



Introduction

The Crestaform® Open is a rapid prototyping 3D printing resin for fabrication of high-resolution models and rapid prototyping. Crestaform Open is a universal 3D printing resin, being compatible with a wide range of resin 3D printers (LCD, SLA, DLP) including Formlabs, Asiga, Anycubic and Elegoo machines.

Crestaform® Open comes with the following benefits:

- Excellent mechanical performance
- High reactivity and printing speed
- Rigorously tested to ensure optimal performance
- Globally available technical support
- Reputable manufacturer with over 100 years of experience and expertise

Typical printing parameters*

Printer Type	LCD	DLP	Formlabs (SLA)
Printer Wavelength (nm)	405	385	405
Layer Height (µm)	<25 - 50	<25 - 50	25, 50, 100
Printing Temperature (°C)	18 - 30	18 - 30	18 - 30
Base Layer Exposure Time (sec)	50 – 70 ¹	15 – 20 ²	Formlabs Grey V4
Normal Layer Exposure Time (sec)	14.0 - 20.0 ¹	4 - 7 ²	Formlabs Grey V4

¹ Printed using a light power of 2.3 mW/cm²

² Printed using a light power of 5.0 mW/cm²

* It is recommended that 3D resin exposure finder test prints are undertaken to find optimum cure settings

Recommended cleaning

- Soak the print in a clean isopropanol (IPA) (or similar solvent) bath for a minimum of 5 minutes. Alternatively, rinse the part with IPA until all the visible uncured resin has been removed. Reusing IPA in multiple cleans can reduce the cleanliness and clarity of a print
- Leave the print to dry off any residual solvent prior to post-curing

Recommended post-curing

- Post-cure as soon as possible after completion of printing
- Post-cure every print for a minimum of 10 minutes under a dedicated curing UV light operating at 405nm wavelength. Alternatively, leave the print to cure for a minimum of 2 hours under direct sunlight.
- For Formlabs printers follow Formlabs recommended postcure time (30 or 60 min.)
- Temperature-assisted UV curing will increase the rigidity of the print

Instructions to use the Crestaform® Open resin:

- Always shake or mix the resin thoroughly before use. This is especially true for Crestaform Open as pigment heterogeneity will affect print quality
- Open the container and pour the appropriate amount of resin into the tank according to the size of the printer model
- Make sure to not spill the resin onto the printer, LCD screen or anywhere outside of the resin tank
- If not used for a long time, please filter the resin and pour the resin into the storage container



Physical properties

	Values	Description
Viscosity (Poise)	6.0 – 8.0	ICI Viscosity @ 25°C
Liquid Density (g/cm ³)	1.08 –1.10	-
Colour Options	-	Grey

Mechanical properties

Typical properties below: Mechanical Testing Specimen Print Orientation - 50°

	Values	Description
Tensile strength (MPa)*	69	ISO 527-2 Type 5A
Tensile modulus (GPa)*	3.3	ISO 527-2 Type 5A
Elongation at break (%)*	4.5	ISO 527-2 Type 5A
Flexural strength (MPa)*	111	ISO 178
Flexural modulus (GPa)*	2.5	ISO 178
Hardness (Shore)*	83D	ISO 868
Heat deflection temperature (°C)*	55	ISO 75-2, Method A (1.8 MPa)

* 16 mins at 60°C + 405nm UV Post Cure for cured properties

Compatibility

Crestaform® Open has been designed to work with any UV LCD, DLP and SLA 3D printer that is open to 3rd party resins, including, but not limited to:

- Anycubic
- Elegoo
- Phrozen
- Creality
- Asiga

In addition, Crestaform® Open has also been optimised to work on Formlabs machines.



Crestaform®

High performance 3D printing resins



Do

- Always wear Personal Protection Equipment (PPE), protective eyewear and chemical nitrile gloves when handling resin
- Shake the resin well every time before you use it or decant from the container
- If spilled, please clean the spill immediately with paper towel, and Isopropanol (IPA)
- Store it in its original container at room temperature, away from children, untrained personnel, direct or indirect sunlight, heat sources, sparks and open flames
- Use it in well ventilated rooms
- Use every sensible preventive precaution to avoid skin contact, spillage of resin, eye contact or swallowing. Make note of Local Poison Centres availability

X Do not

- Expose resin to direct or indirect sunlight, UV light, heat sources, sparks and open flame while handling and storing the resin
- Touch the resin with bare hands. Always wear appropriate gloves. If skin contact occurs, wash it with soapy water. If you feel unwell, please consult immediately medical assistance
- Swallow the resin or printed objects
- Expose to children or pets
- Handle before completing training
- Expose persons sensitive to the resin components – please see Material Safety Datasheet
- Inhale the resin fumes. Use only in well ventilated rooms or areas
- Pour the resin or used IPA into the draining system

Storage

Crestaform® Open should be stored in the dark, in suitable, closed containers. It is recommended that the storage temperature should be between 15°C and 35°C. Ideally, containers should be opened only immediately prior to use. Keep out direct light/sunlight.

Packaging

Crestaform® Open is supplied in 1000 g bottles. Bulk supply available.

Health and safety

Please see separate Safety Data Sheet.

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