

# User Guideline

## Ultracur3D® ST 45 B

The following User guideline is for professionals who use: **Ultracur3D® ST 45 B**.

The safety data given in this publication is for information purposes only and does not constitute a legally binding Material Safety Data Sheet (MSDS). The relevant MSDS can be obtained upon request from your supplier or you may contact BASF directly at [sales@basf-3dps.com](mailto:sales@basf-3dps.com).

**For more information, please refer to the country specific MSDS for advice.**

### **Manufacturer**

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### **Storage Conditions and Disposal Considerations**

Keep container tightly closed in a room temperature, well-ventilated place. Keep container dry. If Material is not being used fill it back through a filter in the corresponding material bottle. The filter prevents to fill cured pieces or failed prints back into the bottle. Ultracur3D® ST 45 B must be disposed of or incinerated in accordance with local regulations.

**For more information, please refer to the country specific MSDS for advice.**

### **Delivery units**

Ultracur3D® ST 45 B is available in the following packaging sizes: 1 kg, 5 kg (available soon), 10 kg and possible larger volume packaging are also available upon request.

### **Intendent Use**

Ultracur3D® ST 45 B is a technical material based on (meth-)acrylate resin for suggested LCD and DLP systems. Working wavelength: 355nm, 385 nm or 405 nm. Attached a list of suggest 3D printer and Printing parameters. For more information contact BASF directly at [sales@basf-3dps.com](mailto:sales@basf-3dps.com).

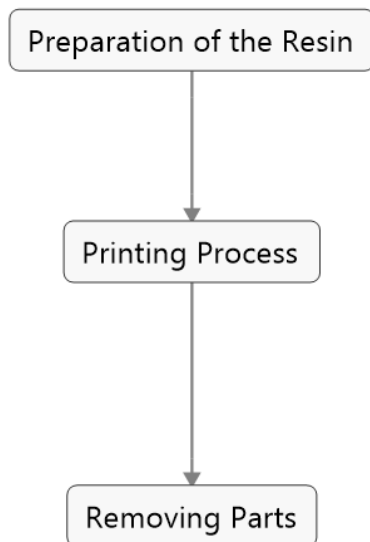
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Version 2.1

### Example of Suitable 3D-Printers and Settings

PRINTER	MIICRAFT ULTRA 125	MIICRAFT ULTRA 125	ORIGIN GEN 2.5 A2 (ORIGIN)
<b>Wavelength</b>	385 nm	385 nm	385 nm
<b>Power</b>	5.5 mW / cm <sup>2</sup>	2.5 mW / cm <sup>2</sup>	5 mW / cm <sup>2</sup>
<b>Curing time</b>	2.25 s	3 s	4.5 s
<b>Voxel depth</b>	75 μm	50 μm	100 μm

### Printing Process



The material should be processed at room temperature. Before usage the material should be shaken well. Pour it slowly in the vat and wait a couple minutes, until smooth, bubble-free surface is obtained before starting the print job.

As the suitable 3D printer examples and setting parameters stated above are only for general guidance purpose, user should always define the optimal settings according to his needs by himself. Please refer to Instruction of Use or User Guide of the employed 3D-Printer for the printer settings and handling.

Remove the parts carefully from the build platform with a suitable tool, for more information see the Instruction for Use of the used 3D-Printer.

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## Cleaning and Post-curing process

### Cleaning Process

Ultracur3D® ST 45 B can be cleaned with ResinAway (Monocure 3D) & 2-propanol, please refer to the following cleaning procedure.

#### Cleaning with ResinAway & 2-propanol

**Step 1:** Place the parts in a container filled with ResinAway (Monocure 3D) and in an Ultrasonic bath filled with water for 3 minutes.

**Step 2:** Rinse the parts with 2-propanol for a few seconds. Fine structures or holes may be better cleaned by using 2-propanol and a syringe or by separate brushing. The parts should be placed afterwards in a container filled with fresh 2-propanol and subsequently treated in an ultrasonic bath filled with water for 3 minutes.

**Step 3:** Blow dry the parts with pressure air/nitrogen, until the parts are clean.

### Drying

Place the parts into a warming cabinet @40°C for 30 minutes.

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Post curing

Ultracur3D® ST 45 B parts require adequate post curing to achieve the optimized final mechanical properties. After each post-curing cycle, the part needs to be flipped to achieve an even curing.

Examples of post curing procedures

**MiiCraft Ultra 125**

<b>Post-curing unit</b>	<b>Dymax ECE 2000 flood</b>
<b>Amount of cycles</b>	2
<b>Duration of one curing cycle</b>	600 seconds

**Origin Gen 2.5 A2 (Origin)**

<b>Post-curing unit</b>	<b>Dymax ECE 2000 flood</b>
<b>Amount of cycles</b>	2
<b>Duration of one curing cycle</b>	600 seconds

Finishing Process

Remove, if necessary, support structures and smoothing the surface.

These proceedings are only general guidelines, the optimal printing settings as well as curing time must be defined by the user himself. The post-curing might differ by using different 3D-Printers and different post-curing units may require different settings.

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