

iForm Cast03WR

Specifically designed for jewelry casting

- Color: Red
- Wavelength: 405nm
- Low shrinkage
- Low ash
- Fine surface detail
- Easy to cast
- high strength and stiffness
- Suitable for casting gold,silver



Color	Red	/
Viscosity	250~350cps (25°C)	ASTM D1084
Density	1.06~1.1g/cm ³	ASTM D1875-69
Hardness	40D~50D	ASTM D2240

Printing parameter settings

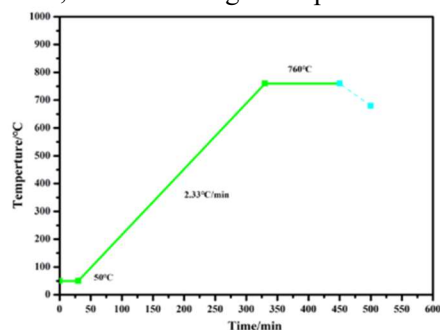
Layer height	Exposure time	Bottom exposure time	Film
0.05mm	5.5s~7.5s	30s~40s	NFEP/ACF
Bottom Layer Count	Transition Layer Count	Rest Time After Lift	Rest Time After Retract
6	10	2s	2s

Washing and Post -Curing info

1. Wash Cast03WR prints in alcohol(95%) for 5minutes
2. Wash again in alcohol(95%) for 5minutes
3. Put Cast03WR prints and alcohol(95%) into the ultrasonic machine for 5minutes
4. Dry Cast03WR 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	