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RI RESIONE F80-CA-P

RESIONE F80 Elastic 3D Printer Resin User Manual

Brand: RI RESIONE | Model: F80 Elastic Resin

1. Product Overview

The RESIONE F80 Elastic 405nm UV-Curing 3D Printer Resin is engineered for producing highly elastic and resilient 3D prints. This photopolymer resin offers high elongation at break, excellent resilience, and a soft touch with a Shore hardness of 50-60A. It maintains its flexibility even in low temperatures (below 10°C) and is broadly compatible with mainstream LCD, MSLA, and DLP 3D printers.



Figure 1: RESIONE F80 Elastic Resin and example elastic prints.

2. Safety Information

Attention!

If the resin is not to be used within 1 day, please pour it into a clean, light-shielded container and keep it tightly sealed. Do not mix printed resin liquid with unused resin to avoid contamination of new resin.

Precautions for Use:

- Operating temperature: 20~35℃ (68℉~95℉).
- Shake well before each use. If the resin is very viscous, preheat the bottle with 80℃ warm water before shaking it.
- Always wear nitrile rubber gloves during operation and ensure the operating environment is well ventilated.
- Do not use resin near windows, balconies, or other strong ultraviolet environments.
- If resin accidentally gets into your eyes, mouth, or nose, rinse immediately with plenty of water and consult a doctor.

- Resin remaining on the skin can be washed with soap, hand sanitizer, etc.

3. Setup and Preparation

Before beginning any printing process, ensure your workspace is clean, well-ventilated, and at the recommended temperature range of 20-35°C. Prepare your 3D printer according to its manufacturer's instructions.

Resin Preparation:

- Shake the resin bottle thoroughly before pouring to ensure all components are well mixed.
- If the resin is particularly viscous, gently warm the sealed bottle in 80°C water to improve flow before shaking.
- Pour the required amount of F80 Elastic Resin into your printer's resin vat.



Figure 2: F80 Elastic Resin is compatible with various LCD/MSLA/DLP 3D printers.

4. Operating Instructions

RESIONE F80 Elastic Resin is designed for high-performance elastic prints. Optimal results are achieved by understanding its unique properties and adjusting printer settings accordingly.

Key Characteristics:

- **Soft Touch:** F80 resin prints have a Shore hardness of 50-60A, providing a soft and elastic feel.
- **Good Resilience:** Prints exhibit excellent resilience, quickly recovering their original shape after deformation.
- **Low Temperature Resistance:** Even in cold conditions below 10°C, F80 prints remain soft, though elasticity may slightly decrease.
- **Broad Adaptability:** Suitable for all mainstream LCD/MSLA/DLP 3D printers, including RGB or Mono screen printers.



Figure 3: Demonstration of F80's soft touch and elasticity.



Figure 4: F80 prints exhibit excellent resilience.



Figure 5: F80 maintains softness even at low temperatures.

Printer Settings:

Refer to the official RESIONE website or the included User Guide PDF for recommended exposure settings specific to your 3D printer model. Due to the unique properties of elastic resins, initial calibration and test prints are highly recommended to achieve optimal results.

5. Maintenance and Disposal

Waste Liquid Disposal:

- If the resin is no longer needed, pour it into a transparent container (a small amount at a time), then place it in direct sunlight to completely cure it. Once solidified, it can be disposed of as solid waste according to local regulations.
- Do not discharge cleaning fluid containing resin directly into the sewer. Place the cleaning solution in sunlight until the resin inside is completely solidified and precipitated. Filter out the solid residue, and the filtered cleaning solution can be reused or disposed of responsibly.

Storage:

- Store in a sealed, shading, and cool place.
- Keep away from fire.
- Keep out of reach of children.
- If you do not need to use the resin within 1 day, please pour it into a clean, light-shielded container and keep it tightly sealed. Do not mix the printed resin liquid with the unused resin to avoid contamination of the new resin.

6. Troubleshooting

While RESIONE F80 Elastic Resin is designed for reliability, issues can occasionally arise. Here are some common troubleshooting tips:

- **Print Failures (Parts not sticking/incomplete):** Ensure proper build plate leveling and adequate bottom exposure time. Verify the resin temperature is within the recommended 20-35°C range. Increase bottom layer exposure time or number of bottom layers if adhesion is an issue.
- **Excessive Stickiness/Difficulty Cleaning:** F80 resin is inherently sticky due to its elastic properties. Use sufficient IPA (99%) for cleaning and consider using a soft brush for intricate details. Ensure prints are fully cured after washing.
- **Strong Odor/Eye Irritation:** Always operate in a well-ventilated area. Use personal protective equipment (gloves, safety glasses, respirator if necessary). If irritation persists, consult a medical professional.
- **Prints Not Flexible Enough:** Verify your exposure settings match the manufacturer's recommendations for your specific printer. Ensure post-curing is not excessive, as over-curing can sometimes reduce flexibility.

For more detailed troubleshooting or specific printer profiles, please refer to the official RESIONE website or contact customer support.

7. Specifications

Attribute	Value
Brand	RI RESIONE
Model Number	F80-CA-P
Color	Black
Material Type	Resin
Item Weight	1 Kilogram (2.2 pounds)
Curing Wavelength	405nm UV
Shore Hardness	50-60A
Operating Temperature	20-35°C (68-95°F)

8. Warranty and Support

For detailed warranty information and technical support, please refer to the official RESIONE website or contact their customer service directly. A comprehensive User Guide PDF is also available for download:

Download Official User Guide (PDF)

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