

iForm Cast03B

Specifically designed for jewelry casting

Color: Black

Wavelength: 405nm

- Low shrinkage ·Fine surface detail ·Easy to cast
- Low ash ·high strength and stiffness ·Suitable for casting gold,silver

Color	Black	/
Viscosity	180~280cps (25℃)	ASTM D1084
Density	1.076~1.1g/cm ³	ASTM D1875-69

Printing parameter settings

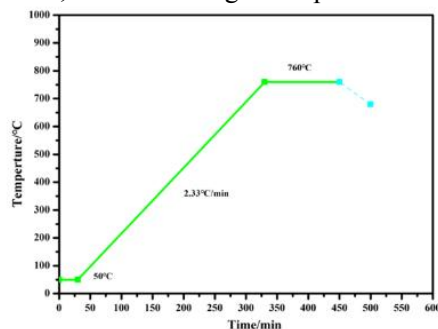
Layer height	Exposure time	Bottom exposure time	Film
0.05mm	3.5s~5.5s	15s~25s	ACF
Bottom Layer Count	Transition Layer Count	Rest Time After Lift	Rest Time After Retract
6	10	2s	2s

Washing and Post -Curing info

1. Wash Cast03B prints in alcohol(95%) for 5minutes
2. Wash again in alcohol(95%) for 5minutes
3. Put Cast03B prints and alcohol(95%) into the ultrasonic machine for 5minutes
4. Dry Cast03B prints
5. Curing in a high power UV curing box for 30mintues

Standard burnout schedule

The following burnout schedule is designed to help reduce thermal expansion of resin in the mold, while ensuring a complete burnout for thick jewelry parts.



PHASE	TIME	SCHEDULE °C
Hold	30mintues	50
Ramp	300mintues	2.33°C/min
Hold	120mintues	760°C
Casting Window	Desired casting temp	