

Flexible Resin

FEATURES	APPLICATIONS
<p>Flexible Photopolymer Resin: Features excellent flexibility with a Shore hardness $\leq 70A$, outstanding tear resistance, and elongation at break. It offers good elasticity, easy molding during printing, low odor, easy cleaning, high printing precision, and good weather resistance.</p> <p>Colors: Black, Gray.</p>	<p>Suitable for model printing: figurines, shoe molds, toys, cushioning parts, airtight components, etc.</p>

Properties	ASTM/ISO	Test Condition	S.I. Units	Typical Values
Mechanical				
Tensile Strength	ISO 527	50mm/min	MPa	4
Elongation at break	ISO 527	50mm/min	%	130
Flexural Strength	ISO 178	10mm/min	MPa	/
Flexural Modulus	ISO 178	10mm/min	MPa	/
IZOD Impact Notched	ISO 179	4mm, 23°C	J/m	/
Thermal				
Heat Deflection (HDT)	ISO 75	0.45MPa	°C	/
Glass Transition(Tg)	ISO 11357-2	10°C/min	°C	/
Melting Point	ISO 11357-1	10°C/min	°C	/
@5%Decomposition Temp.	ASTM E2402	20°C/min	°C	335.58
Coefficient of Thermal Exp.	ASTM E831	/	$\mu m (m^{\circ}C)$	101×10^{-6}
Others				
Lishao hardness	ISO868	23°C	A	70
Mold Shrinkage	ISO294	23°C	%	7.38
Basic physical properties of resin				
Item	Parameters/Methods			
Curing wavelength (nm)	365—405			
liquid density (g/cm ³)	1.00742±0.05			
Solid density (g/cm ³)	1.1598±0.03			
Resin viscosity (mPa.s/°C)	≤ 2000			
Storage condition	15-35°C , <60%RH Light-shielded sealed storage			
validity period	2 years			
Cleaning method	The printed model can be cleaned with alcohol. For models with intricate details, it is recommended to use an ultrasonic cleaner			

	with alcohol for 2-5 minutes. Alternatively, manual cleaning with alcohol is also effective, and using a brush can enhance the cleaning results.
Post-curing mode	After cleaning, cure in a post-curing chamber for 5-10minutes..

[1]Typical values are laboratory average data and are provided for reference only. They are not to be considered as product standards.

Suggested print parameters and instructions

Item	Explain
Print optimum ambient temperature (°C)	25—30°C/ < 60%RH
Recommended print layer thickness (mm)	0.05mm
Bottom number	5-10
Bottom exposure time (S)	RGB LCD Screen 30-120s; Monochrome LCD Screen 25-100s
Layer exposure time (S)	RGB LCD Screen 8-30s; Monochrome LCD Screen 5-10s
Lifting height (mm)	6-10 mm (7-inch or larger machines: lifting height recommended >8. 10-inch or larger machines: lifting height recommended >10.)
Lifting speedt (mm/min)	60-90
Return/descent speed (mm/min)	60-90
Extinguishing delay time (S)	1-2

The above values are for printer reference only, and can be adjusted according to different models, different models and product requirements.

Safety and Handling Precaution

A Material Safety Data Sheet (SDS) for this product is available from your local Sunlu office. The SDS provides customers with information on material handling, safety and disposal, as well as the requirements of applicable local health and safety regulations. The following are general precautions and apply only to the resins supplied.

This product is not for oral consumption, keep out of reach of children, avoid eye contact, and in case of accidental contact, rinse with plenty of water immediately. If discomfort persists, seek medical attention promptly.

Follow proper operating procedures; ensure good ventilation in the printing area. Before using resin, shake well and wear gloves and a mask. It is recommended to store in a light-shielded place at a temperature of 15°C-35°C and humidity

resin viscosity. Optimal printing conditions are at 25°C-30°C, with humidity below 60%. Before printing, wait for the bubbles to disappear completely. In most cases, good general ventilation equipment is sufficient. Local exhaust ventilation should be used when necessary.

Seal and store to avoid environments with excessive dust or moisture, which may affect printing quality. Store in a light-shielded area to prevent direct sunlight exposure, as sunlight contains a large amount of ultraviolet rays that

Users are advised to investigate the final use of their product beforehand to ensure the correct use of Sunlu products. To prevent misuse or incorrect use of Sunlu products, it is advisable to contact the Sunlu R&D department or the marketing



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