

D01 D01S Dental Model Resin Instruction

1. The Product Description

D01 is a yellow-orange high-precision dental model resin. This resin produces prints with high tolerances, as well as smooth and wear-resistant surfaces. Moreover, it can withstand high temperatures for short periods during the vacuum molding process. It's an ideal material for printing dental models for restoration, implant, study, and orthodontic purposes. Additionally, the prints are very easy to clean, making it a very convenient option.

D01S is a seashell-colored dental model resin that incorporates unique inorganic fillers for enhanced performance. The printed dental models exhibit a matte surface with a plaster texture, ensuring precise scanning results. In addition, the resin material boasts accurate size, a wear-resistant surface, extremely low shrinkage rate, and long-lasting stability, making it ideal for printing high-quality restoration, plant, and study dental models. With D01S, you can create dental models with confidence and precision.

2. Material Properties Data

	METHOD	D01-DATA	D01S-DATA
Viscosity (25°C)	ASTM:D4212-10	300mpa.s	1100mpa.s
Shore Hardness	ASTM:D2240-05	85-90D	92D
Tensile Strength	ASTM: D638-14	27MPa	20MPa
Flexural Strength	ASTM: D790-10	39MPa	39MPa
Elongation at Break	ASTM: D638-14	12%	5%
Notched IZOD	ASTM:D256-10	14J/m	7.9J/m

3. Printing

1.If the dental model is hollow and no support is added at the bottom, it is necessary to punch holes near the bottom of the model (as shown in the figure below) to prevent the formation of a "vacuum sucker" and cause printing failure;



2. You can download the resin printing parameters from RESIONE's official website. The detailed operations are as follows: RESIONE's official website →Support→Settings

3. If the print is difficult to shovel off the build plate or is shattered, the exposure time of the bottom layer can be reduced to reduce the adhesion of the print to the metal plate

4. Cleaning and Post-curing

Cleaning: You can use the ethanol (concentration $\geq 95\%$), or IPA to clean. D01 resin printing is recommended to be cleaned and soaked within 10min, while D01S resin prints are recommended to be cleaned with a toothbrush. After cleaning, use compressed air to dry the prints.

(Why does D01S resin need to be cleaned with a toothbrush? Because some printers have an anti-aliasing effect, it is easy to produce a layer of incompletely cured resin on the surface of the print, which makes it difficult to clean and easily cause the surface of the D01S print to become white.)

Post-curing: After cleaning and drying, the print can not be cured immediately, which will make the surface of the print white. It is recommended to place it for half an hour after drying with compressed air and wait for the solvent on the surface of the model to evaporate before post-curing. If you use a post-curing box with a power of 40W, our recommended post-curing time is about 20min*2 (Adjust the post-curing time according to the power of the post-curing box, the greater the power, the shorter the time). So you can get a dry surface print.

Both the front and back of the dental model need to be post-cured to prevent the print from shrinking and deforming



Attentions:

- Too long post-curing time will make the resin prints easy to warping, hard and brittle.
- The resin prints will be fragile after post-curing. It is not recommended to apply force to the prints immediately. Just need to wait for a while until the internal stress of the prints is completely released.

For more questions, please contact support@godsaid3d.com