



RESINIFY — INSTRUCTIONS FOR USE (IFU)

GlassFill Pro (RT-CP6000) — High-Modulus, Glass-Reinforced Composite Resin For Stiff, Lightweight Structural Components & Precision Engineering Parts

1. Product Overview

GlassFill Pro is a **glass-reinforced composite resin** engineered for maximum stiffness, reduced deflection, and stable dimensional performance. Ideal for structural prototypes, fixtures, precision jigs, tooling components, and parts requiring low creep and high rigidity.

2. Printer Compatibility

- LCD / mSLA / DLP printers
- 385–405 nm wavelength
- Optimized for engineering-grade printing

3. Printing Instructions

Parameter	Recommended
Layer Height	50 μm (25–100 μm compatible)
Normal Exposure	3.2–4.0 sec
Bottom Exposure	45–60 sec
Bottom Layers	6–8
Lift Speed	Medium
Light-Off Delay	Enabled

Support Tips:



- Use **strong medium-to-heavy supports** for rigid parts.
- Angle large surfaces 20–30° to prevent peel-related warping.
- Reinforce long, thin sections to avoid micro-deflection during print.

4. Cleaning Instructions

- Wash **3–4 minutes** in IPA or resin cleaner.
- Allow full drying — composite resins need complete evaporation.
- Do not use ultrasonic cleaners (may weaken glass-bound regions).

5. Post-Curing Instructions

- UV cure **25–35 minutes**.
- Optional heat cure: **60–65°C for 15 minutes** to maximize modulus.
- Avoid temperatures >70°C to prevent stress whitening.

6. Usage Guidelines

- Ideal for rigid tooling components, structural brackets, fixtures, calibration masters.
- Produces a smooth, matte composite surface.
- Machines well with carbide tools at low feed rates.
- Avoid sharp impacts — reinforced composites can chip under extreme force.

7. Safety & Disposal

- Wear gloves, mask, and eye protection.
- Avoid inhalation of dust when sanding.
- Cure all waste resin before disposal.
- Dispose of IPA according to local environmental requirements.