Guides for Siraya Tech Resins

SOURCE:
https://support.zortrax.com/siraya-tech/

Table Of Contents

Properties

- **Tensile Strength** – 44 MPa
- **Young’s Modulus** – 1500 MPa
- **Elongation At Break** – 25%
- **Hardness** – 85 Shore D
- **Heat Deflection Temperature** – 75° C
- **Shrinkage** – 6% by volume

Features

- Great for making functional parts,
- Fast and easy to print. Best when resin temperature is above 25° C,
- Smooth surface with great resolution,
- Easy to wash, post-cure, paint and sand.

Post-processing

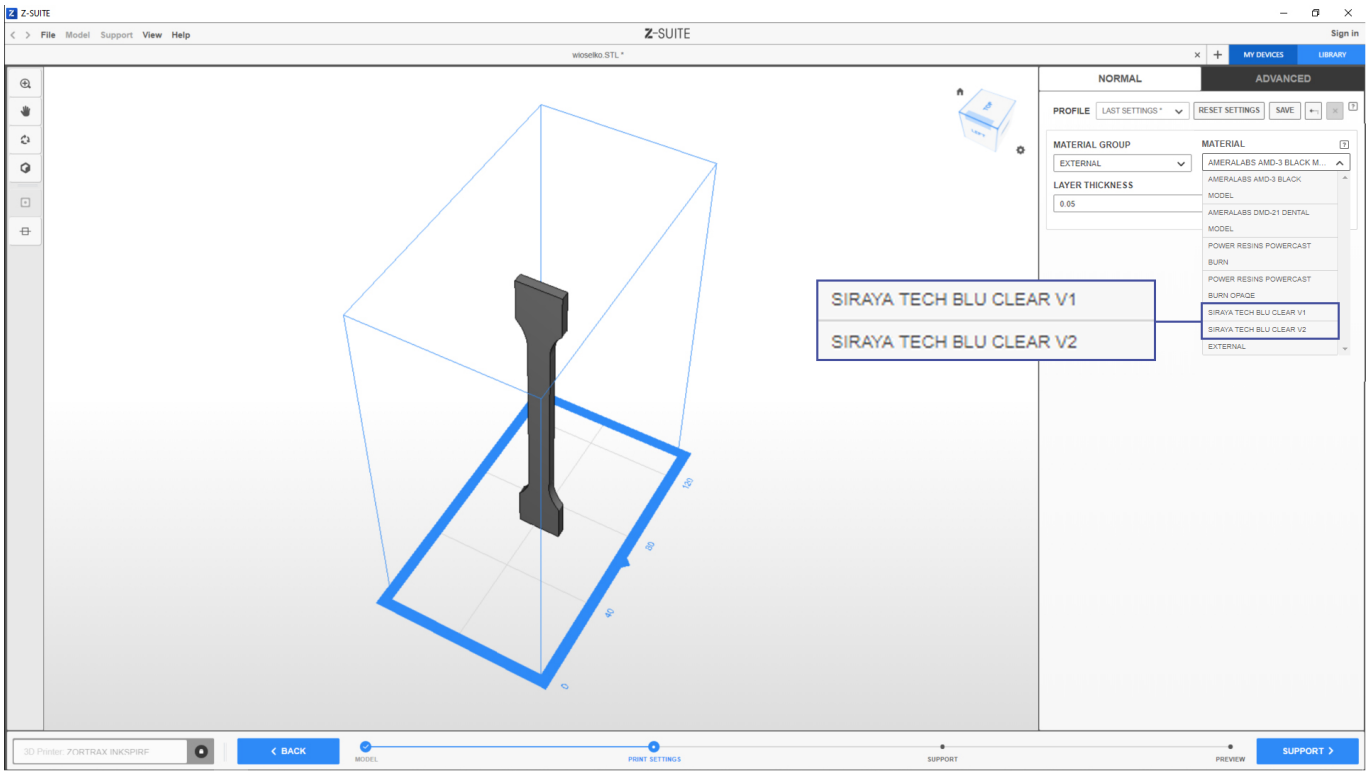
Cleaning:

- Remove excess resin from the printed part with a painter brush (or any brush made with hair) and 95% concentrated Ethanol (preferred) or IPA. Some form of methanol 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, remove alcohol with a hair dryer or air blower. For complex parts with a lot of cavities, it may be a good idea to clean/dry multiple times.
- You can touch the dried surface to see if it is still sticky. If the surface is still sticky, repeat washing and drying again.

Post-Curing:

- Blu resin reaches its optimal strength when the printed part is post-cured with UV light after cleaning. Use 395-405nm UV light and cure for about 15 minutes.
- Make sure the resin is completely cleaned off and there is no alcohol left on the print before curing (the print must be dry).
- Submerging the object in water will significantly increase curing efficiency.

Print settings



First, change the *Material group* to *External*, and then select the *SIRAYATECH BLU CLEAR v1* or *SIRAYATECH BLU CLEAR v2* from the drop-down list.

Next, set the *Layer thickness* with which you are going to print your model. This parameter determines the height of each layer. Finer layers provide better surface quality but make the printing process more time-consuming.