

zDental Clear Aligner

A printing resin which can directly print orthodontic sleeve models. It provides the high precision, and has the characteristic of shape memory. It is light yellow liquid, but magically the printing models become colorless and transparent after post curing.

1. Suggested Printing Parameters

For NBEE		
Layer Thickness /mm	0.1	
Initial Layers	3	
Transition Layers	7	
	Normal Layer	Initial Layer
Exposure Time /s	1.1	15
Cool Down Time /s	1.0	1.0
Motor Speed / mm/min	1500	1500
Rise Height /mm	8	15
Shrink Internal /mm	0	
Shrink External /mm	0	
Offset X	1.007	
Offset Y	1.007	
LED Power	100%	

2. Properties Data

Properties	Post-Cured	Method
Tensile Strength	21.44 Mpa	ASTM D 638-14
Elongation at Break	99.44%	ASTM D 638-14
Tensile Modulus	177.47 Mpa	ASTM D 638-14
Flexural Strength	32.31 MPa	ASTM D 790-15
Flexural modulus	933.82 Mpa	ASTM D 790-15
Unnotched izod	310.60 J/m	ASTM-D256
Hardness Shore D	68D	
Heat Deflection Temp.(1.82 Mpa)	33.2°C	ASTM D 648-16
Heat Deflection Temp.(0.45 Mpa)	38.1°C	ASTM D 648-16

Tested by NBEE printer, layer thickness is 100um. Post-cured by Cure M with 5 minutes on level 3.

3. Storage

Stored in dark place where avoid direct sunlight or any kind of UV light, environment temperature is suggested around 5 to 30°C, and environment humidity is less than 45%RH.

The information and data stated herein are based upon tests in our lab and are considered to be reliable and accurate. Use by customers should be tested by themself firstly. This information and data are used for reference only, no warranty as a legal basis.

4. Precautions

- 1) After the resin is poured into the resin tank, let stand still for 5 to 10 minutes before start a print job.
- 2) The good using temperature for this resin is 18-28°C. Use the resin away from direct sunlight or any kind of UV light.
- 3) After the model is printed, please take it out in time and wash it with 95% concentration alcohol. Using an ultrasonic cleaner, the cleaning time depends on the size and complexity of the model, but the time should not be too long, otherwise the structural performance of the model will be reduced, what is no more than 2 minutes is suggested.
- 4) After the model is cleaned, immediately blow it dry with an air gun and post cure the model with a UV light, **a long post-curing time is needed for eliminating color residue of model** .
- 5) After the model is printed, please restore the remaining resin in resin bottle ASAP. It's not recommended to leave the resin in the resin tank for a long time.
- 6) Wear nitrile rubber gloves and a face mask when using this product. Keep the room ventilated. Swallowing such as eating and drinking is forbidden in the printing place.
- 7) If the user accidentally drops the resin on the skin, please wipe it away and then clean again with water. Use hand sanitizer or soap to assist in washing. If the users still feel uncomfortable, please see a doctor immediately. If the user accidentally splashes the resin in the eyes, flush with plenty of water and seek medical attention immediately. More safety details please refer MSDS of this resin.