SIRAYA Tech

Shake the bottle and mix the resin in the vat before start printing!

Fast - Navy Grey requires 20% exposure than other Fast, click to visit Navy Grey User Guide

User Guide for Fast

For other resin user guides, please visit https://siraya.tech support section

Fast is an affordable fast curing and non-brittle general application resin ideal for model making like tabletop minis, and figurines.
It is not a tough or engineering resin but can be mixed with Blu/Tenacious for more impact resistant.

While the ideal printing condition for Fast is over 20C, we have printed as long as 15C as long as the bottom layers uses more exposure time
Fast is designed for MSLA printer in mind. It can work in DLP and laser SLA printer but you would need FEP film based vat
Best print with recommended support setting, see below

Exposure (For all Fast colors except Navy Grey) Fast Navy Grey user guide here: Navy Grey User Guide

	Recommended	Resin Temperture 25-35C			Room temperature 20-25C			
Printer	Layer Height	Exposure (s)	# of Initial Layers	Exposure for Init Layers	Exposure (s)	# of Initial Layers	Exposure for Init	Note
Photon	50um	10 (s)	4	60 s	11(s)	6	60 s	
Peopoly Phenom	use Peopoly Deft profile for your printer type in Chitubox							
EPA X1	50um	7.5 (s)	4	45 s	8 (s)	6	50 s	
EPA X1	100um	12 (s)	4	75 s	12 (s)	6	90 s	
Shuffle	50um				7.5(s)	5	60 s	
Shuffle XL	50um				11(s)	5	75 s	
Phrozen Transform	50um				8(s)	5	60 s	due to variation in light system in Transform, best to calibrate your resin for your machine in your environment using this https://www.thingiverse.com/thing:4280278
Peopoly Moai	50um 100um				laser power 50			Only FEP vat. 50 is conservative, some print at 48-49
D7	50um				8(s)	5	60 s	
Inkspire	50um				11 (s)	6	75 s	Inkspire does not specify its light output, one user told us it is very closely to Photon
Photon S	50um	8s	5	60s	8s	5	60s	
Mars	50um	8 (s)	4	50 s	8 (s)	4	50 s	
Mars Pro	50um	6.5s	4	40s	6.5s	4	40s	
SL1	50um	6s	10	40 s	7s	10	45 s	

Recommend best support settings:

We recommend medium preset support setting in chitubox for smaller prints. Heavy support for large prints on large priners
If you don't use chitubox, at least download a copy and see the detail settings for each preset and copy them over to your software of choice

Cleaning:
Use a painter brush (or any brush made with hair) remove excess resins on the printed part with Use 95% concentrated Ethanol (preferred) or IPA to clean. Some form of methnol should work but make sure it does not contain acetone.
Do not submerge the parts in alcohol for more than 30 seconds. After 2-3 minutes of cleaning action, remove alcohol with a hair dryer or air blower. For complex part with lots cavities, it may be a good idea to clean/dry multiple times.
User can check by touching the dryed surface of the part to see if it is still sticky. If the dryed surface is still sticky, wash some more and dry again.

Post Curing:
Fast reached its optimal strength when the printed part is post-cured with UV after cleaned. Use 395-405nm UV light and cure for about 1-2 minutes.
Make sure resin is completely cleaned off and there is not alcohol left (it needs to be dry) on the print before curing.
It is important to dry the print made by Fast completely before post curing. There is no need to use submerge in water technique with Fast.

Mechanical Properties
Shore D 72
Tensile Strength 33Mpa
Young's Modulus 800Mpa
Elongation At Break: 6%
Viscosity: 100cps
Heat Deflection Temperature: 68C
MSDS
https://drive.google.com/open?id=1lWqnHnGQKKKlNFQRnKpSpGX_4cuvIxrP