



RESINIFY — INSTRUCTIONS FOR USE (IFU)

FlexPro 80A (RT-FX80A) — Medium-Flex Elastomer Resin (Shore 80A) For Functional Flexible Parts, Protective Components & Industrial Prototyping

1. Product Overview

FlexPro 80A is a durable elastomeric resin engineered for **medium-flex components**, providing rubber-like performance with excellent tear resistance and rebound. Suitable for hinges, protective covers, grips, vibration-damping parts, and industrial elastomer applications.

2. Printer Compatibility

- LCD / mSLA / DLP printers
- 385–405 nm wavelength
- Best performance with controlled, slower lift speeds

3. Printing Instructions

Parameter	Recommended
Layer Height	50–100 μm
Normal Exposure	2.8–3.4 sec
Bottom Exposure	40–55 sec
Bottom Layers	6–8
Lift Speed	Slow–Medium
Light-Off Delay	Enabled

Support Tips:



- Use medium supports for flexibility.
- Angle prints 20–30° to avoid stresses on flexible walls.
- Add additional supports on thin ribs or hinges.

4. Cleaning Instructions

- Wash **1–2 minutes total** with IPA or resin cleaner.
- Avoid long IPA exposure — can stiffen or damage elastomer surfaces.
- Blow dry gently and ensure full evaporation before post-cure.

5. Post-Curing Instructions

- UV cure **10–15 minutes**.
- For highest tear resistance: heat cure **45–50°C**, 10 minutes.
- Avoid over-curing — can increase hardness above Shore 80A.

6. Usage Guidelines

- Ideal for snap-fits, living hinges, gaskets, vibration dampers.
- Maintains flexibility with repeated cycles.
- For maximum toughness, avoid sharp internal corners.
- Not recommended for ultra-thin walls below 0.8 mm.

7. Safety & Disposal

- Wear gloves and eye protection.
- Fully cure waste resin before disposal.
- Dispose of IPA per local regulations.