



## RESINIFY — INSTRUCTIONS FOR USE (IFU)

**ImpactMax (RT-TF1600) — High-Impact, Toughened Engineering Resin** For Functional Parts Requiring Maximum Durability, Shock Absorption & Drop Resistance

### 1. Product Overview

ImpactMax is a **next-generation tough engineering resin** formulated for parts that must withstand high impact, repeated mechanical loading, and functional abuse. It delivers excellent energy absorption, crack resistance, and long-term durability, making it ideal for real-world functional prototypes and production components.

### 2. Printer Compatibility

- LCD / mSLA / DLP systems
- 385–405 nm wavelength
- Optimized for high-toughness engineering prints

### 3. Printing Instructions

Parameter	Recommended
Layer Height	50 µm (25–100 µm compatible)
Normal Exposure	2.8–3.6 sec
Bottom Exposure	40–55 sec
Bottom Layers	6–8
Lift Speed	Medium



Parameter	Recommended
Light-Off Delay	Enabled

**Support Tips:**

- Use medium supports for flexible-tough prints.
- Angle models 20–30° to minimize suction forces.
- Add reinforcement supports on high-stress regions.

**4. Cleaning Instructions**

- Wash **2–3 minutes** total in fresh IPA or resin cleaner.
- Do not over-wash — excessive IPA exposure may slightly reduce impact toughness.
- Air dry or gently blow dry until fully evaporated.

**5. Post-Curing Instructions**

- UV cure **15–25 minutes**.
- Optional heat cure: **50–60°C for 10 minutes** to maximize impact strength.
- Avoid long curing cycles that may increase stiffness.

**6. Usage Guidelines**

- Ideal for brackets, clips, bumpers, tool handles, and mechanically loaded parts.
- Excellent drop resistance and functional durability.
- Allows drilling, tapping, sanding, and mechanical finishing.
- Avoid thin unsupported walls (<0.8 mm) for best performance.

**7. Safety & Disposal**

- Wear gloves, mask, and eye protection.
- Cure all uncured resin before disposal.
- Dispose of IPA according to local regulatory requirements.