

Water Washable Resin

# iF3125

Compatible to most LCD printers

Excellent toughness, not easy to break;  
Easy to clean, only wash by water



---

Updated date 2021.04.20

## iF3125 Resin Material Properties Data

project	content	Data value	testing method
Physical and chemical properties (before curing)	colour	white	
	viscosity	200-400cps(@25°C)	ASTM D1084
	density	1.08g/cm <sup>3</sup>	ASM D1875
Physical and chemical properties (after curing)	critical exposure	6~13mj/cm <sup>3</sup>	
	linear shrinkage	< 1.5%	
	hardness(D)	76D	ASTM D2240
	elongation at break	< 10%	
	elongation strength	60~80MPa	
	bending strength	> 60MPa	
	high impact strength	> 10kj/m <sup>2</sup>	
	thermal deformation	80~90°C	

### Remark:

Water-based resin can be directly washed with water, such as the model hollow, need to clean the hollow to prevent resin reaction, causing the model cracking.

## 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
iF3125	white	0.05mm	405nm

machine	Bottom exposure	Normal layer exposure	Top support diameter	Support diameter
LCD(4K Mono)	60s	4 (3~5)s	0.6~0.8mm	0.8~1.2mm
Anycubic mono X	35s	3 (2-4)s	0.6~0.8mm	0.8~1.2mm
DLP	5s	2.5(2~4)s	0.6~0.8mm	0.8~1.2mm

Support density	Support angle	post-curing time (30W power)
50%	45%	2 min

