

IMPACT | INDUSTRIAL STRENGTH RESIN

1. Product Overview

IMPACT™ is a tough, high-strength engineering resin designed for functional parts that must withstand heavy use and stress.

Formulated for superior durability and crack resistance, it delivers outstanding performance for industrial and mechanical applications.

Ideal for impact-resistant components, tools, and functional prototypes requiring resilience and accuracy.

Provides a balanced combination of tensile strength, flexibility, and long-term dimensional stability.

2. Key Features & Benefits

- ✓ Exceptional impact resistance and toughness
- ✓ High tensile strength with low brittleness
- ✓ Durable, long-lasting functional parts
- ✓ Tappable, drillable and easy to post-process
- ✓ Consistent print performance across printer types
- ✓ Compatible with CustomMix™ additive system

3. Applications

- ★ Functional prototypes and load-bearing components
- ★ Tools, jigs, and fixtures for workshop or lab use
- ★ Impact-resistant mechanical housings and parts
- ★ Industrial and consumer product development
- ★ Parts that require screw tapping

4. Physical Properties

Property	Value	Test Method
Viscosity @ 25 °C	650–850 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)	65	ASTM D638
Elongation at Break (%)	15.0	ASTM D638
Young’s Modulus (GPa)	1.30	ASTM D638
Shore Hardness (D)	84	ASTM D2240
Heat Deflection Temp (°C)	62	ASTM D648

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