

FLEX60A | RUBBER-LIKE RESIN

1. Product Overview

Flex60A is a rubber-like UV-curable resin formulated for DLP, LCD, and SLA 3D printers. It combines flexibility, tensile strength, and elastic recovery to produce parts with the feel and behaviour of rubber.

The resin’s low odour, low shrinkage, and fine detail reproduction support consistent printing results. Low release forces and balanced build plate adhesion help parts remain secure during printing while allowing straightforward removal. Once fully post-cured, the material develops a dry-touch surface that resists tackiness and improves handling.

Flex60A is suited to producing functional rubber-like prototypes.

2. Key Features & Benefits

- ✓ Realistic rubber-like feel with reliable elasticity
- ✓ Shore A hardness of 60 for flexible, functional parts
- ✓ Low shrinkage for accurate, detailed prints
- ✓ Dry-touch, non-tacky finish after full post-curing
- ✓ Low release forces to support reliable printing
- ✓ Compatible with CustomMix™ additive system

3. Applications

- ★ Prototyping flexible parts and rubber-like components
- ★ Tools, jigs, and fixtures for workshop or lab use
- ★ Flexible mechanical housings and parts
- ★ Industrial and consumer product development
- ★ Producing custom washers, sleeves and gaskets

4. Physical Properties

Property	Value	Test Method
Viscosity @ 25 °C	1400-1800 Cps	ASTM D2196
Odour	3. Weak Odour	VDA 270
Shelf Life	36 months	Internal QC
Optimal UV Cure	365–405 nm	Internal
Cure Speed	(3–5 sec layers)	Internal
Tensile Strength (MPa)	1.92	ASTM D638
Elongation at Break (%)	166.9	ASTM D638
Resilience (%)	15.00	ASTM D2632-15
Shore Hardness (A)	60	ASTM D2240
Glass transition temp. (°C)	-10	DSC

5. Printer Compatibility

- MSLA resin printers
- Curing wavelength 365–405 nm
- Tested with Phrozen, Anycubic, Elegoo, Creality, Uniformation, and many more!

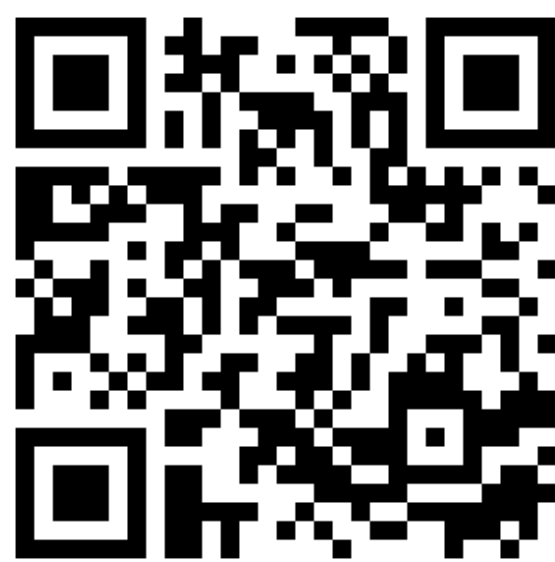
10. Disclaimer

The information provided in this Technical Data Sheet is based on laboratory testing and intended as a general guideline. Actual results may vary depending on printing conditions, curing methods, and environmental factors. Monocure3D assumes no liability for improper use of this product.

6. Printing & Post-Processing Guidelines

Tested with: Anycubic M7 / Phrozen Mini 8K

- Layer thickness 50–100 µm
- Base layer exposure 35–45 seconds
- Normal exposure 2.5–4 seconds
- Lift speed 70 mm/s
- Lift height 8–12 mm



(Refer to printer settings database)

Post-Processing Steps

1. Wash in ResinAway® or IPA immediately after printing
2. Ultrasonic clean in ResinAway® for 5–10 minutes
3. Dry with compressed air or air-dry naturally
4. UV cure for at least 1 hour
5. Optional heat cure at 60°C for 1 hour (recommended)
6. Final rinse with fresh water

7. Health & Safety Information

- Not for intended for intraoral or direct food contact use.
- Use in a ventilated area. Avoid skin & eye contact.
- If contact occurs, wash thoroughly with soap and water.
- Refer to SDS (Safety Data Sheet) for complete handling guidelines www.monocure3d.com.au

8. Storage & Handling

- **Storage Temperature:** 10–30°C (Avoid direct sunlight)
- **Shelf Life:** 36 months
- **Handling:** Use recommend red PPE eg. **gloves & safety goggles** when handling liquid resin
- **Disposal:** Follow **local hazardous waste disposal regulations**.

9. Ordering Information

- **Available Sizes:** 1L & 5L UV-safe bottles
- **Where to Buy:** Available through **Monocure3D resellers**
- For technical support or bulk orders, contact:
 support@monocure3d.com.au | www.monocure3d.com.au