

MSLA Castable – Cyan (MSP-C001CN)

Check

- Vat and LCD screen are clean
- Shake well (60 sec) before pouring
- Vat and platform are tightened properly

Setting Recommendation Chart

MSLA Castable

Recommended Setting Parameters
(50 um layer thickness for fine structure)

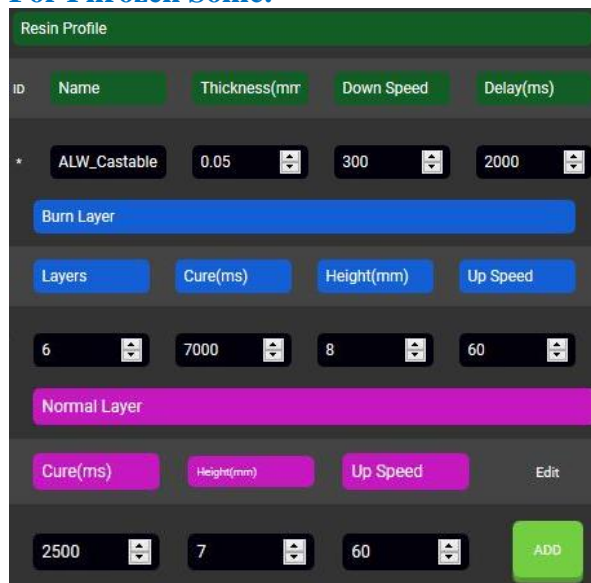
Printer	Normal Layer Time (sec)	Bottom (Burn-In) Layers	Bottom (Burn-In) Time (sec)	Lifting Speed (mm/min)
Shuffle	12	6	40	60
Shuffle XL	12	6	40	60
Sonic	2.5	6	7	60
Sonic mini	5	6	15	60
MiiCraft	1.2	6	4	slow

Each printer is unique, light intensity varies from printer to printer even though they are the same model and make. Please adjust normal exposure time from our recommended settings ± 3 (± 0.5 for sonic) seconds for your printer and print geometry.

For size calibration, download the stl file:
<https://www.thingiverse.com/thing:1586206>

Setting Example:

For Phrozen Sonic:



For Phrozen Sonic Mini:

Layer Height:	0.05	mm
Bottom Layer Count:	6	
Exposure Time:	5	s
Bottom Exposure Time:	15	s
Light-off Delay:	3	s
Bottom Light-off Delay:	6	s
Bottom Lift Distance:	6	mm
Lifting Distance:	8	mm
Bottom Lift Speed:	60	mm/min
Lifting Speed:	60	mm/min
Retract Speed:	300	mm/min

Washing

Fresh IPA rinse (95+% concentration) over prints. Do NOT submerge prints in IPA. Blow dry via compressor air immediately after rinse and set print in a shaded airy place to fully dry before casting (approx 60 mins). **Limit IPA contact time to 30 seconds as prolong contact time could cause print deformation.**

Color migration (leaking color from prints) of prints are normal.

No Post-Curing Needed

Storage

Do Not store resin in the vat for more than **2 days** when not in use. Filter out all debris in case of failed prints.

Note: Slight pigment settlement is normal. Gently mix remaining resin in resin vat with soft wiper for color evenness.

Product Features

Low shrinkage (Storage at 25°C for 1 week, <1 vol%)

Low ash

Low expansion during burnout

No need for UV post-curing

No need for dip or spray

Compatible with gypsum-bonded investment (R&R Ultravest, Omega+ or other similar investments)

Burnout Cycle

Follow the burnout cycle of your investment manufacturer, or the cycle we recommend below and make modifications according to your burnout equipment.

Ideal Max. Temp: 750~800°C (ensure the investment is able to withstand 800°C)

