

LITLIQ FX60 Resin Instruction

1. The Product Description

LITLIQ FX60 resin is a black flexible resin. One of the most significant advantages of FX60 is its fluidity, which allows for faster printing and clearer details. It also maintains its flexibility and elasticity in cold temperatures and has a high printing success rate.

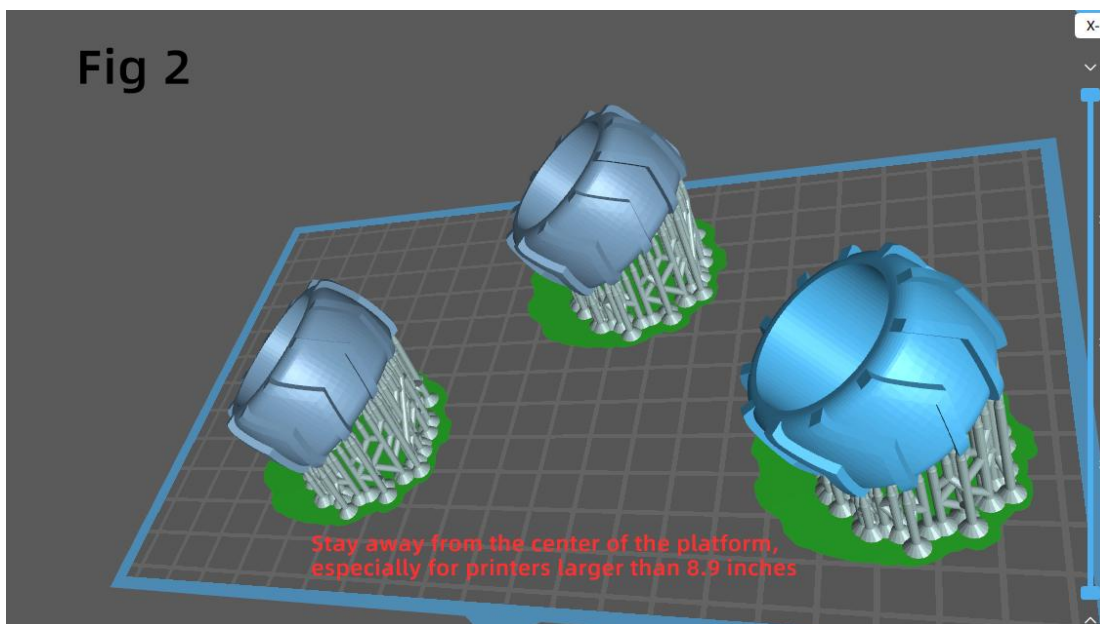
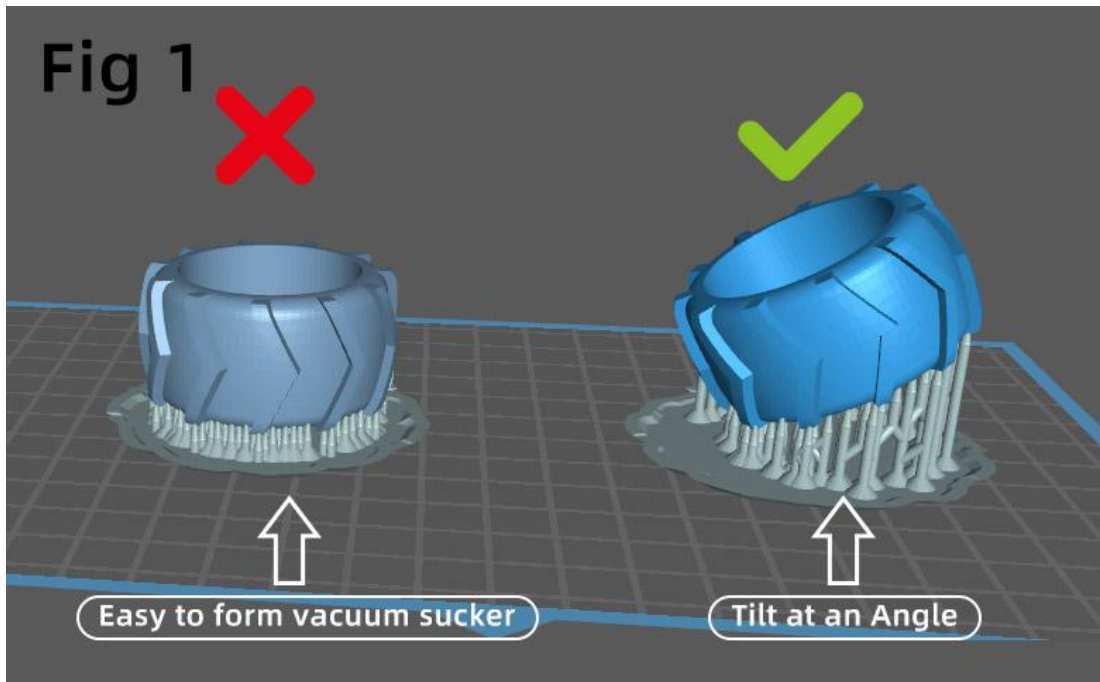
2. Material Properties Data

	METHOD	FX60 DATA
Shore Hardness	ASTM:D2240-05	58-62A
Tear strength	ASMT:D624-98	12.75KN/m
Tensile Strength	ASTM: D412-06	5.2MPa
Elongation at Break	ASTM: D412-06	142%
Viscosity (25°C)	ASTM:D4212-10	568mpa.s

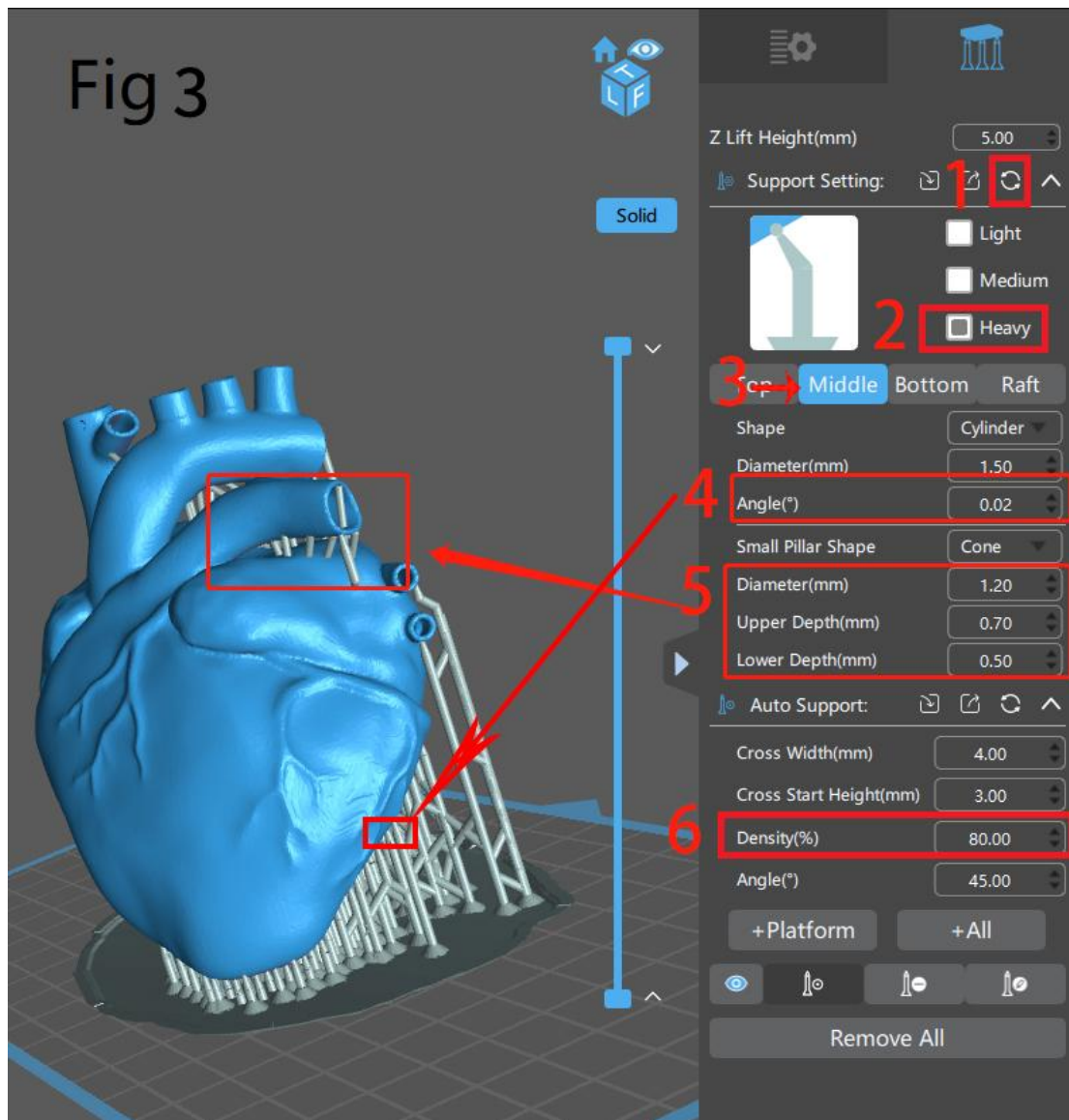
3. Printing

Because the soft resin prints are easy to be stretched and deformed when they are separated from the FEP film during printing. Please following below steps in order to improve the success rate of printing.

I. **Model Location:** Please don't place the model in the middle of the build plate. Because FX60 resin is soft resin with slightly higher viscosity.(Fig2).The model should be placed at a certain Angle to avoid a vacuum sucker. (Fig1)



II. **Supports Settings:** Please use heavy and massive support (Density: 80%-95%), vertical supports (Angle: 0°).The supports in the middle of the model also need to be thick.(Figure 3).A thin raft or none raft are much better considering easy remove the prints from the build plate,because FX60 resin are very tightly stick to the build plate.



III. **Printing Settings:** You can download the resin printing parameters from RESIONE's official website. The detailed operations are as follows: RESIONE's official website —>Support —>Settings

The slow Lifting Speed is required to ensure that the model will not stretched and deformed; High Lifting Distance ensures that the printing piece is completely separated from the FEP film; Long Rest Time After Retract ensures the resin fully backflow.

4. Cleaning and Post-curing

Cleaning: Cleaning with the ethanol (concentration $\geq 95\%$), or IPA. Cleaning and soaking time: ≤ 3 mins. It is **not** recommended to brush the prints with a toothbrush. Please use compressed air to dry the prints after cleaning it. It is a normal phenomenon if there are a little sticky hand feeling.

Post-curing: If you use a post-curing box with a power of 40W, our recommended post-curing time is about 10-20mins (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.



Attentions:

- a. Too long post-curing time will make the resin prints easy to warping, hard and brittle.
- b. 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.

5.Use and Save

- a. Add the needed resin liquid when printing. To avoid moisture absorption of resin, please filter the remaining resin as soon as possible and pour it into a new light-proof container for sealing and preservation after printing.
- b. If the FX60 print has been hung on the platform for more than 12 hours after printing, it will absorb moisture and expand. After this happens, the print will break easily during cleaning. It is recommended to perform post-processing in time after printing. The expanded print can be carefully cleaned and blown dry, and will return to its normal size after being left for a while.
- c. The prints can maintain normal performance at 25-35°C, and they will become hard and brittle at low ambient temperature like traditional plastics. Flexible resin prints show more obvious, FX60 can maintain good flexibility at low temperature, but it will feel stiffer than normal temperature.
- d. In order to make the flexible resin prints maintain good flexibility for a long time. It is recommended that save the prints in sealed bags or apply a layer of soft waterproof coating.

For more questions, please contact support@godsaid3d.com