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## Technical datasheet Prusament Resin Model+



### Identification

Name	Prusament Resin Model+
Color	All colors
Usage	3D printing
Manufacturer	Prusa Polymers a.s., Prague, Czech Republic

### Basic material properties

Odour	Low	
Viscosity (25 °C) [mPa/s]	300-400	ISO 2431

## Recommended settings

Resin details		SL1S					
Type	Name	25 um [s]	First layers [s]	50 um [s]	First layers [s]	100 um [s]	First layers [s]
Model+	All colors	1.8-2	5-6	<b>2-2.3</b>	<b>6-8</b>	3.2-3.5	8-10

## Recommended post-processing

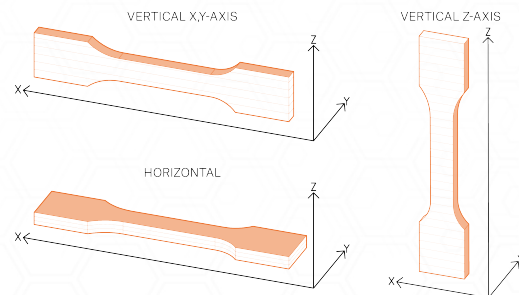
1. Washing cycle in Prusament Resin Cleaner DPM (or IPA) [min] (1)	5
2. Washing cycle in water (at approx. 25 °C) [min]	3
Minimal curing time [min]	3
Optimal curing time [min]	10
Model+ Transparent Clear minimal curing time [min]	1
Model+ Transparent Clear optimal curing time [min]	2

(1) The second washing cycle in water is not necessary when using isopropyl alcohol.

## Mechanical properties(2)

Property/print direction	XY Greenbody	Cured XY (3 mins)	Cured XY (60 mins)	Method
Tensile strength [MPa]	15.4	27.3	47.4	ISO 527-1
Elongation [%]	25.9	19.8	9.7	ISO 527-1
Tensile modulus [MPa]	348.9	1169.2	2010.2	ISO 527-1
Impact strength Charpy [kJ/m <sup>2</sup> ](3)	57	52	39	ISO 179-1
Notched impact strength Charpy [kJ/m <sup>2</sup> ](4)	12	9	8	ISO 179-1
Heat deflection temperature (0,45 MPa) [°C]	29.6	30.2	39.3	ISO 75
Heat deflection temperature (1,8 MPa) [°C]	26	27	36.9	ISO 75
Hardness - Shore D	83	84.5	86	ISO 164

(2) Original Prusa SL1S Speed 3D printer was used to make testing specimens. PrusaSlicer-2.9.4 was used to create G-codes with the following settings: Prusament Resin Model+ Prusa Orange; layer 0,05mm; faded layers: 0; exposure times: 2s/7s (SL1S), without supports and pad; other parameters set the default.  
 (3) Impact resistance Charpy - Edgewise direction of blow according to ISO 179-1.  
 (4) Notched impact resistance Charpy - Edgewise direction of blow according to ISO 179-1.



## Basic safety information

This resin is not meant for contact with food, drinks, or medical use on or in the human body. Always read the material safety data sheet thoroughly.

Resins are classified as dangerous chemicals and it is necessary to dispose of them properly in designated containers.

Resin bottles (empty or full) must never be disposed of or poured into the general waste.

## Manipulation directions

Shake well before use.

Store at room temperature away from direct sunlight.

Use protective equipment for manipulation.

Do not pour the contents of the canister into general waste. Dispose of empty bottles and unused resin at designated places.

### ***Disclaimer***

The results presented in this data sheet are just for your information and comparison. Values are significantly dependent on print settings, operator experiences, and surrounding conditions. Everyone has to consider the suitability and possible consequences of printed parts usage. Prusa Polymers Corp. can not carry any responsibility for injuries or any loss caused by using Prusament Resin Model+. Before the use of Prusament Resin Model+ material, read properly all the details in the available safety data sheet (SDS).