MyMiniFactory

Premium Resin
Technical Specifications, User and Safety Guide

Product name: **Premium Resin**
Brand: **MyMiniFactory**
Color: **Adamantine Gray**

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Resin characteristics

Proprietary non-brittle formula, slightly elastic for improved resistance.
Premium Resin can be suitable for different post processing like drilling, tapping, assembling etc. Non VOC, RoHS, Reach, En71-3 certified

Ideal for miniatures and terrains. The color shading has been studied to highlight details from the 3D model. The porosity of cured resin guarantees an ideal product for application of paint.

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Technical Data

Flexural modulus：**993.8** Mpa ±10%	Elongation at break：**35.44**% ±10%
Flexural strength ：**39.38** MPa ±10%	Hardness(Shore D)：**80-83** D ±10%
Yield point elongation： **7.22**% ±10%	Glass transition temp.：**80**℃
Viscosity：**600-800** MPa·s	Density：**1.05**—**1.25** g/cm3
Maximum pulling strength: **1768**N ±10%	Notched impact strength: **493.3** j/m ±10%

Tensile strength：**31.53**Mpa ±10%
Tensile modulus：**523.73** Mpa

Testing room temperature：**23**℃±2℃	Testing room humidity ：**50**%RH±5%RH
Testing standard of test strip： **ASTM**	

Post curing： test strip in water for 2 mins post curing with **200**mw/cm²405n

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Printing parameters

MyMiniFactory's Premium Resin is Compatible for most LCD/MSLA and DLP 3D printers brands like: Anycubic, Phrozen, Creality, Longer 3D, Elegoo and more.

Suggested settings:

For MSLA - LCD printer with **RGB Screen**

Bottom layers (aka burnt layers):	**50s** to **55s**
Standard layers :	**8s** to **10s**
Layer height up to :	**50 micron**

For MSLA - LCD printer with **Monochrome Screen**:

Bottom layers (aka burnt layers):	**25s** to **50s**
Standard layers :	**2s** to **3s**
Layer height up to :	**50 micron**

For DLP printers (**Projector based**):

Bottom layers (aka burnt layers):	**15s**
Standard layers :	**1s** to **5s**
Layer height up to :	**50 micron**

These are standard settings, exposure time should be adjusted based on light intensity, desired layer height and structure of the model.

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Cleaning

Step one:

Remove the extra liquid resin on the print by letting it drip away from the model. This can be achieved by using gravity or by spraying Isopropanol (alcohol> 95%) on the print and applying cool air from a hair dryer or a similar source. Be aware that the second option might require more working space.

Step two:

To remove the remaining resin, fill two containers with Isopropanol (alcohol> 95%) and put the printed item in one while slightly shaking it, soak the part in the second container and leave it for no more than a minute. Repeat the process if necessary.

Step Three:

Remove any trace of Isopropanol (alcohol> 95%) by rinsing the model in clean water, use a bucket of clean water or flush some water on your print. Avoid using sources as bathroom or kitchen sinks.

Make sure that the alcohol is completely removed from the model and dry it before going to the post-curing process. Any alcohol leftover may cause spots or cracks on your print during the post-curing process.

**Alternatively, cleaning stations from major brands such as Anycubic, Creality and Elegoo are available on the market. Be sure to check and use settings provided by the manufacturer.*

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Curing

The curing time is proportional to the volume of the print and inversely proportional to the UV light power of the curing chamber.

For better results, use a UV light and make sure any side of the print gets exposed to the light source. Turn the model at regular intervals to make sure each side of the model will get the same amount of light. If possible, use a motorized turning table within a closed chamber to achieve uniform exposure to light.
Do not overexpose your prints to UV lights, remove your print once satisfied with the quality of curing. For best quality, make sure no side of your model is left with uncured resin.
Any residual uncured resin will leave a sticky patina over your model, expose the uncured part to more UV lights to avoid the patina.

**Alternatively, curing stations from major brands such as Anycubic, Phrozen, Creality and Elegoo are available on the market. Be sure to check and use settings provided by the manufacturer.*

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Use and Storage

Prior to any use, make sure to shake the bottle well and leave it for at least 30 minutes to eliminate any air bubbles generated during the shaking process. Avoid any light when handling the resin.
After each use, any excess resin in your vat can be filtered and stored back in the original bottle for further use.
Recommended operating temperature: **25°C** to **30°C** (**77°F** to **86°F**)

Keep the resin in its original packaging and store the bottle in a cool and dry place. When in storage, avoid exposing the packaging to any source of light.
Recommended storage temperature: **25°C** to **30°C** (**77°F** to **86°F**)

Dispose of any waste of resin in accordance with the local environmental regulations.

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Warning

When handling the resin, always use protective gear such as gloves, eye protection and breathing mask. Be sure to clean your gear thoroughly and ventilate the area of work after use.

Never let the resin be in contact with eyes, skin or clothing. Avoid ingestion and any contact with your mouth. If the resin accidentally touches your eyes or skin, immediately rinse the exposed part with water for at least 20 minutes. Seek medical advice where necessary.

Photopolymer resins are toxic products, conceived to be used only by informed adults. Avoid any use by minors.
Always handle resin with caution and knowledge of the dangers that any misuse can bring.

MyMiniFactory Ltd. or Jamg-He won't be responsible for any damage caused to persons or goods by any misuse of Premium Resin or related products.

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