

MOIIN Tech Clear

NOTES FOR USE

MOIIN Tech Clear Resin is a (meth)acrylate-based light-curing resin for the production of technical objects (e.g. for rapid prototyping) using 3D printing.

The material is only suitable for use in tray polymerization devices (e.g., DLP / SLA printers) operating at a wavelength of 405 nm or 385 nm.

RECOMMENDED USE IN THE PRINTER

- Follow the printer instructions.
- Observe the machine and material parameters.
- Maintain the processing temperature of the material at $23\text{ °C} \pm 2\text{ °C}$ ($73\text{ °F} \pm 2\text{ °F}$).
- Shake material for at least 1 min prior to use and do not leave in the tray after printing.
- Ensure clean working procedures. Residues on the machine can cause defects on the printed object.
- Finishing should take place immediately after the construction process where possible.
- The object is not fully cured after printing (see "recommended post-processing").
- Close the bottle after use.

RECOMMENDED POST-PROCESSING

- Loosen the printed object from the construction panel. Carefully loosen the supporting structures and other supports.
- Optional: Pre-clean the printed object for 03:00 min using ethanol (approx. 96 %) and a brush.
- Optional: Clean openings, holes and gap areas for 02:00 min with compressed air.
- Clean the printed object for 03:00 min in a separate container using fresh ethanol (if necessary in an ultrasonic cleaner).
- Optional: Heat the printed object up to approx. 40 °C (104 °F) for 30 min in an oven to remove any solvent residues remaining from the cleaning process.
- Burn the printed object. Observe the manufacturer's instructions for the light-curing unit.
- Examples of post-curing devices and light-curing times:

Otoflash	2 x 2,000 flashes
Kulzer HiLitePower3D	2 x 180 s
Heraeus Heraflash	2 x 180 s

If other post-curing devices are used, the post-curing time should be adjusted accordingly

- Process the surface if necessary.

SAFETY INSTRUCTIONS

- Using the device incorrectly and failing to observe the specifications may place the user at risk or impair quality.
- Observe the safety data sheet.
- Irritates the eyes and skin (sensitization possible).
- Wear safety gloves (nitrile gloves), protective clothing and safety goggles while processing.
- Avoid eye contact! In the event of the liquid material accidentally coming into contact with the eyes, immediately rinse eyes thoroughly with plenty of water and consult a doctor if necessary.
- Avoid skin contact with non-polymerized material and the inhalation of monomer vapors. In rare cases, allergic reactions to components in the material may occur. If this occurs, consult a doctor.

COMPOSITION

Mixture of acrylate and methacrylate resins, photoinitiators and additives.

STORAGE

- Store in a dry place at room temperature ($15\text{ °C} - 25\text{ °C}$ / $59\text{ °F} - 77\text{ °F}$) protected from light.
- Even low exposure to light can trigger polymerization.
- Do not use after the expiration date.
- Keep out of the reach of children!

DISCLAIMER OF LIABILITY

- These instructions do not represent safety information according to applicable chemicals legislation.
- No liability for the type and use of the 3D printed products.
- If necessary, applicable laws and regulations must be observed.
- No guarantee for the function and durability of the 3D printed products.
- Use in the life science sector (as a medical device) is prohibited.

PACKAGING

REF 179002

1 Bottle @1 kg