



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

## User Guide for Simple

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

Simple is an affordable easy to print and clean for general application resin ideal for model making like tabletop minis, and figurines. It can be cleaned with 15% alcohol and is ideal for large format printer and new resin printer users

Simple Resin is very easily dissolved by water and thus do not leave the print in alcohol or water for more than 20s. Actively quickly wash the print and dry quickly with a hairdryer if needed. Don't slow dry and use sun to cure at the same time

While the ideal printing condition for Simple is over 20C, we have printed as long as 15C as long as the bottom layers uses more exposure time

**Best print with recommended support setting, see below**

### Exposure (Simple Clear / Smoky Black)

	Recommended	Resin Temperture 25-35C			Room temperature 20-25C							
Printer	Layer Height	Exposure (s)	# of Initial Layers	Exposure for Init Layers	Exposure (s)	# of Initial Layers	Exposure for Init	Note				
Photon	50um	10 (s)		4 60 s	10(s)		6 60 s					
Peopoly Phenom	50um	10s		6 60 s	10s		6 60 s	see below for detail settings				
EPA X1	50um	7 (s)		4 45 s	7 (s)		6 50 s					
Mars	50um	7 (s)		4 50 s	7 (s)		4 50 s					
Prusa SL1	50um	4.5 s		10 30 s	4.5		4 30s	50um, 4.5 sec exposure time, 30 sec initial exposure time, 10 fade layers				
Phrozen Transform	Siraya Simple Clear	0.05	300	1000	6	32000	8	75	12000	6	80	
Photon Mono	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Photon Mono X	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Mars 2 Pro	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Mars 3	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Saturn	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Sonic Mini 4K	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Might 4K	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Mega 8K	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing</a>											
Peopoly Printers	Where to find printer profiles: <a href="https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing">https://drive.google.com/drive/folders/1eCz4_dc0fT-fjBLp4L9mKYebY90lfHHO?usp=sharing</a>											

### Before Printing

It is a good practice to stir resin in the vat and expose the bottom of the vat to air before printing. This replenish oxygen in the vat and helps reduce peel force.

### Recommend best support settings:

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

Simple is best cleaned with 15% alcohol (1 part 90% alcohol + 5 part water). It could be clean with higher alcohol but is not needed to achieve great cleaning.  
Simple Resin is very easily dissolved by water and thus do not leave the print in alcohol or water for more than 20s.

**Actively quickly wash the print and dry quickly with a hairdryer if needed. Don't slow dry and use sun to cure at the same time**

Use a painter brush (or any brush made with hair) remove excess resins on the printed part with Use 15% 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.

When using ultrasonic + non-solvent based cleaning agent, be careful not to leave the print in too long. It should be no longer than 3 minutes and must dry completely before post curing or the residual water may lead to cracks.

**Post Curing:**

**Quickly drying print is essential for Simpl resin. Do not leave it in the sun to dry. Use a hairdryer.**

Simple 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 Simple completely before post curing. There is no need to use submerge in water technique with Simple. Failure to dry before curing may lead to cracks**

### Mechanical Properties

Shore D 86

Tensile Strength 32Mpa

Young's Modulus 450Mpa

Elongation At Break: 4%

Viscosity:	52 cps
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MSDS

<https://drive.google.com/open?id=17VhFINshNEJ9AS5D2Ilp-LOMBAsSfXWO>