

HT100 Heat-resistant Resin Instruction

1. The Product Description

HT100 is a heat-resistant resin with a heat distortion temperature of 98°C. Prints using HT100 have extremely high hardness, bending strength and tensile strength. It's resistant to long-term boiling and chemical agents. HT100 is primarily used for pressing silicone rubber molds or making injection molds.

2. Material Properties Data

	METHOD	DATA
Viscosity (26°C)	ASTM:D4212-10	560mpa.s
Shore Hardness	ASTM:D2240-05	90D
Flexural Strength	ASTM: D790-10	108MPa
Flexural Modulus	ASTM: D790-10	2880MPa
Tensile Strength	ASTM:D638-14	78MPa
Elongation at Break	ASTM: D638-14	2.20%
Notched IZOD	ASTM:D256-10	8J/m
HDT(0.455Mpa)	ASTM:D648-18	98°C

3. Printing

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

4. Cleaning and Post-curing

Cleaning: Cleaning with the ethanol(concentration $\geq 95\%$), or IPA. Cleaning and soaking time: ≤ 15 min. Please use compressed air to dry the prints after cleaning it.

Post-curing: If you use a post-curing box with a power of 40W, our recommended post-curing time is about 60mins (Adjust the post-curing time according to the power of the post-curing box, the greater the power, the shorter the time).

If there is a higher temperature resistance requirement, you can put the prints in boiling water for 10 minutes to make it solidify more fully.



5. Application Guide

a. Silicone Rubber Molds(As shown below)

艺辉牌双控制数显压模机压制硅胶模 ①		② 割胶、开胶模	
			
填充艺辉牌硅胶	填充艺辉牌硅胶	将压好的胶模泡水降温	割胶模
			
硫化硅胶	取出硫化好的胶模	割胶模	取出母模
③ 制做蜡模		④ 铸造	
			
自动真空注蜡机注蜡	取出蜡模(抽心)	种树(焊蜡树)	种树(焊蜡树)
			
得到完美蜡件	完美蜡件	完美铸件	完美铸件

b. Used as an injection mold for the following thermoplastics

Injection material	Mold temperature (°C)
PP	10~60
PS	10-80
ABS	50~80
PMMA	40-90
PC	80-120
PA66	40-120

c. Other Application

- Test in outdoor conditions or high temperature gas/liquid environment
- Carbon fiber mold
- Metallized surface treatment such as electroplating
- Automotive interior
- Heat-resistant parts of electrical or power equipment
- Fixture

For more questions, please contact support@godsaid3d.com