RESINIFY — INSTRUCTIONS FOR USE (IFU)

ToughPro 2000 (RT-TF2000) — High-Performance Tough Engineering Resin For Strong, Durable, Impact-Resistant Functional Parts

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1. Product Overview

ToughPro 2000 is a **high-performance tough engineering resin** designed for demanding applications requiring a balance of impact resistance, elongation, and structural durability. Ideal for functional prototypes, snap-fit features, mechanical housings, and production-ready engineering parts.

2. Printer Compatibility

- LCD / mSLA / DLP printers
- 385–405 nm wavelength
- Tuned for performance printing on engineering platforms

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
Light-Off Delay	Enabled

Support Tips:

- Use medium supports for most functional geometries.
- Angle models 20–30° to reduce suction and improve layer adhesion.
- Add reinforcement supports on thin brackets or long arms.

4. Cleaning Instructions

- Wash **2–3 minutes** in IPA or resin cleaner.
- Do not over-wash — may slightly reduce impact toughness.
- Dry completely before curing.

5. Post-Curing Instructions

- UV cure **15–25 minutes**.
- Optional heat cure: **50–60°C for 10 minutes** to boost strength and modulus.
- Avoid excessive curing to prevent unwanted stiffening.

6. Usage Guidelines

- Excellent for functional parts requiring toughness + durability.
- Supports drilling, tapping, sanding, machining.
- Ideal for snap-fits and hinge components.
- Avoid thin unsupported walls (<0.8 mm) for best mechanical consistency.

7. Safety & Disposal

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