SIRAYA Tech

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

Fast - Navy Grey requires 20% longer exposure than other Fast, click to visit Navy Grey User Guide

User Guide for Fast

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

Fast is an affordable fast curing and non-brittle general application resin ideal for model making like tabletop minis, and figurines.
It is not a tough or engineering resin but can be mixed with Blu/Tenacious for more impact resistance.

While the ideal printing condition for Fast is over 20C, we have printed as low as 15C as long as the bottom layers uses more exposure time
Fast is designed for MSLA printer in mind. It can work in DLP and laser SLA printer but you would need FEP film based vat
Best print with recommended support setting, see below

Exposure (For all Fast colors except Navy Grey) Fast Navy Grey user guide here: Navy Grey User Guide

Please download profiles base for Elegoo, Anycubic, Phrozen, Peopoly, EPAX, Creality

https://drive.google.com/drive/folders/1eCz4_dc0fT-jfBLp4L9mKYebY90lfHHO?usp=sharing

If you don't fine profiles above, try these Print Setting Recommendation

Brand	Creality	Creality	Creality	Creality
Printer	LD-002H	LD-002R	Halot One	Halot Sky
Layer height (mm)	0.05	0.05	0.05	0.05
Bottom layer count	5	5	5	5
Exposure time (s)	2.25	8	2.5	2.5
Bottom exposure time (s)	33	50	35	35
Waiting Mode During Printing	Rest	Rest	Rest	Rest
Bottom light off delay (s)	0	0	0	0
Rest Time Before Lift (s)	0	0	0	0
Rest Time After Lift (s)	0	0	0	0
Rest Time After Retract (s)	1	1	1	1
Bottom Lift Distance (mm)	5	5	5	5
Lift Distance (mm)	5	5	5	5
Bottom Retract Distance (mm)	5	5	5	5
Retract Distance (mm)	5	5	5	5
Bottom Lift Speed (mm/min)	50	50	50	50
Lift Speed (mm/min)	60	60	60	60
Bottom Retract Speed (mm/min)	150	150	150	150
Retract Speed (mm/min)	200	200	200	200
Transition Layer Count	5	4	5	5
Transition Type	Linear	Linear	Linear	Linear
Transition Time Decrement	n/a	n/a	n/a	n/a

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.

After 4 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 dryed surface of the part to see if it is still sticky. If the dryed surface is still sticky, wash some more and dry again.

Post Curing:

Fast reaches 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 no alcohol left (it needs to be dry) on the print before curing.

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

Mechanical Properties

Shore Hardness (D)	75D
Tensile Stress at Break (MPa)	31
IZOD Impact (Notched, J/m)	25
HDT at 0.455 MPa (°C)	65
Elongation at Break (%)	7
Young's Modulus (MPa)	1100
Viscosity	110cps
Shrinkage	6% per volume

MSDS

https://drive.google.com/open?id=1lWqnHnGQKKKlNFQRnKpSpGX_4cuvIxrP

TDS

https://drive.google.com/file/d/1K8FkqqNVSuEOm-T05kwhnx5uyvkKtULp/view?usp=drive_link