

TH72 Resin Instruction

1. The Product Description

TH72 is a long-term tough resin, so you don't have to be careful when you play with prints, and it will not be easily damaged during long distance transportation. It is an ideal material for printing hair, capes, swords, etc., as well as static figures and models with hollow interiors, it can also be used as a toughening agent for other resins.

2. Material Properties Data

	METHOD	TH72-DATA
Viscosity (25℃)	ASTM:D4212-10	618mpa.s
Shore Hardness	ASTM:D2240-05	74-78D
Tensile Strength	ASTM: D638-14	23MPa
Elongation at Break	ASTM: D638-14	25.40%
Elongation at Yield	ASTM: D638-14	9.60%
Notched IZOD	ASTM:D256-10	18J/m
Water Absorption (48hr)	ASTM:D570	0.60%

3. Printing

Support setting:TH72 resin is not rigid enough when printing.The model with thin and less support was successfully printed with resins with good rigidity (such as standard resin, rigid resin, ABS resin, etc.), but it might will failed to print with TH72 resin instead. It's recommended when printing with TH72 resin after the following treatment: a) Add more supports at the island of the model; b) The higher the supports, the larger the middle diameter; c) The heavier the model, the thicker the supports.

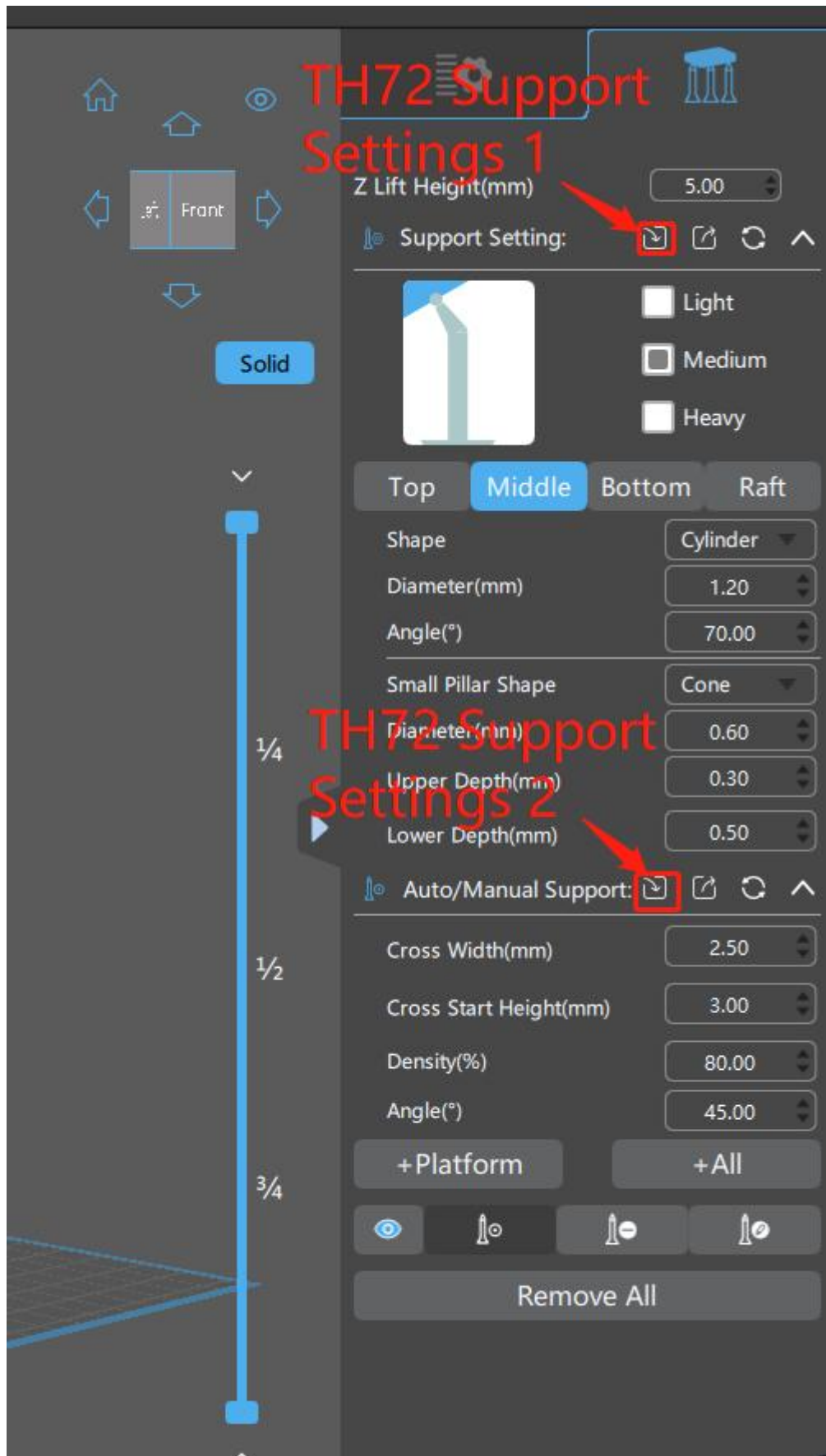
In addition, the following is the TH72 resin Support Settings recommended by RESIONE , which can be used for normal models after importing the Support Settings using the Chitubox slicer as instructed in the following figure. (There are two support Settings files in the zip package)



TH72 Support Settings 2.cfg



TH72 Support Settings 1.cfg



Printing Settings: You can download the resin printing parameters from RESIONE's official website. The detailed operations are as follows: RESIONE's official website —>Support —>Settings

4. Cleaning and Post-curing

Cleaning: You can use ultrasonic or 3D printing special cleaning machine with the ethanol(concentration $\geq 95\%$), or IPA. Cleaning time: ≤ 5 mins. Please use compressed air to dry the prints after cleaning it.

Post-curing: If you use a post-curing box with a power of 40W, our recommended post-curing time is about 30mins-60mins (Adjust the post-curing time according to the power of the post-curing box, the greater the power, the shorter the time).



Attentions:

- For some types of 3d printers, the surface of the printed TH72 resin parts has a silky texture, and the prints will feel slightly sticky after cleaning.
- The resin prints will be fragile after post-curing. It is not recommended to apply force to the prints immediately. Just need to wait for a while until the internal stress of the prints is completely released.