RESINIFY — INSTRUCTIONS FOR USE (IFU)

CeramixGray — High-Stiffness, Ceramic-Reinforced Modeling Resin For High-Precision Engineering & Prototype Tooling

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1. Product Overview

CeramixGray is a ceramic-reinforced engineering resin designed for **high stiffness**, **dimensional stability**, and **low shrinkage**, ideal for precision prototypes, jigs, fixtures, and tooling components.

2. Printer Compatibility

- LCD / mSLA / DLP systems
- 385–405 nm wavelength
- Suitable for high-detail engineering prints

3. Printing Instructions

Parameter	Recommended
Layer Height	50 µm (25–100 µm compatible)
Normal Exposure	3.2–4.2 sec
Bottom Exposure	45–60 sec
Bottom Layers	6–8
Lift Speed	Medium
Light-Off Delay	Enabled

Support Tips:

- Use medium-to-heavy supports for rigid components.
- Tilt large flat surfaces 20–30° to prevent peel distortion.
- Reinforce long features to avoid micro-warping.

4. Cleaning Instructions

- Wash **3–4 minutes** total in clean IPA or resin cleaner.
- Dry thoroughly; ceramic materials benefit from complete evaporation.
- Avoid over-washing to prevent surface chalkiness.

5. Post-Curing Instructions

- UV cure **25–35 minutes**.
- Optional heat cure: **60°C** for 15–20 minutes to maximize rigidity.

6. Usage Guidelines

- Excellent for precision components, form-fit prototypes, molds, and fixtures.
- Produces a matte, ceramic-like surface finish.
- Sands and machines well with fine-grit tools.
- Avoid dropping—high stiffness materials can chip.

7. Safety & Disposal

- Wear gloves, mask, and eye protection.
- Avoid breathing sanding dust.
- Fully cure waste material before disposal.
- Dispose of IPA per local chemical regulations.