

MOIIN High Temp

NOTES FOR USE

MOIIN High Temp 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 suitable for use in vat photopolymerization devices (e.g., DLP / SLA / LCD printers) operating at a wavelength of 405 nm or 385 nm.

RECOMMENDED USE IN PRINTERS

- Follow the printer instructions.
- Observe the machine and material parameters.
- Shake the material before use.
- Ensure clean working procedures. Residues on the machine can cause defects on the printed object.
- The object is not quite fully cured after printing (see "recommended post-processing").

RECOMMENDED POST-PROCESSING

- Carefully remove the printed object from the build platform. Carefully remove the reinforcing structures and supports (can also be performed after post-curing)
- Pre-clean the printed object with isopropanol ($\geq 99\%$) or ethanol ($\geq 96\%$) (max. 03:00 minutes, using an ultrasound bath or brush as necessary)
- Optional: Clean openings, holes and gap areas with compressed air.
- Clean the printed object for three minutes in a separate container using clean isopropanol ($\geq 99\%$) or ethanol ($\geq 96\%$) (if necessary, in an ultrasound bath).
- Before post-curing, all solvent and resin residues from the cleaning process should be removed. To ensure this, either clean the printed object using compressed air, let it dry completely in the air for 30:00 minutes or heat it in an oven at approx. 40°C (104°F).
- Mechanical post-processing of the objects can be carried out prior to post-curing. This will minimize the risk of fractures or damage that may occur during machined processing.
- Light-cure 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 the quality of the printed object.
- 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 the 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 °C – 25 °C / 59 °F – 77 °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 the applicable chemicals legislation.
- No liability for the type and use of the 3D printed products.
- If relevant, 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 not permitted.

PACKAGING

REF 179010

1 Bottle @ 1 kg