



Shake the bottle and mix the resin in the vat before start printing!

User Guide for Craft - Glow in Dark

For other resin user guides, please visit <https://siraya.tech/support-section>

The Craft – Glow In The Dark resin is ideal for applications that require print to emit light in the darkness. The resin can be activated with UV light, Sunlight or even flashlights from smartphones.

The ideal printing condition for Craft is over 25C as it improves curing speed and lowers viscosity.

Best print with recommended support setting, see below

Exposure Setting

Printer	Recommended Layer Height	Resin Temperture 25-35C	
		Exposure (s)	# of Initial Layers Exposure for Init Layers
Photon	50um	12 (s)	4 60 s
Peopoly Phenom	use Peopoly Deft profile for your printer type in Chitubox		
EPA X1	50um	9.5 (s)	4 55 s
Shuffle	50um		
Shuffle XL	50um		
Mars 2 Pro	50um	2s	5 25
Mars	50um	9.5 (s)	4 55 s
Photon Mono	50um	2s	5 25
Mono X	50um	2s	5 25

Glow-in-the-dark effect

The glow be activated via the use of common household light sources, including LED and flourecent light. A quick charge of a minute in close range (10cm) can give good effect.

UV Light can also be used to add energy to the printed object and depending on energy level, 30 seconds to a minute can be ample when done in clsoe range.

The glow effect can last up to 4 hours in dark environment while the glow diminishes over time.

Recommend best support settings:

We recommend medium preset support setting in chitubox for smaller prints. Heavy support for large prints on large priners

If you don't use chitubox, at least download a copy and see the detail settings for each preset and copy them over to your software of choice

Cleaning:

Use a painter brush (or any brush made with hair) remove excess resins on the printed part with Use 95% concentrated Ethanol (preferred) or IPA to clean. Some form of methnol should work but make sure it does not contain acetone.

Do not submerge the parts in alcohol for more than 30 seconds. After 2-3 minutes of cleaning action, remove alcohol with a hair dryer or air blower. For complex part with lots cavities, it may be a good idea to clean/dry multiple times.

User can check by touching the dried surface of the part to see if it is still sticky. If the dried surface is still sticky, wash some more and dry again.

Post Curing:

Craft reached its optimal strength when the printed part is post-cured with UV after cleaned. Use 395-405nm UV light and cure for about 1-2 minutes.

Make sure resin is completely cleaned off and there is not alcohol left (it needs to be dry) on the print before curing.

It is important to dry the print made by Craft completely before post curing. There is no need to use submerge in water technique with Craft

Mechanical Properties

Shore D 84

Tensile Strength 43Mpa

Young's Modulus 950Mpa

Elongation At Break: 2.5%

Viscosity:	330cps
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Heat Deflection Temperature: 65C

MSDS

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