

### Available Resins

**1** Pro Model Resin

**3** Temporary C&B; Resin

**5** Surgical Guide Resin

**7** Pro Model Resin Washable

**2** Pro Model Resin Plus

**4** Gingiva Mask Resin

**6** Pro Model Resin for Implant

### Printing Setting Table

| Resin Type                           | Layer Height (mm) | Bottom Exposure (s) | Normal Exposure (s) | Lift Height (mm) | Lifting Speed (mm/min) | Rest Time After Retract (s) |
|--------------------------------------|-------------------|---------------------|---------------------|------------------|------------------------|-----------------------------|
| Pro Model Resin                      | 0.05              | 35                  | 3                   | 6                | 120                    | 5                           |
| Pro Model Resin Plus                 | 0.065             | 35                  | 3.2                 | 6                | 120                    | 5                           |
| Pro Model Resin for Implant (Yellow) | 0.065             | 35                  | 3                   | 6                | 120                    | 2                           |
| Pro Model Resin Washable             | 0.05              | 35                  | 4.5                 | 6                | 90                     | 5                           |
| Temporary C&B; Resin                 | 0.65              | 30                  | 3.2                 | 6                | 120                    | 5                           |
| Gingiva Mask Resin                   | 0.05              | 17                  | 4                   | 6                | 70                     | 5                           |
| Surgical Guide Resin                 | 0.065             | 30                  | 2.5                 | 6                | 120                    | 5                           |

## Technical Specifications

| Test Item                    | Pro Model Resin | Pro Model Resin Plus | Temporary C&B; | Gingiva Mask | Surgical Guide |
|------------------------------|-----------------|----------------------|----------------|--------------|----------------|
| Viscosity (mPa·s)            | 222             | 259.3                | 419.4          | 84.91        | 542            |
| Density (g/cm <sup>3</sup> ) | 1.113           | 1.056                | 1.368          | 1.031        | 1.1            |
| Elongation at Break (%)      | —               | —                    | —              | ≥200         | —              |
| Flexural Strength (MPa)      | 50–60           | 74.5–78.5            | 83–90          | —            | 76–90          |
| Flexural Modulus (MPa)       | 900–1000        | 2148–2334            | 2107–2241      | —            | 2155–2508      |
| Hardness (Shore D)           | 87              | 84                   | 85             | 36           | 86             |

| Test Item                    | Pro Model Resin for Implant | Pro Model Resin Washable |
|------------------------------|-----------------------------|--------------------------|
| Viscosity (mPa·s)            | 259.3                       | 259.3                    |
| Density (g/cm <sup>3</sup> ) | 1.056                       | 1.036                    |
| Elongation at Break (%)      | —                           | —                        |
| Flexural Strength (MPa)      | 78.8–84.2                   | 68.5–76.5                |
| Flexural Modulus (MPa)       | 2389–2561                   | 1648–1842                |
| Hardness (Shore D)           | 88                          | 74                       |

## Cleaning and Post-Curing

- 1 Remove the printing platform from the printer.
- 2 Carefully detach prints from the platform using a scraper.
- 3 Submerge the workpiece in a container of alcohol, ensuring it is fully covered.
- 4 Place the container in an ultrasonic machine and clean for 1–2 minutes. Ensure alcohol is thoroughly removed; gloves may be used to assist.

**5** Remove prints and dry immediately using an air gun or blower.

**6** Place models in a curing machine. Curing time depends on the light power of the curing box.

### Suggested Curing Times

| Resin                                | Cure Time per Side |
|--------------------------------------|--------------------|
| Pro Model Resin                      | 1 minute           |
| Pro Model Resin Plus (Yellow)        | 3 minutes          |
| Pro Model Resin Plus (Grey)          | 1 minute           |
| Pro Model Resin for Implant (Yellow) | 3 minutes          |
| Pro Model Resin Washable             | 1 minute           |
| Temporary C&B;                       | 20 seconds         |
| Gingiva Mask                         | 30 seconds         |
| Surgical Guide                       | 1 minute           |

**Note:** If using a non-rotating curing lamp, cure both front and back sides (two cycles total). A 360° rotating lamp requires only a single cycle.

### Caution

- Wash hands and face thoroughly after handling.
- Wear protective gloves and mask when working with resin.
- If resin contacts eyes, immediately flush with plenty of water for at least 15 minutes. Seek medical advice if necessary.
- Dispose of waste water and materials in accordance with local environmental regulations.

### Storage

- Seal the product and store in a dry, well-ventilated room free of corrosive gases.
- Store at 25–30°C.
- Keep away from heat sources, moisture, and direct sunlight.
- Shelf life: Two years.

### Printing Parameters — Creality Halot-X1

| Photo                                                                              | Model                                | Layer Height | Exposure Time (s) | Rising Height (mm) | Motor Speed | Light-off Delay | Initial Exposure | Bottom Layers | Cushion Layer H. | Cushion Motor S | Cushion Turn off | Curing Time | Scale Advance             | Cleaning                |
|------------------------------------------------------------------------------------|--------------------------------------|--------------|-------------------|--------------------|-------------|-----------------|------------------|---------------|------------------|-----------------|------------------|-------------|---------------------------|-------------------------|
|    | Pro Model Resin Plus (Yellow)        | 0.05         | 3                 | 8                  | 300         | 4               | 30               | 4             | 5                | 120             | 6                | 3 min       | x:100<br>y:100<br>z:100   | 95% Alcohol / Isopropyl |
|    | Pro Model Resin                      | 0.05         | 2.5               | 8                  | 300         | 4               | 30               | 3             | 5                | 120             | 6                | 1 min       | x:100<br>y:100<br>z:100   | 95% Alcohol / Isopropyl |
|  | Pro Model Resin Washable             | 0.05         | 3.5               | 8                  | 300         | 4               | 35               | 4             | 5                | 120             | 6                | 1 min       | x:100<br>y:100<br>z:100.2 | Water                   |
|  | Pro Model Resin for Implant (Yellow) | 0.05         | 3                 | 8                  | 300         | 4               | 30               | 4             | 5                | 120             | 6                | 3 min       | x:100<br>y:100<br>z:100.2 | 95% Alcohol / Isopropyl |
|  | Try-in Resin                         | 0.05         | 2.5               | 8                  | 300         | 4               | 30               | 4             | 5                | 120             | 6                | 30 s        | x:100<br>y:100<br>z:100   | 95% Alcohol / Isopropyl |
|  | Gingiva Mask Resin                   | 0.05         | 3.2               | 8                  | 300         | 4               | 15               | 4             | 5                | 120             | 6                | 30 s        | x:100<br>y:100<br>z:100   | 95% Alcohol / Isopropyl |
|  | Surgical Guide Resin                 | 0.05         | 3                 | 8                  | 300         | 4               | 30               | 4             | 5                | 120             | 6                | 1 min       | x:100<br>y:100<br>z:100   | 95% Alcohol / Isopropyl |

Wavelength: 385 nm / 405 nm — applies to all resins above.

### Printing Parameters — Elegoo Mars5 Ultra

| Photo                                                                               | Model                                | Layer Height | Exposure Time (s) | Bottom Exp. (s) | Bottom Layers | Rest After Retract (s) | Scale Comp.             | Curing Time | Cleaning                |
|-------------------------------------------------------------------------------------|--------------------------------------|--------------|-------------------|-----------------|---------------|------------------------|-------------------------|-------------|-------------------------|
|    | Pro Model Resin Plus (Yellow)        | 0.05         | 3                 | 30              | 5             | 2                      | x:100.2 y:100.2 z:100.2 | 3 min       | 95% Alcohol / Isopropyl |
|    | Pro Model Resin Plus (Grey)          | 0.05         | 3                 | 30              | 5             | 1                      | x:100.2 y:100.2 z:100.2 | 1 min       | 95% Alcohol / Isopropyl |
|   | Pro Model Resin                      | 0.05         | 3                 | 30              | 5             | 1                      | —                       | 1 min       | 95% Alcohol / Isopropyl |
|  | Pro Model Resin Washable             | 0.05         | 3.8               | 30              | 5             | 1                      | —                       | 1 min       | Water                   |
|  | Pro Model Resin for Implant (Yellow) | 0.05         | 3.5               | 30              | 5             | 1                      | x:100.2 y:100.2 z:100.2 | 3 min       | 95% Alcohol / Isopropyl |
|  | Pro Model Resin for Implant (Grey)   | 0.05         | 3                 | 30              | 5             | 1                      | x:100.2 y:100.2 z:100.2 | 1 min       | 95% Alcohol / Isopropyl |
|  | Temporary C&B; Resin                 | 0.05         | 3.5               | 30              | 5             | 1                      | —                       | 30 s        | 95% Alcohol / Isopropyl |
|  | Gingiva Mask Resin                   | 0.05         | 3.8               | 12              | 5             | 1                      | x:99.95 y:99.95 z:99.95 | 30 s        | 95% Alcohol / Isopropyl |
|  | Surgical Guide Resin                 | 0.065        | 3.5               | 30              | 5             | 1                      | —                       | 1 min       | 95% Alcohol / Isopropyl |

Wavelength: 385 nm / 405 nm — applies to all resins above.