

High Clear Resin

iF3124

Suitable for transparent parts

Linear shrinkage and volume reduction, high surface accuracy,
good dimensional stability.



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iF3121 Resin Material Properties Data

project	content	Data value	testing method
Physical and chemical properties (before curing)	colour	clear	
	viscosity	320-340mPa·s(@25°C)	ASTM D1084
	density	1.2±0.05g/cm ³	ASM D1875
Physical and chemical properties (after curing)	Gloss retention rate	QUV2000h, 80%, b=1.0	
	shrinkage	≤1%	
	hardness(D)	72D	ASTM D2240
	elongation at break	12-15%	
	tensile strength	40~45MPa	
	bending strength	35-40MPa	
	high impact strength	80kj/m ²	
	Temperature resistance	65°C	

Remark:

1. The printing accuracy of the coordination degree with the printer is 0.5%-1%. The exposure time should be matched according to the light intensity of the machine to avoid over-exposure. Otherwise, the accuracy will decrease and the material will become yellow due to accelerated aging.
2. Good transparency, long light retention time
3. The main raw materials are safe and environment-friendly materials suitable for long-term use in hospitals with little irritation to human skin.
4. Linear shrinkage and volume reduction, high surface accuracy, good dimensional stability.
5. To increase transparency, it is recommended to spray UV varnish on the surface of the printed model.
6. After cleaning, please strictly control the time of post-curing, too long post-curing time will lead to material aging and yellowing.
7. Low smell, less skin irritation.

Light source intensity comparison

Machine type	DLP	L4K Pro	CREALITY	ANYCUBIC (2k)
Relative light intensity	5	1	0.6	0.4

Print parameter recommendation form

Material model	Material Colour	Recommended thickness	Light source wavelength
iF3124	clear	0.05mm	405nm

machine	Bottom exposure	Normal layer exposure	Top support diameter	Support diameter
LCD(4K Mono)	60s	3.5 (4~5)s	0.6~0.8mm	0.8~1.2mm
Anycubic mono X	35s	2 (1.5~2)s	0.6~0.8mm	0.8~1.2mm
DLP	5s	1.5(1.5~3)s	0.6~0.8mm	0.8~1.2mm

Support density	Support angle	post-curing time (30W power)
50%	45%	20~30s