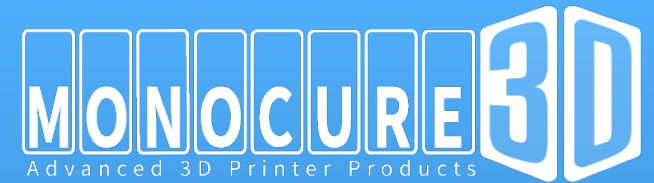


# CHEATSHEET

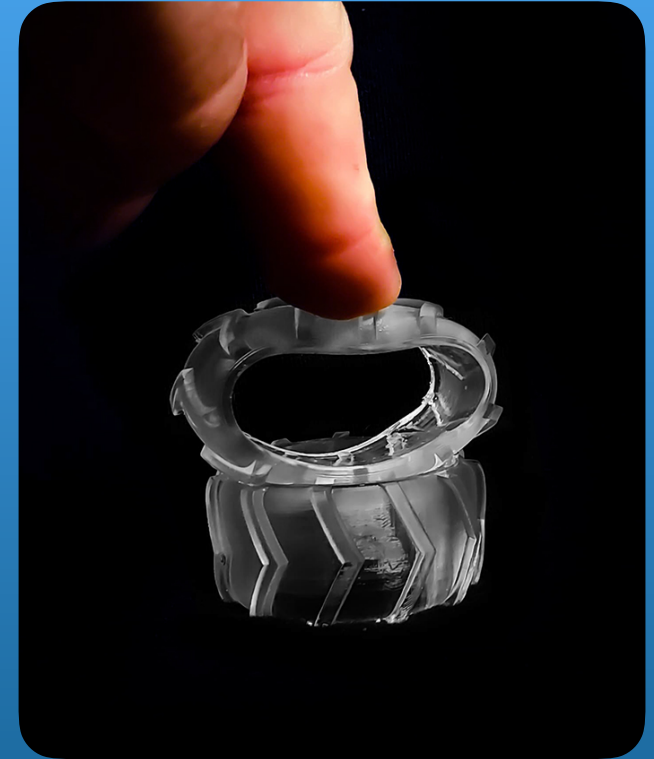
## MONOCURE 3D FLEX100 RAPID RESIN



### Product Description

Congratulations on the purchase of our FLEX100™ Rapid Resin. The FLEX100™ has an extremely high level of flexibility so you can 3D print compressible and bendable models. The clear appearance allows you to see internal structures when 3D printed. This Cheat Sheet will help you get the best out of the Flexible resin when using it with your 3D printer. Please be aware that there are many variable factors with 3D printing & the results may vary depending on your printer, it's settings and your model selection.

The information provided should be enough to get you printing like a PRO in no time. All our products can be purchased directly from our [website](#) or our friendly [resellers](#).



### What should my printer settings be?

Resin Type: Monocure RAPID FLEX100™

Layer thickness: 0.05 (mm)

Normal exposure time: 7-18 seconds\*

Wait after print: 1 second

Bottom Exposure Time: 60 seconds

Bottom Layers: 4

\* These settings are a guide only as your environment & printer can change the way the resin reacts when cured.

### How do I get the best results?

FLEX100™ can be used on its own or by mixing with our Rapid colour range to produce varying degrees of flexibility and firmness. If you are using it neat, remember the thinner the part, the more flexible it will be. So best to use thicker supports with larger tips. By adding a small amount of FLEX100™ to our Rapid resin, you would create a less brittle and more durable part. By adding more significant amounts of FLEX100™, the more flexible it will become.

To results can be repeated, remember to use scales to weigh the resins. We recommend you make 100 grams at a time to keep the ratios simple. For example, for a firm, durable resin try 25:75 mix - 25 grams of FLEX100™ to 75 grams of Rapid resin. For a very flexible version, you could try 80:20 mix 80 grams of FLEX100™ and 20 grams of Rapid.

NB: When mixing FLEX100 with RAPID RESIN please ensure that you cure for a long enough time to fully cure the flexible resin. This is a slower curing resin and takes more UV exposure to fully cure. Although the part might look perfectly formed, if it hasn't been cured for long enough, cracks may appear over time.

### How should I handle the resin?

- \* Shake the bottle well before every use.
- \* Store the resin in a dark cool place.
- \* Clean parts and spills with [RESINAWAY](#) or IPA.
- \* Filter resin back into the bottle when not printing.
- \* Post-cure using a 405nm light to avoid yellowing.

### Important things to remember!

- ★ Only mix with Monocure Resins
- ★ If mixing, use longer layer times
- ★ Use thick supports and tips
- ★ Thin parts = more flexibility
- ★ Thick parts = less flexibility
- ★ Use scales to weigh resins
- ★ Add CMYK pigments for colour

Having Problems? Download our [Calibration Models](#) yet. Please contact us on our website