



Siraya Tech

Technical Data Sheet

Siraya Tech Build

High Resolution Resin

Sonic Grey/ Smoky Black



Product Introduction

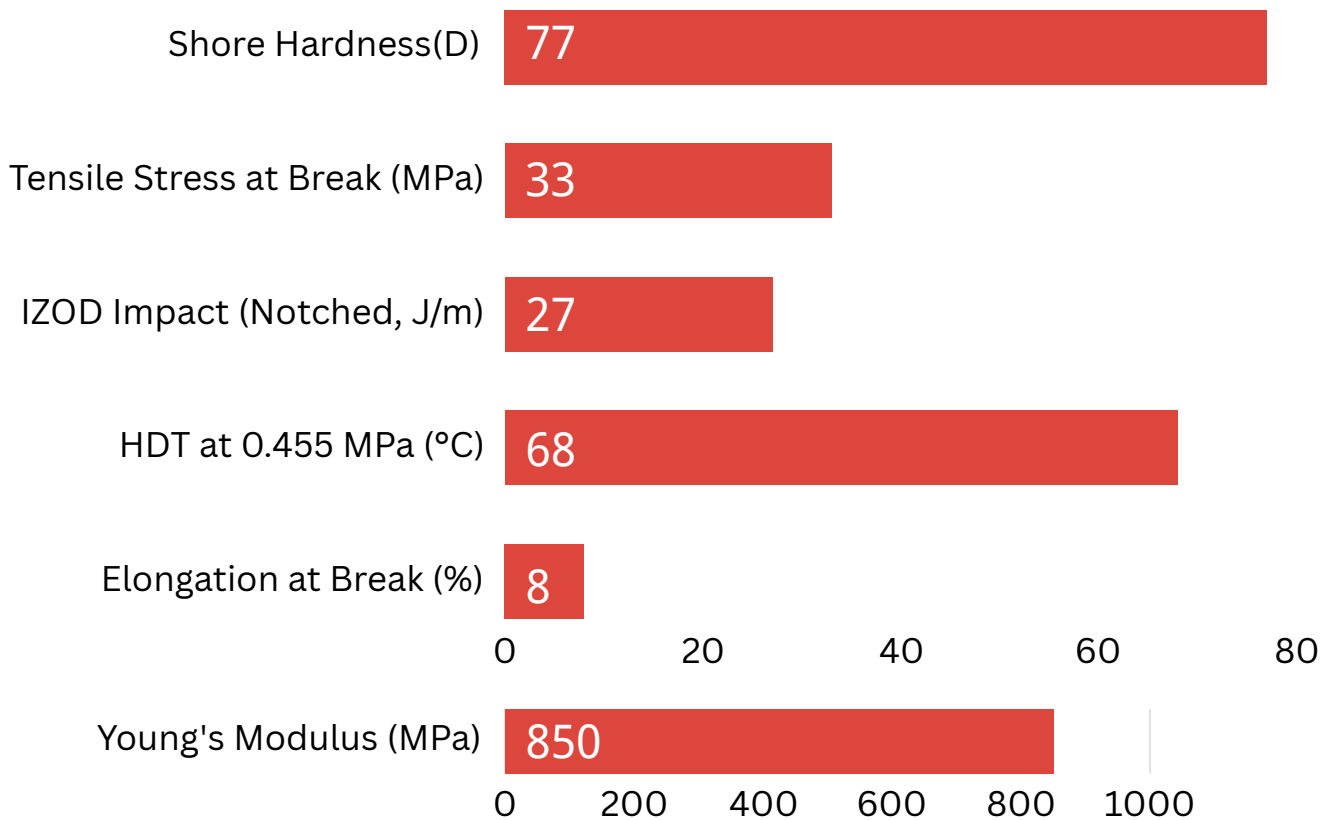
Build High Resolution Resin

Key Features

- It has High resolution and easy-to-tap threaded holes
- Low shrinkage and warping compared to common model resins
- Hardness and flexibility, not brittle and low odor
- Rapid UV-curing resin with good fluidity. Ideal for desktop miniatures
- It is easy to clean and cure, and process

Application:

- Assembly parts and fitted models
- Trains and other models that require high precision and accuracy
- Functional parts, especially mixed with Blu
- Printing masters for molding making



Property Data

Mechanical Properties	Measure	Method	Post Processed
Tensile Stress at Yield	35	ASTM D638	-
Tensile Stress at Break	33	ASTM D638	-
Young's Modulus	850	ASTM D638	-
Elongation at Break	8	ASTM D638	-
Flexural Modulus	1450	ASTM D790	-
Flexural Stress at Yield	-	ASTM D790	-
Flexural Strain at Break	-	ASTM D790	-

Other Properties	Measure	Method	Post Processed
HDT at 0.455 MPa	68	0.455 MPa	-
IZOD Impact (Notched) J	27	-	-
Shore Hardness	77D	-	-
Solid Density	1.2	-	-
Water Absorption (24hr)	2%	-	-
Biocompatibility	Not tested	-	-

Liquid Properties	Measure	Method	Post Processed
Viscosity at 25°C (77°F)	110	25°C (77°F)	-
Liquid Density	1.1	-	-

Work Flow

Printing

Build is a precise, high-resolution non-brittle, low-shrinkage resin material that is widely compatible with DLP/LCD 3D printers. Compared with other resins that are too brittle, this Build 3D printer resin is strong enough to withstand accidental drops from time to time.

To achieve optimal results with Build resin, you need to use the appropriate slicer profiles for your printer model and software. You can download the slicer profiles for Chitubox and Lychee slicers from this link: <https://siraya.tech/pages/print-settings-download>

Clean

Here are some tips for cleaning your printed parts:

- Use a painter brush (or any brush made with hair) to remove excess resins on the printed part.
- Use 95% concentrated Ethanol (preferred) or IPA to clean. Some form of methanol should work but make sure it does not contain acetone.
- Do not submerge the parts in alcohol for more than 5 minutes.
- After cleaning, remove alcohol as soon as possible with a hair dryer or air blower. For complex parts with lots of cavities, it may be a good idea to clean/dry multiple times.
- You can check by touching the dried surface of the part to see if it is still sticky. If the dried surface is still sticky, wash some more and dry again.

Post Curing

Here are some tips for post-curing your printed parts:

- Post-cure printed parts made with Build resin for optimal strength using 395-405nm UV light for 1-2 minutes after cleaning.
- Ensure complete cleaning and drying of the resin print before curing to avoid any remaining alcohol.
- Dry the Build resin print entirely before post-curing and avoid using the "submerge in water" technique.