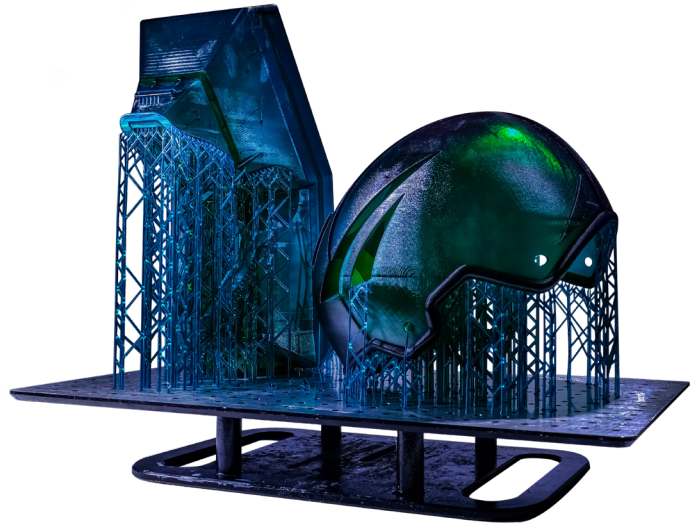




Daylight Magna Draft

SPECS



KEY FEATURES

Photocentric's Draft resin is our fastest printing resin yet. Specifically designed to allow for detailed, large parts to be printed in shorter times for rapid prototyping or even production. This resin works up to a 350 µm layer height with low curing times, reducing print times dramatically. The end parts manufactured exhibit very high strength comparable to acrylic and polyimide. The parts can't be bent or compressed easily and exhibit minimal shrinkage and high accuracy.

With excellent imaging in the LC Magna, this resin has fast exposure times and a wide exposure latitude. Allowing the parts to also hold the finest details possible from LC Magna. The finished material is tough, durable and long lasting provided it is stored in dry conditions away from strong UV light.

PRINTING (PROCESSING) INSTRUCTIONS

Follow the procedures laid out in the LC Magna user manual. Shake resin prior to use, recommended 2 minutes. Avoid direct sunlight while pouring. The resin is reusable after pouring through the supplied filter and funnel to remove any solids. Always keep door closed when not in use to avoid curing or contamination.

Post Processing guidelines:

- Do not leave the platform in the ambient light before washing and post exposing, this could lead to liquid resin curing prematurely.
- Wash in the wash 99L for approximately 15 minutes (as a maximum)
- Rinse with hot water to remove residue cleaner and resin
- Dry with air compressor to remove any remaining water from the part
- Post cure in a pre-heated Cure L for 2 hours at 60 degrees, for larger parts it can take up to 4 hours to post cure

Support guidelines:

- Support profile for small parts – 0.6mm tips / 1.5mm pole diameter / 2mm widening factor
- Support profile for large parts – 0.8mm tips / 2mm pole diameter / 2mm widening factor

Recommended resin temperature (pre-printing)

- 30°C

DATA

(Test pieces post cure: Cure L 405, 60 minutes 60°C)

Viscosity 970 cPs

(At 25°C Brookfield spindle 3)

Hardness 90 Shore D

ASTM D2240 (After post exposure for 60 minutes at 60°C)

Tensile strength 84 MPa

ASTM D638 (After post exposure for 60 minutes at 60°C)

Elongation at break 4.4%

ASTM D638 (After post exposure)

Young's modulus 3200 MPa

ASTM D638 (After post exposure for 60 minutes at 60°C)

Impact strength notched Izod 4.1kJ/m²

ASTM D256 (After post exposure)

Flexural strength 109 MPa

ASTM D792 (After post exposure)

Flexural modulus 2840 MPa

ASTM D792 (After post exposure)

Water absorption (24 h at 60°C) <0.2 wt%

Heat deflection temperature 75°C

Storage 10<t>50°C

Density 1.16 g/cm³

AVAILABLE COLOURS

Turquoise.

Available in 5kg bottles.