MOIIN Easy Cast

NOTES FOR USE

MOIIN Easy Cast is a (meth-)acrylate-based light-curing casting resin for the fabrication of burnout objects for casting processes (e.g., casting jewellery).

PRINTING

MOIIN Easy Cast is suitable for use in tray polymerization devices (e.g., DLP/ SLA/ LCD printers) operating at a wavelength of 405 nm or 385 nm.
The recommended temperature range is 20°C to 35°C. You can find details about the printer parameters and starting values for exposure times at:
https://www.moiin-resins.de/technische-daten/

Wavelength	Intensity	Critical energy Ec	Penetration depth Dp
405 nm	10 mW/cm²	5.5 mJ/cm²	0.19 mm
385 nm	6.4 mW/cm²	3.8 mJ/cm²	0.13 mm

CLEANING

Cleaning is important to remove all liquid resin residues from the object before the post-curing. Any suitable 3D printing cleaning agent can be used. We recommend isopropyl alcohol (IPA) or ethanol. The use of other cleaning agents may cause differences in the product properties. Ensure that the printed object is not in contact with the cleaning agent for too long (less than 5 minutes). Moreover, the printed object should be completely dried before post-curing.

Cleaning step		
1. Cleaning	IPA or Ethanol	Ultrasound or agitator
2. Cleaning	IPA or Ethanol	Ultrasound or agitator
Optional	IPA or Ethanol	Spray with a spray bottle
Dry	Compressed air or allow to air-dry for at least 30 min.	

POST-CURING

The printed objects must be post-cured to achieve the specified material properties. Either UV LEDs with wavelengths between 365 nm and 415 nm or lamps with a large wavelength range should be used for this purpose.

Post-curing device	UV light source	Light-curing time	Additional settings
Anycubic Wash & Cure	UV-LED (405 nm)	2 x 5 min	
RS cure	UV-LED (415 and 365 nm)	8 min	170% Upper & Lower Wavelength, 50 mbar

Post-curing device	UV light source	Light-curing time	Additional settings
NK-Optik Otoflash	Flash lamp with large wavelength range	2 x 2,000 flashes	
Heraeus Heraflash	Flash lamp with large wavelength range	2 x 180 s	
Kulzer HiLitePower3D	Flash lamp with large wavelength range	2 x 180 s	

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.

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) and 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.

PACKAGING

REF 179035 1 Bottle @ 1 kg