MOIIN Model Grey 2.0

NOTES FOR USE

MOIIN Model Grey 2.0 Resin is a (meth)acrylate-based light-curing resin for the production of technical objects (e.g. for rapid prototyping) using 3D printing.
The material is suitable for use in tray polymerization devices (e.g., DLP / SLA printers) operating at a wavelength of 405 nm or 385 nm.
For LCD printers with a wavelength of 405 nm and a low light intensity (e.g. 2 mW/cm² or less), there may be a reduction in the printing accuracy and detail reproduction that can be achieved.

RECOMMENDED USE IN PRINTERS

- Follow the printer instructions.
- Observe the machine and material parameters.
- Maintain the processing temperature of the material at 23- 32 °C (73- 89.6 °F).
- Shake the material for at least 01:00 min before use.
- With longer printing processes, the components of the material may separate. If required, mix the material again.
- Ensure clean working procedures. Residues on the machine can cause defects on the printed object.
- The object is not quite fully cured after printing (see "recommended post-processing").

RECOMMENDED POST-PROCESSING

- Carefully remove the printed object from the build platform. 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).
- Dry the printed object (e.g. with compressed air, at 40 °C in an oven or for about 30:00 min at room temperature).
- Light-cure 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.

- If necessary, prepare the surface as usual.

SAFETY INSTRUCTIONS

- Using the device incorrectly and failing to observe the specifications may place the user at risk or impair the quality of the printed object.
- 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 the 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 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 the applicable chemicals legislation.
- No liability for the type and use of the 3D printed products.
- If relevant, 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 not permitted.

PACKAGING

REF 179006 1 Bottle @ 1 kg