

Recommended		Resin Temperature 25-35C			Room temperature 20-28C			Note
Printer	Layer Height	Exposure (s)	# of Initial Layers	Exposure for Init Layers	Exposure (s)	# of Initial Layers	Exposure for Init Layers	
Photon	50um	12 (s)	4	40 s	12 (s)	4	40 s	
EPA X1	50um	9 (s)	4	40 s	9 (s)	4	40 s	
EPA X1	100um							
Shuffle	50um							
Shuffle XL	50um							
D7	50um							
Inkspire	50um				15 (s)	6	80 s	Inkspire does not specify its light output, one user told us it is very closely to Photon
Photon Mono	Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHhO?usp=sharing							
Photon Mono X	Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHhO?usp=sharing							
Mars 2 Pro	Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHhO?usp=sharing							
Mars 3	Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHhO?usp=sharing							

Saturn	Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing
Sonic Mini 4K	Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing
Might 4K	Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing
Mega 8K	Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing
Peopoly Printers	Where to find printer profiles: https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing
Before Printing	
It is a good practice to mix resin and expose the bottom of the vat to air before printing. This replenish oxygen in the vat and helps reduce peel force.	
It would also ensure print consistency if user can get the initial resin temperature above 25 and keep the environmental temperature above 20 C	
Recommend best support settings:	
Tenacious has the most impact resistance of all the Siraya Tech resins and thus has the most flexibility. This means it likes thicker support to print well.	
Depending on the printer, you may want to check out the Blu recommended support setting as a starting point. It is best to print no less than 80um for this resin.	
Tenacious Support recommendation: Tenacious has the more flexibility of all our resins. Make sure the support tip diameter is 1.2mm for larger prints with a depth of 0.5mm. See more full settings recommended https://www.facebook.com/groups/sirayatech/permalink/290257771885611/	
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:	
Tenacious reached its optimal strength when the printed part is post-cured with UV after cleaned. Use 395-405nm UV light and cure for about 25 minutes.	
Make sure resin is completely cleaned off and there is not alcohol left on the print before curing. Curing by submerging object in water will significantly increase curing efficiency	
Mechanical Properties	
Shore Hardness (D)	65D
Tensile Stress at Break (MPa)	28
IZOD Impact (Notched, J/m)	57
HDT at 0.455 MPa (°C)	55
Elongation at Break (%)	70
Young's Modulus (MPa)	800
msds	
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TDS	
https://drive.google.com/file/d/1COV6emzdbWFPRHsKVQWdlzhHwwZKDzrlx/view?usp=drive_link	