GETTING STARTED GUIDE

This Getting Started Guide provides useful information to get the best experience from our resins and includes handling of the materials, safety and general information. Visit garrecoprint.com for Support and Frequently Asked Questions or contact us at info@garreco.com if you have questions.

1. General Information

This Guide contains useful information to get started with Garreco Print 3D resins. The table below explains the symbols you will find on the product label.

Liquid waste and contaminated towels should be treated as chemical waste.

Keep bottles and resin out of direct (sun) light.

Resin and packaging should not be stored below 5°C or above 30°C for a longer period.

1000G This bottle contains 1000 grams of resin when un-used.

This resin is designed to be printed at 25 to 100 micron layer thickness.

Shake bottles properly before use.

This sign indicates if a resin is designed to be printed on LCD/MSLA (Liquid Crystal Display), and DLP (projection-based) or laser-based 3D printers. Ideally within the range of 385-420 nm.

2. Resin Handling

Shake the bottle for at least 1 minute before use. After shaking leave the resin to rest for 10 minutes to let air bubbles escape. The resin can be poured back into the bottle after use. Check the resin for residual pieces of polymer before pouring back the resin in the bottle. Always use protective measures when handling Garreco Print resins. Extended safety instructions can be found in the product Safety Data Sheets at https://garrecoprint.com/support.

3. Compatible 3D Printers

Most of our are resins categorized as either LCD and DLP, or SLA and DLP. The resins in the LCD category have a higher reactivity to generate higher print speed on low power 3D-printers. A wide range of 3D printers have been validated with Garreco Print, which includes the Shining3D, UnionTech, Asiga, Anycubic Photon, Kudo3D Bean, Phrozen and many more. A full list of compatible printers plus the latest settings are available on our website at https://garrecoprint.com/printer-compatibility.

4. Support Settings

Rigid polymers like Model 3D Ultra are easy to print and usually only need medium supports.

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5. Post-Processing

Proper post-processing is necessary to get the optimal properties out of your prints. Read more information about our recommended post-processing at https://garrecoprint.com/post-processing.

Post-processing includes rinsing a maximum of 6 minutes in resin cleaner, IPA or (bio)ethanol, preferably ultrasonic or under agitation. Make sure the parts are dry before post-curing, by placing the parts in a well ventilated area for at least 30 minutes or use pressurized air for 2 minutes for Ethanol and IPA. The last step includes curing in a high-power UV curing chamber. The latest post-curing instructions are available on our website at https://garrecoprint.com/post-curing.

Caution: Green parts could break or crack if they are exposed to solvents, resin cleaner, (bio)ethanol, IPA for longer than 20 minutes. Flexible and tough resins could crack even after soaking 10 minutes of Ethanol/IPA.

Caution: Green parts need to be completely dry before post-curing. Curing wet and or sticky parts can lead to parts with surface defects.

Caution: Using a low-power curing unit can lead to inferior part properties.

Caution: Always use protective measures when handling Garreco Print resins or green parts. Parts are safe to touch without gloves after proper post-processing.

Caution: UV post-curing of flexible resins are best to be executed in glycerin, water or nitrogen atmosphere to prevent sticky surface after curing.

6. Safety

Garreco Print resins and green parts should always be handled with care using the advised precautions such as gloves, glasses and protective clothing. Discard all disposables that have been in contact with resin as chemical waste. Check the Safety Data Sheet at https://garrecoprint.com/support for more information.

6.1. Spill Cleaning Protocol

Spilled resin can be cleaned with standard rinsing solvents like (bio)ethanol or IPA. Treat paper towels with resin as chemical waste.

7. Storage and Transport

Garreco Print resins should be stored in the original package in a dark and dry area between 41°F and 86°F (5°C and 30°C). Close the packaging after every use. For transport, the resins should not be exposed to temperatures above 140°F (60°C) to ensure usability within the expiry date.

8. Plastic and Packaging Waste

Fully polymerized Garreco Print resins can be treated as plastic waste and are not harmful for the environment. Liquid residue (washing solvent and contaminated papers included) should be treated as chemical waste and disposed as such. Cardboard packaging can be recycled.