**RESINIFY — INSTRUCTIONS FOR USE (IFU)**

**FlexX 95A (RT-FX95A) — High-Durometer Elastomer Resin (Shore 95A)** For Tough, Semi-Rigid, TPU-Like Functional Parts

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## 1. Product Overview

FlexX 95A is a **high-durometer elastomer resin** designed for parts requiring strong flexibility with rigid, TPU-like performance. It provides excellent abrasion resistance, fatigue strength, and dimensional stability for industrial applications. Ideal for protective housings, snap-fit mechanisms, semi-flexible couplings, vibration-damping parts, and industrial-grade functional prototypes.

## 2. Printer Compatibility

- LCD / mSLA / DLP printers
- 385–405 nm wavelength
- Slower lift speeds recommended due to material elasticity

## 3. Printing Instructions

| Parameter | Recommended |
|---|---|
| **Layer Height** | 50–100 µm |
| **Normal Exposure** | 3.0–3.8 sec |
| **Bottom Exposure** | 45–60 sec |
| **Bottom Layers** | 6–8 |
| **Lift Speed** | Slow–Medium |
| **Light-Off Delay** | Enabled |

**Support Tips:**

- Use strong medium supports.
- Angle 20–30° to avoid internal suction.
- Add bracing supports on thicker flexible walls.

## 4. Cleaning Instructions

- Wash **1–2 minutes** with IPA or resin cleaner.
- Avoid soaking — can alter elasticity.
- Dry completely; damp surfaces reduce cure quality.

## 5. Post-Curing Instructions

- UV cure **10–20 minutes**.
- Optional heat cure: **45–55°C** for maximum toughness.
- Over-curing may reduce flexibility.

## 6. Usage Guidelines

- Excellent for flexible components under stress.
- Maintains performance under repeated bending cycles.
- Supports fine detail while preserving elasticity.
- Avoid ultra-thin unsupported features (<1 mm).

## 7. Safety & Disposal

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