



Printer compatibility 405nm (UV)



MATERIAL PROCESSING GUIDE - SUPERWAX

Material may solidify at room temperature. This is not a fault with the material.. To return resin to liquid follow the steps below.

HANDLING / SAFETY / STORAGE

Wear disposable nitrile gloves at all times when handling liquid resin.

Avoid contact with skin. If contact with skin occurs wash thoroughly with cold soapy water.

If contact with eyes occur seek immediate medical assistance.

Storage on printer for up to 4 weeks with hood closed. Store in bottle for up to 12 months in a cool dark place.

INI FILE

Ensure you are using the latest material ini file. You can access the latest material ini file for this material in your Asiga account online here: https://www.asiga.com/accounts/#tab_material

WARMING RESIN

Material may be solid at room temperature so it is important to warm material prior to printing.

Activate the heater on printer. Settings > Temperature > Controller ON. Change Setpoint to 35°C.

- Warm Bottle in Water bath

Place bottle in a bowl of warm water below 60°C until material has returned to liquid. Ensure lid on bottle is tight. Once liquid, pour into Build Tray and place Build Tray inside preheated printer. Allow 30 minutes for temperature of material to stabilize.

- Warm Bottle in Oven

Loosen lid on bottle and place in preheated oven set to 60°C for 15-20 minutes or until liquid. Once liquid, pour into Build Tray and place Build Tray inside preheated printer. Allow 30 minutes for temperature of material to stabilize.

- Warm Build Tray in Printer

Place Build Tray inside preheated printer and allow 60 minutes for material to return to liquid.

PRINTING

After warming the material using any of the options above it is important to allow the material to stabilize to the printer temperature. Wait 30 minutes before starting the print. Stir material well with a spatula prior to printing to verify material is liquid.

Ensure film on the Build Tray is clear of any debris before starting the next print.

WASHING

Rinse parts thoroughly under running water. Ensure water temperature is approximately 35° Celcius. Allow parts to dry thoroughly after washing - NO POST CURING NECESSARY.

INVESTMENT CASTING

1. Use a standard gypsum bonded investment
2. Use a standard phosphate bonded investment



IRRITANT

For MSDS or technical assistance open a support ticket in your account online. <https://www.asiga.com/accounts/support/>