60
Sonic mini	5	6	15	60
MiiCraft	1.2	6	4	slow

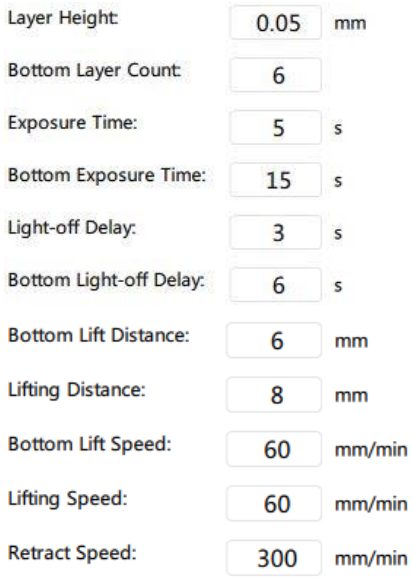
Each printer is unique, light intensity varies from printer to printer even though they are the same model and make. Please adjust normal exposure time from our recommended settings ±3 (±0.5 for sonic) seconds for your printer and print geometry.

For size calibration, download the stl file:
https://www.thingiverse.com/thing:1586206

Setting Example:

For Phrozen Sonic:

For Phrozen Sonic Mini:



Washing

Fresh IPA rinse (95+% concentration) over prints. Do NOT submerge prints in IPA. Blow dry via compressor air immediately after rinse and set print in a shaded airy place to fully dry before casting (approx 60 mins). **Limit IPA contact time to 30 seconds as prolong contact time could cause print deformation.**

Color migration (leaking color from prints) of prints are normal.

No Post-Curing Needed

Storage

Do Not store resin in the vat for more than **2 days** when not in use. Filter out all debris in case of failed prints.

Note: Slight pigment settlement is normal. Gently mix remaining resin in resin vat with soft wiper for color evenness.

Product Features

Low shrinkage (Storage at 25℃ for 1 week, <1 vol%)
Low ash
Low expansion during burnout
No need for UV post-curing
No need for dip or spray
Compatible with gypsum-bonded investment (R&R Ultravest, Omega+ or other similar investments)

Burnout Schedule

Follow the burnout schedule of your investment manufacturer, or the schedule we recommend below and make modifications according to your burnout equipment.
Ideal Max. Temp: 750~800℃ (ensure the investment is able to withstand 800℃)