

MOIIN Wax Cast

NOTES FOR USE

MOIIN Wax Cast Resin is a light-curing (meth)acrylate-based resin for the production of residue-free burn-out objects using 3D printing (e.g. rings for jewelry production). The material is only suitable for use in tray polymerization devices (e.g., DLP / SLA printers) operating at a wavelength of 405 nm or 385 nm.

RECOMMENDED USE IN THE PRINTER

- Follow the printer instructions.
- Observe the machine and material parameters.
- Maintain the processing temperature of the material at 20 °C - 35 °C (68 °F - 95 °F).
- Shake material for at least 1 min prior to use and do not leave in the tray after printing.
- Ensure clean working procedures. Residues on the machine can cause defects on the printed object.
- Finishing should take place immediately after the construction process where possible.
- The object is not fully cured after printing (see "recommended post-processing").

RECOMMENDED POST-PROCESSING

- Loosen the printed object from the building plate. Carefully loosen the supporting structures and other supports.
- Optional: Pre-clean the printed object for 03:00 min using ethanol (approx. 96%) and a brush.
- Optional: Clean openings, holes and gap areas for 02:00 min with compressed air.
- Clean the printed object for 03:00 min in a separate container using fresh ethanol (if necessary in an ultrasonic cleaner).
- Optional: Heat the printed object up to approx. 40 °C (104 °F) for 30 min in an oven to remove any solvent residues remaining from the cleaning process.
- Burn the printed object. Observe the manufacturer's instructions for the light-curing unit.
- Examples of post-curing devices and light-curing times:

Otoflash	2 x 2,000 flashes
Kulzer HiLitePower3D	2 x 180 s
Heraeus Heraflash	2 x 180 s

If other post-curing devices are used, the post-curing time should be adjusted accordingly

- Process the surface if necessary.
- Burnout: Please observe the manufacturer's instructions for the embedding compound used. The temperature profiles have to be established by individual test series according to the size of the embedded objects, so that the material burns out completely.

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. Irritates the eyes and skin (sensitization possible).
- Wear safety gloves (nitrile gloves), protective clothing and safety goggles while processing.
- Avoid eye contact! In the event of the liquid material accidentally coming into contact with the eyes, immediately rinse eyes thoroughly with plenty of water and consult a doctor if necessary.
- Avoid skin contact with non-polymerized material and the inhalation of monomer vapors. In rare cases, allergic reactions to components in the material may occur. If this occurs, consult a doctor.

COMPOSITION

Mixture of acrylate and methacrylate resins, photoinitiators, colorants and additives.

STORAGE

- Store in a dry place at room temperature (15 °C - 25 °C / 59 °F - 77 °F) 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.
- Use in the life science sector (as a medical device) is prohibited.

PACKAGING

REF 179003

1 Bottle @1 kg