

【Phrozen Resin User Guide】

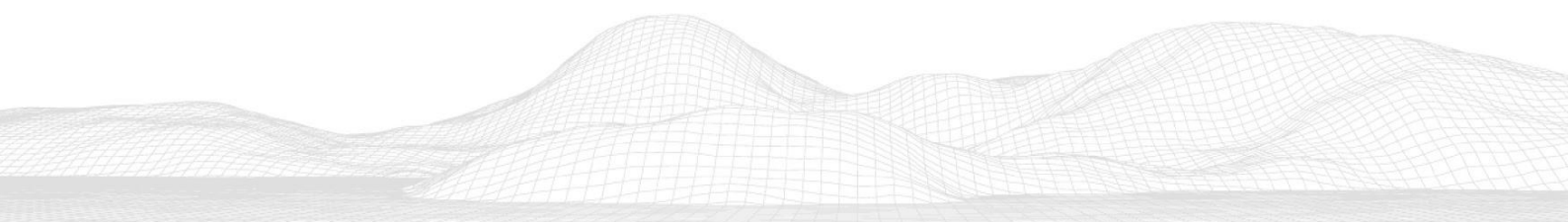
Engineering Tough Resin: Tough 100E, Green,Black

Outline

Before printing an object, it is important to first understand the limits of the materials and how it can be successfully printed under various conditions. With this in mind, Phrozen provides the following design recommendations to help improve print success rates and produce models that better match your intended results.

Table of Contents

TDS.....	1
Printing.....	3
Printing Parameters.....	3
Cleaning.....	8
Post-Curing.....	9
Design Specifications.....	10
Minimum Unsupported Wall Thickness.....	10
Size Tolerance, X-Y plane.....	10
Minimum Pin Diameter.....	11
Minimum Hole Diameter, X-Y plane.....	11
Minimum Embossed Detail Width, X-Y plane.....	12
Minimum Engraved Detail Width, X-Y plane.....	12
Maximum Horizontal Bridge Span.....	13
Minimum Hole Diameter and Engraved Detail Width, Z-axis, at 0.05.....	13
mm layer height.....	13
Block shrinkage test, at 0.05mm layer height.....	14



Section 1

TDS

General Properties	Norm	Typical values	
Appearance	-	Green	Black
Viscosity, 30	BROOKFIELD Viscometer(LV)	1900 - 2500 cps	1900 - 2500 cps
Density (liquid resin)	ASTM D4052-18a	1.10 g/cm ³	1.10 g/cm ³
Tensile Properties	Norm	Typical values (UV post-cured)	
Tensile Strength at Break	ASTM D638	29.9 MPa	24.6 MPa
Tensile Modulus	ASTM D638	1058.8 MPa	925.4 MPa
Elongation at Break	ASTM D638	93.5 %	100.5 %
Flexural Properties	Norm	Typical values (UV post-cured)	
Flexural Strength	ASTM D790	33.2 MPa	23 MPa
Flexural Modulus	ASTM D790	1381.7 MPa	711 MPa
Impact Properties	Norm	Typical values (UV post-cured)	
Notched Izod (Machined), 23 °C	ASTM D256	69.1 J/m	77.3 J/m
Thermal Properties	Norm	Typical values (UV post-cured)	
HDT at 0.45 MPa	ASTM D648	51.5 °C	52.7 °C
Hardness	Norm	Typical values (UV post-cured)	
Shore D	ASTM D2240	69 - 76D	69 - 76D
Water Absorption	Norm	Typical values (UV post-cured)	
Short Term (24hr)	ASTM D570	5.82 %	5.79 %

** All testing specimens are printed using Phrozen Sonic Mighty 8K or Sonic Mini 8K, and post-cured using Phrozen Wash & Cure Kit.*

** Increasing the curing time might improve the mechanical properties, but also increase the risk of deformation.*

Specimens are printed unless stated otherwise. The information in this TDS, including product recommendations, is based on our current knowledge and experience.

Descriptions, drawings, photographs, data, proportions, weights, etc. provided may change without notice and do not establish the product's contractual quality. Request the relevant MSDS from your supplier or contact Phrozen Tech Co., Ltd at sales@phrozen3d.com

Section 2

Printing

Printing Parameters

Printer	Sonic mini / Sonic mini 4K	
Color	Green	Black
Layer Height	50 μ m	50 μ m
Exposure Time	3.5 $\pm$ 0.5 s	6 $\pm$ 0.5 s
Bottom Exposure Time	30 $\pm$ 5 s	30 $\pm$ 5 s
Light-off Delay	15 s	15 s
Lift Distance	6 mm	6 mm
Lifting Speed	60 mm/min	60 mm/min

Printer	Sonic Mini 8K	
Color	Green	Black
Layer Height	50 μ m	50 μ m
Exposure Time	4 $\pm$ 0.5 s	4.5 $\pm$ 0.5 s
Bottom Exposure Time	35 $\pm$ 5 s	30 $\pm$ 5 s
Rest Time After Retract	5 $\pm$ 1 s	5 $\pm$ 1 s
Lift Distance	6 mm	6 mm
Lifting Speed	60 mm/min	60 mm/min

Printer	Sonic Mini 8K S	
Color	Green	Black
Layer Height	50 μ m	50 μ m
Exposure Time	6 $\pm$ 0.5 s	6.5 $\pm$ 0.5 s
Bottom Exposure Time	20 $\pm$ 5 s	20 $\pm$ 5 s
Rest Time After Retract	5 $\pm$ 1 s	5 $\pm$ 1 s
Lift Distance	6 mm	6 mm
Lifting Speed	60 mm/min	60 mm/min

Printer	Sonic Mighty 4K	
Color	Green	Black
Layer Height	50 μ m	50 μ m
Exposure Time	3.5 $\pm$ 0.5 s	6 $\pm$ 0.5 s
Bottom Exposure Time	30 $\pm$ 5 s	30 $\pm$ 5 s
Light-off Delay	20 $\pm$ 5s	20 $\pm$ 5s
Lift Distance	8 mm	8 mm
Lifting Speed	60 mm/min	60 mm/min

Printer	Sonic Mighty 8K	
Color	Green	Black
Layer Height	50 μ m	50 μ m
Exposure Time	3 $\pm$ 0.5 s	4.5 $\pm$ 0.5 s
Bottom Exposure Time	35 $\pm$ 5 s	35 $\pm$ 5 s
Rest Time After Retract	10 $\pm$ 5 s	10 $\pm$ 5 s
Lift Distance	10 mm	10 mm
Lifting Speed	60 mm/min	60 mm/min

Printer	Sonic Mighty 12K	
Color	Green	Black
Layer Height	50 μ m	50 μ m
Exposure Time	3 $\pm$ 0.5 s	4.5 $\pm$ 0.5 s
Bottom Exposure Time	35 $\pm$ 5 s	35 $\pm$ 5 s
Rest Time After Retract	10 $\pm$ 5 s	10 $\pm$ 5 s
Lift Distance	10 mm	10 mm
Lifting Speed	60 mm/min	60 mm/min

Printer	Sonic Mighty Revo 14K	
Color	Green	Black
Layer Height	50 μ m	50 μ m
Exposure Time	4 $\pm$ 0.5 s	5 $\pm$ 0.5 s
Bottom Exposure Time	35 $\pm$ 5 s	40 $\pm$ 5 s
Rest Time After Retract	10 $\pm$ 5 s	10 $\pm$ 5 s
Lift Distance	10 mm	10 mm
Lifting Speed	60 mm/min	60 mm/min
Heating Function	On	On

Printer	Sonic Mighty Revo 16K	
Color	Green	Black
Layer Height	50 μ m	50 μ m
Exposure Time	3.5 $\pm$ 0.5 s	4.5 $\pm$ 0.5 s
Bottom Exposure Time	25 $\pm$ 5 s	25 $\pm$ 5 s
Rest Time After Retract	10 $\pm$ 5 s	10 $\pm$ 5 s
Lift Distance	10 mm	10 mm
Lifting Speed	60 mm/min	60 mm/min
Heating Function	On	On

Printer	Sonic Mega 8K*	
Color	Green	Black
Layer Height	50 μ m	50 μ m
Exposure Time	3 $\pm$ 0.5 s	4 $\pm$ 0.5 s
Bottom Exposure Time	30 $\pm$ 5 s	30 $\pm$ 5 s
Rest Time After Retract	10 $\pm$ 5 s	10 $\pm$ 5 s
Lift Distance	10 mm	10 mm
Lifting Speed	60 mm/min	60 mm/min
Heating Function	50 μ m	50 μ m

Printer	Sonic Mega 8K S*	
Color	Green	Black
Layer Height	50 μ m	50 μ m
Exposure Time	3 $\pm$ 0.5 s	4 $\pm$ 0.5 s
Bottom Exposure Time	30 $\pm$ 5 s	30 $\pm$ 5 s
Rest Time After Retract	10 $\pm$ 5 s	10 $\pm$ 5 s
Lift Distance	10 mm	10 mm
Lifting Speed	60 mm/min	60 mm/min
Heating Function	50 μ m	50 μ m

Printer	Sonic Mega 8K V2	
Color	Green	Black
Layer Height	50 μ m	50 μ m
Exposure Time	3 $\pm$ 0.5 s	4 $\pm$ 0.5 s
Bottom Exposure Time	35 $\pm$ 5 s	35 $\pm$ 5 s
Rest Time After Retract	10 $\pm$ 5 s	10 $\pm$ 5 s
Lift Distance	10 mm	10 mm
Lifting Speed	60 mm/min	60 mm/min
Heating Function	50 μ m	50 μ m

- ◆ Sonic Mega 8K / Mega 8K S / Mega 8K V2 has a higher peeling force. Therefore, a longer exposure time is necessary to increase the success rate.
- ◆ Be sure to cover the hood when printing to maintain the best printing condition of the resin.
- ◆ Increasing rest time can slow down resin accumulation, leading to improved resolution.

Cleaning

1. After removing the printed object from the building plate, use the Phrozen Wash and Cure Kit for post-processing.
2. Soak the object in the Washing Station filled with 95% ethanol for 45–60 seconds to remove uncured resin from the surface. Do not soak models in solvent for more than 60 seconds as it may damage model surfaces.
3. Make sure to clean the inner parts of hollow objects completely.
4. After thoroughly cleaning the object, leave it in a cool, well-ventilated place for at least 30 minutes. Alternatively, you may gently use a compressed air gun to dry the printed object.

*When printing flat on the building plate, remove the printed objects carefully to avoid deformation on the objects.

Post-Curing

1. Use Phrozen post-curing stations (Phrozen Wash & Cure Kit / Phrozen Cure Mega S) or other post-curing lamps with the same wavelength to cure
2. printed objects.
3. Regular UV post-curing for 60 minutes.

Section 3

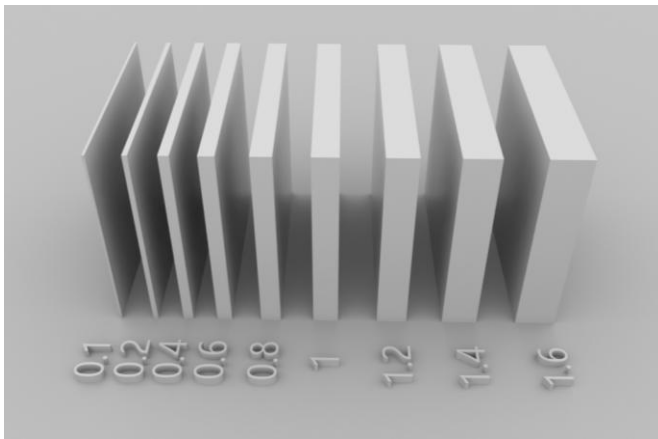
Design Specifications

※Note: All indicators are limited to each resin; the value will vary with different machines and environmental conditions.

Minimum Unsupported Wall Thickness

This indicator shows the minimum wall thickness that can be printed independently with no support without causing any bending or breaking.

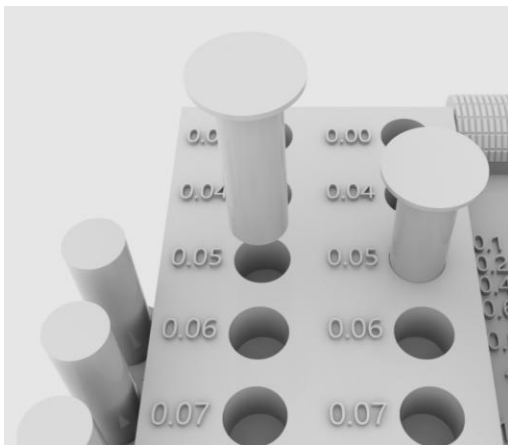
Recommended thickness : ≥ 0.2 mm



Size Tolerance, X-Y plane

This indicator shows the minimum dimensional tolerance between the hole and the column parallel to the XY plane.

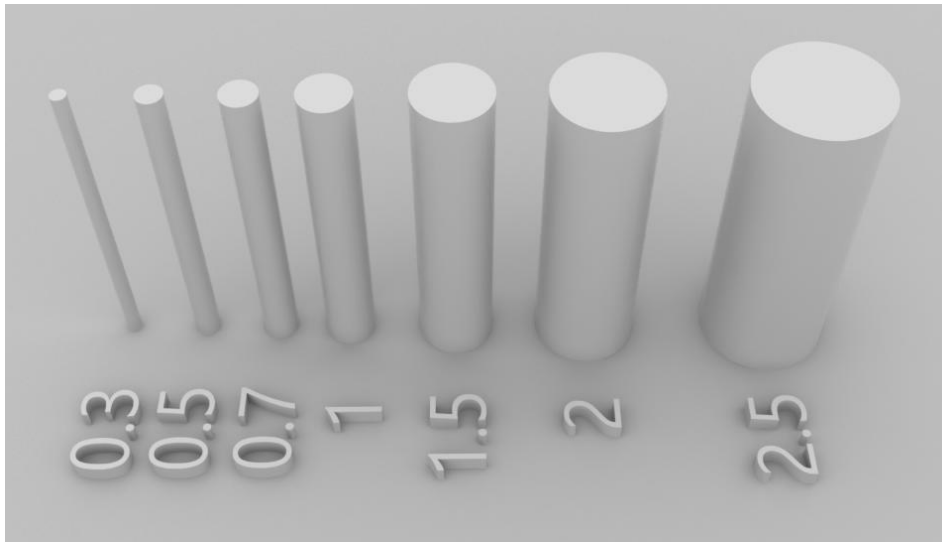
Recommended tolerance : ≥ 0.06 mm



Minimum Pin Diameter

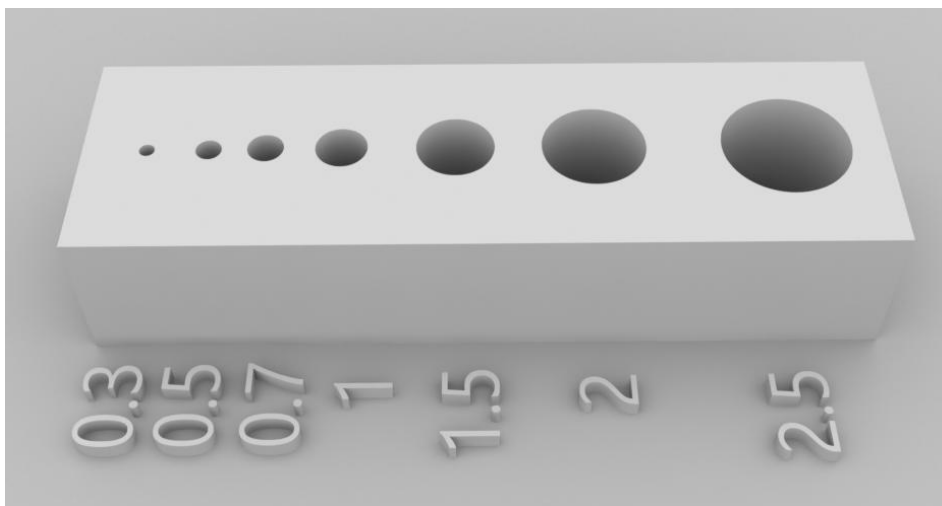
This indicator shows the minimum column diameter of pillars and supports that can be printed independently without bending or breaking.

Recommended diameter : ≥ 0.3 mm



Minimum Hole Diameter, X-Y plane

This indicator shows the minimum hole diameter that can be successfully printed parallel to the XY plane. Recommended diameter : ≥ 0.7 mm



Minimum Embossed Detail Width, X-Y plane

This indicator shows the minimum line width that can successfully be printed with embossed details.

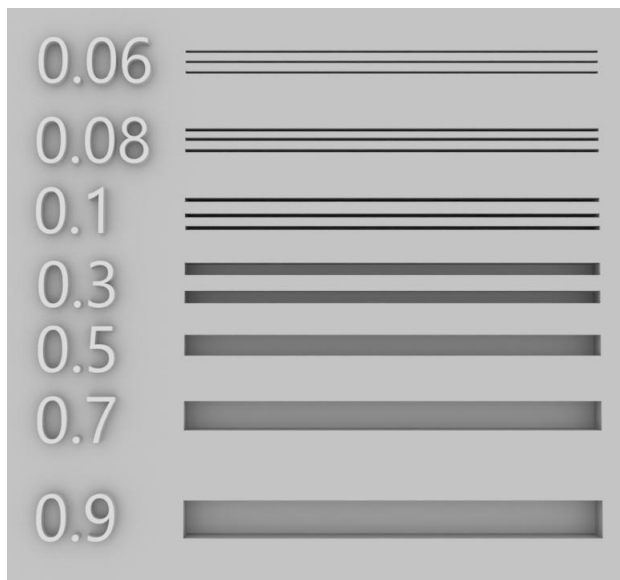
Recommended width: ≥ 0.1 mm



Minimum Engraved Detail Width, X-Y plane

This indicator shows the minimum line width that can successfully be printed with engraved details.

Recommended width: ≥ 0.3 mm



Maximum Horizontal Bridge Span

This indicator shows the maximum width between the supporting walls that can be printed without deforming the bridge.

Recommended width : ≤ 2 mm

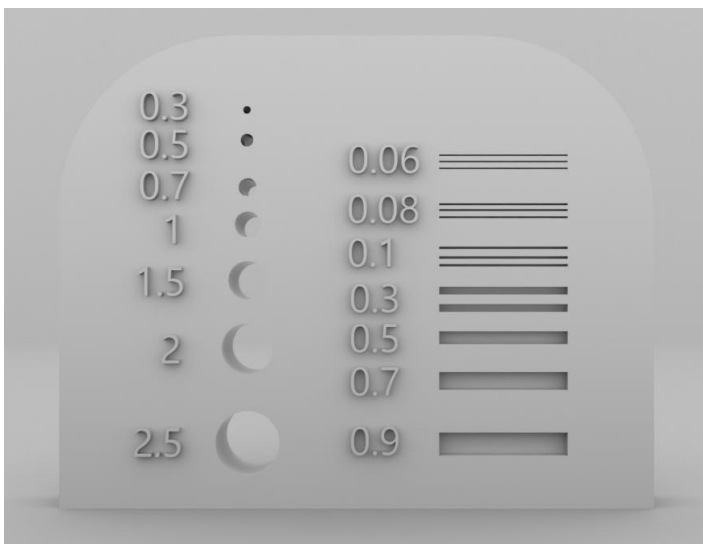


Minimum Hole Diameter and Engraved Detail Width, Z-axis, at 0.05 mm layer height

This indicator shows the minimum hole diameter and engraving groove width that can be successfully printed on the Z-axis with a layer thickness of 0.05 mm.

Recommended diameter : ≥ 0.7 mm

Recommended width : ≥ 0.08 mm



Block shrinkage test, at 0.05mm layer height

This indicator shows the possible deformation for a 2x2x1 cm cuboid printed parallel to the XY plane. A Vernier caliper is used to measure the cuboid after post-curing to calculate the shrinkage rate. (This test result is only for reference purposes. Different machines and models may affect results.)

Calculation method: $[(\text{Cured size} - \text{Original size}) / \text{Original size}] \times 100\%$

X-Axis Recommended Shrinkage Rate: 0.75%

Y-Axis Recommended Shrinkage Rate: 0.7%

