

## WATER WASHABLE 3D PRINTING RESIN

Water Washable Resin Parameters	
Curing Wavelength	355nm – 410nm
Layer Thickness	0.05mm
Exposure Time	1.5s – 2.5s
Light Turn Off Time	0.5s
Bottom Layer Exposure Time	20s – 25s
Bottom Layer Quantity	4 – 6
Anti-Aliasing Level	1
Z-axis Lifting Distance	6mm
Z-axis Lifting Speed	2mm/s – 6mm/s
Z-axis Lifting Retraction Speed	3mm/s – 6mm/s

Water Washable Resin Technical Specifications		
Physical Properties	Test	
Density	ISO 1183	1.1g/cm <sup>3</sup> – 1.2g/cm <sup>3</sup>
Viscosity (25c)	Rotameter Viscometer	100cps – 200cps
Molding Shrinkage	ISO 294	0.2% – 0.7%
Mechanical Properties		
Tensile Strength	ISO 527	30Mpa – 35Mpa
Elongation at Break	ISO 527	6% - 9%
Flexural Modulus	ISO 527	2100Mpa – 2200Mpa
Flexural Strength	ISO 178	55Mpa – 65Mpa
Hardness (after curing)	ISO 868	84 Shore D

### Directions:

Shake well before use, always use gloves and mask when handling. Before pouring into vat inspect FEP sheet for any dents, deep scratches, or holes and that the FEP sheet is clear (transparent), clean, and free of any debris. Do NOT fill vat past max fill line. After printing strain remaining resin back into bottle and tighten lid. Store in a cool, dry place until next use, avoid direct sunlight.

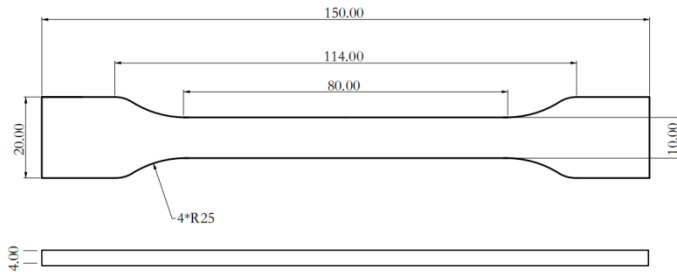
### Post Processing:

Once printed, models need to be washed with water to remove excess resin and dried with a lint-free cloth, paper towel or compressed air. Once dried, model needs to be cured under a 405nm UV light for 1-5 minutes depending on size and rinsed off with water. Beware: overcuring can cause yellowing, brittleness and cracking.

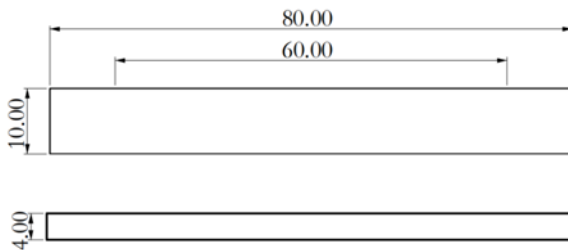
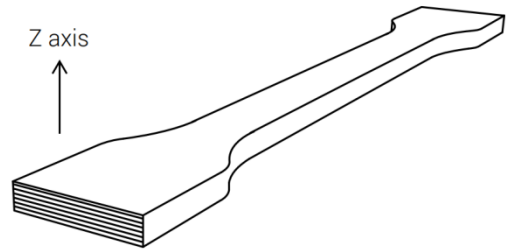
### Safety Information:

KEEP OUT OF REACH OF CHILDREN AND ANIMALS. Avoid skin or eye contact, inhalation or ingestion. Resin not suitable as a food and drink container or for use in aquariums. Please refer to products MSDS for safety information, available below at [info@3dmeta.com.au](mailto:info@3dmeta.com.au)

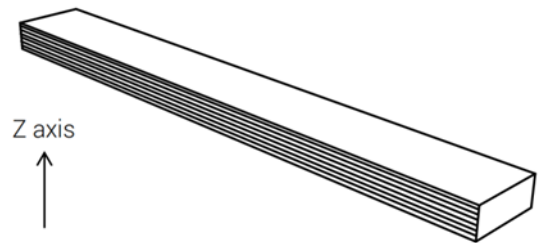
## Test Sample Dimensions and Printing Direction



Tensile testing specimen; ASTM D638 (ISO 527, GB/T 1040)



Flexural testing specimen; ASTM D790 (ISO 178, GB/T 9341)



### Disclaimer:

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