

Castable Wax Resin

珠宝铸造树脂

*Product introduction 产品介绍

Castable wax resin is a low skin irritation and low skin allergenic UV curable resin for 3D printing. It has low shrinkage, high precision, ash free, which is easy to reverse mold. Suitable for mass-produced products casting for all kind of jewelry application. 珠宝铸造树脂是一种用于3D打印的低皮肤刺激性和低皮肤致敏性紫外线固化树脂。它具有低收缩、高精度、低灰分和易倒模等特能，适用于各种珠宝首饰产品批量铸造等。

*Resin property 树脂特性:

Pre-cure 固化前(液态):

| Measurement 测试项目 | Test method 测试方法 | Value 测试数值 |
|---------------------------------------|---------------------|---------------|
| Viscosity 粘度, cps (@25°C) | ASTM D 2196 | 50-100 |
| Density 密度, g/cm ³ (@25°C) | ASTM D 792 | 1.05-1.15 |

*Suggest casting temperature 铸造温度建议:

| Part 1 | Part 2 | Part 3 |
|------------------|--------------------|------------------|
| 180 °C (3 hours) | 350 °C (2.5 hours) | 650 °C (3 hours) |

*Parameter suggestion 参数建议:

| Equipment 设备名称 | Thickness 层厚 | Base layer exposure 首层曝光时间 | Normal layer exposure 一般层曝光时间 | Lift speed 电机速度 |
|-------------------|-----------------|----------------------------------|-------------------------------------|--------------------|
| DJ-89 | 0.05-0.1 mm | 30-60 s | 6.5-7.5 s | 1-8 mm/s |
| DJ-89Plus | 0.05-0.1 mm | 30-60 s | 6.5-7.5 s | 1-10 mm/s |
| D128 | 0.05-0.1 mm | 30-60 s | 6.5-7.5 s | 1-3 mm/s |
| D136 | 0.05-0.1 mm | 30-60 s | 6.5-7.5 s | 1-5 mm/s |
| D158 | 0.05-0.1 mm | 20-40 s | 3.5-4.5 s | 1-10 mm/s |
| C01 | 0.05-0.1 mm | 30-60 s | 6.5-7.5 s | 1-10 mm/s |
| C02 | 0.05-0.1 mm | 30-60 s | 6.0-7.0 s | 1-10 mm/s |
| Halot One | 0.05-0.1 mm | 30-60 s | 8.5-9.8 s | 1-3 mm/s |
| Halot Sky | 0.05-0.1 mm | 30-60 s | 6.5-7.5 s | 1-8 mm/s |
| Halot Mage | 0.05-0.1 mm | 30-60 s | 3.5-4.5 s | 1-3 mm/s |
| Photon Mono M5s | 0.05-0.1 mm | 30-60 s | 6.5-7.5 s | 1-20 mm/s |
| Saturn 3 Ultra | 0.05-0.1 mm | 30-60 s | 6.5-7.5 s | 1-10 mm/s |

*Post-Processing Procedure and Note 后处理与清洗:

1. The print model should be cleaned with absolute ethanol/isopropanol and can be cleaned with a low-frequency ultrasonic cleaner. If high-frequency and high-power ultrasonic cleaning is used for

the model, it may cause certain damage to the surface of the model; 将模型利用无水乙醇或异丙醇超声波震荡机清洗，切勿以高频震荡或用力刷洗模型以免模型表面细节遭受破坏。

2. Thoroughly blow the model dry with a hair dryer or the like; 用气枪或吹风机移除表面清洗液。

3. It is recommended to remove the support for model with supports first, and then post-cure treatment. If you remove the supports after it's been post-cured, it will easily cause damage to the contact surface of the support point; 后固化前先移除大部分支撑，待后固化完成后进行细节支撑移除与表面修饰处理。

4. For some occasions where certain toughness is required, you can choose to cure with UV lamp for 5 minutes. The printed parts should be kept in a cool dry place. 根据选用的后固化调整对应的后固化时间。

***Safety Precautions 安全注意事项:**

1)Eye Contact: Immediately flush with plenty of clean water (under eye lids) for at least 20 minutes. Hold eyelids apart to ensure flushing. Washing within one minute of contact is essential to achieve maximum effectiveness. Seek medical attention immediately. 如眼睛不慎接触到树脂，请立即用清水清洗，清洗后如仍感觉不适请立即就医。

2)Skin Contact: Remove contaminated clothing and rinse contact area thoroughly with soap and water. 如不慎接触到衣物请立即更换以肥皂与清水立即清洗皮肤与衣物。

3)3D resin is not approved for use with food, drink, or medical application on the human body. 请勿将树脂与食品接触。

4)For additional information please see the Material Safety Data Sheet. 详情请参考物质安全数据表。

***Storage 储存方式:**

Below 25 °C cold storage for 18 months, sensitive to visible light, general illumination visible light will initiate polymerization reaction. 树脂在 25 °C 条件下避光储存保质期 18 个月，对可见光敏感，容易引发聚合反应。