

# PRIMAVALUE™

## SUPER STRONG RESIN

### Why should I use PRIMAVALUE™ Super Strong resin?

- Great flexibility, strength and very high impact resistance
- Very easy to use
- Low odour



### PRIMAVALUE™ Super Strong Resin

Perfect for most DLP and LCD printers on the market. Applicable industrial, Toys, carton figures, education, dental, jewelry, industrial modeling etc.

#### PRINTING PARAMETER

Only has to adjust the exposure times according the layer height, and leave the rest as it was.

#### RECOMENDED SETTINGS

##### Bottom exposure time

LCD colorful panel: 50s	LCD monochrome panel: 50s	DLP 3D Printer: 20s
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##### Each layer exposure time

LCD colorful panel: 4~10s	LCD monochrome panel: 2~4s	DLP 3D Printer: 1~2s
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##### Print profile

Layer Height:	0,05 mm	Bottom Lift Distance:	5 mm
Bottom Layer Count:	8	Lifting Distance:	5 mm
Exposure Time:	8 s	Bottom Lift Speed:	90 mm/min
Bottom Exposure Time:	50 s	Lifting Speed:	100 mm/min
Light-off Delay:	2 s	Retract Speed:	150 mm/min
Bottom Light-off Delay:	2 s		

##### Note:

1. Bottom layer count: Bottom layer thickness / Layer height + 1 e.g. Bottom height 0,4mm, layer height 50um, the bottom layer count=0,4mm/0,05mm+1=9 layers.
2. The exposure time should be adjusted according to printer light energy, layer thickness and model structure. If the layer height less than 50um, we suggest the exposure time of each layer will be deducted about 2s.



\* Please see our website for latest options and colors available.

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### CLEANING

#### Step 1

Spray with Isopropanol, then blow resin away with cool wind.

#### Step 2

Prepare two containers with Isopropanol (alcohol > 95%), and place the object into the first container and slightly shake it, then soak in the second container for about 1 minute (dental resin should not exceed 30 seconds).

#### Step 3

Flush with water before you dry it, make sure it's 100% dried as residuary alcohol may cause white spot or crack on jobs.

### POST-CURING:

#### Step 1

The curing time is proportional to the volume of the work piece and inversely proportional to the optical power of the curing chamber. Example: 100 watt LED curing box, jewelry jobs is recommended to be cured with soaking in water for 20-30 minutes.

#### Step 2

The post-cure time of dental casting resin, dental non-casting resin and jewelry mold resin shall not more than 5 minutes.

#### Step 3

Work-pieces should be in the water during post-curing to prevent deformation especially for dental and jewelry.

#### Step 4

Don't forget to use cool air to dry it after post-curing.

Reseller:

### WARNING

- This material should not be in contact with eyes, skin or clothing, and should not be tasted or eaten.
- If you accidentally touch your eyes or skin, immediately rinse with water for about 20 minutes and seek medical advice if necessary.
- Please pay attention to air circulation and take protective measures when using. Wash thoroughly after handling.
- The product is in a liquid state with a slight odor. Wear a mask and gloves.
- The product should be stored in a sealed container. After use, it should be filtered and keep back in bottle on time and placed in a dry and well ventilated place. It should not be exposed to sunlight.
- Shake well before use, and leave it for 30 minutes to eliminate air bubbles that generated during the shaking process.
- The ambient temperature is recommended to be controlled at 25-30 degrees Celsius, and during the printing should avoid any lights.
- Dispose of waste in accordance with local environmental regulations.
- Storage environment: Store in cool and dry place, and avoid sunlight, recommended temperature at 25-30 degrees Celsius.

### Technical specification

Flexural modulus: 420.8Mpa ±10%	Elongation at break: 75.7% ±10%
Flexural strength: 12.6 MPa ±10%	Hardness(Shore D): 75-78D ±10%
Yield point elongation: 6.59% ±10%	Glass transition temp.: 80°C
Viscosity: 300-650 MPa·s	Density: 1.05—1.25 g/cm <sup>3</sup>
Maximum pulling strength: 830N ±10%	Notched impact strength: 736 J/m ±10%
Tensile strength: 19.9 Mpa ±10%	Absorb wavelength: 355-415nm
Tensile Modulus: 197.4 Mpa±10%	
Testing room temperature: 23°C±2°C	Testing room humidity: 50%RH±5%RH
Testing standard of test strip: ASTM	