

zDental Gingiva

This resin is used in combination with the model material. It provides certain flexibility and high precision, available in color pink.

1. Suggested Printing Parameters

For NBEE			For NBEE		
Layer Thickness /mm	0.1		Layer Thickness /mm	0.05	
Initial Layers	3		Initial Layers	3	
Transition Layers	7		Transition Layers	7	
	Normal Layer	Initial Layer		Normal Layer	Initial Layer
Exposure Time /s	0.7	15	Exposure Time /s	0.3	15
Cool Down Time /s	0.5	0.5	Cool Down Time /s	0.5	0.5
Motor Speed / mm/min	1500	1500	Motor Speed / mm/min	1500	1500
Rise Height /mm	8	15	Rise Height /mm	8	15
Shrink Internal /mm	0		Shrink Internal /mm	0	
Shrink External /mm	0		Shrink External /mm	0	
Offset X	1.005		Offset X	1.008	
Offset Y	1.005		Offset Y	1.008	
LED Power	100%		LED Power	100%	

2. Properties Data

Properties	Post-Cured	Method
Tensile Strength	1.32MPa	ASTM D 638-14
Elongation at Break	177.30%	ASTM D 638-14
Tensile Modulus	0.93MPa	ASTM D 638-14
Unnotched izod	354.60 J/m	ASTM-D256
Hardness Shore A	56A	

Tested by NBEE printer, layer thickness is 100 um.

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.

4. Precautions

1) Before use, shake the resin bottle well for 5-10 minutes to make the resin uniform. After the resin is poured into the resin tank, let stand still for 5 to 10 minutes before start a print job.

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.

- 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, the post-curing time is depended on the curing machine.
- 5) It's not recommended to leave the resin in the resin tank for over 12 hours. For better printing results, please restore the remaining resin in resin bottle. Shake well before next use.
- 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.