
1. Introduction

This Instructions for Use (IFU) is intended for users of 3D printing technology who utilize **Structomer[®] Water Washable Resin** to manufacture a wide range of printed items. These may include **hobby crafts, functional prototypes, snap-fit parts, and end-use components**. Structomer[®] Water Washable Resin is a high-performance photopolymer resin formulated for easy post-processing using tap water. This IFU also includes important information on proper handling, safety, and environmental considerations. For detailed safety data, please refer to the Material Safety Data Sheet (MSDS) available at www.structo3d.com or through your authorized distributor.

2. Intended Use

Structomer[®] Water Washable Resin is a **light-curable photopolymer** designed for use in **3D printing** of a variety of items, including **hobby crafts, assembly components, and visual models**. These printed parts may serve functional, aesthetic, or illustrative purposes, such as aiding in the **design, planning, and production** of various products, or supporting **creative and recreational activities**.

3. Contraindications

- Not for intraoral use or contact with mucous membranes.
- For **single-use only**.
- Discontinue use in case of **allergic reaction**. Seek medical advice.

4. Safety Precautions

- Always wear **nitrile gloves, safety goggles, and a lab coat** when handling the resin.
- Refer to the MSDS for comprehensive safety guidelines.
- Resin contains substances that may cause skin/eye irritation or allergic reactions. Use in a well-ventilated area.

5. Hardware Compatibility

Structomer[®] Water Washable Resin is compatible with MSLA Structo Dentaform, **DLP, and LCD-based 3D printers** that support Structomer[®] materials. For an updated list of validated hardware, contact Structo.

Follow your printer manufacturer's guidelines for **exposure settings, layer thickness, and support placement**.

6. Printing Process

Step 1: Prepare

- Ensure the printer is compatible with Structomer[®] Water Washable Resin.
- Load the appropriate cloud profile and define supports if needed.

Step 2: Shake

- Shake the bottle vigorously for **2–5 minutes** before use.
- Pour resin into the printer tank up to the maximum fill line.
- Stir resin in the vat before each print for homogeneity.

Step 3: Print

- Print according to your print files throughout the platform per cycle, as needed.

Step 4: Remove

- Detach the build platform from the printer.
- Use a razor or spatula to carefully remove prints from the build platform.

Step 5: Clean

- Soak printed parts in clean **tap water** for **10 minutes**.
- Use fresh water for every wash cycle to avoid contamination.

Step 6: Dry

- Dry the printed parts with **natural dry air**, allow to air dry completely.
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7. Post-Curing

Formlabs Form Cure, Fisrt Gen.: 5mins at 60 OC

Light Source: 13 multi-directional LEDs

LED Power: 39 W

LED Radiant: 9.1 W

LED Wavelength: 405 nm

No vacuum or inert gas environment is required.

- **Metal Halide Lamp PCU:** 1 minute
- **405 nm LED PCU (at 60 °C):** 5 minutes
- **UV-A (315–400 nm) + UV-Blue (400–550 nm) PCU:** 15 minutes

Remove models immediately after curing.

8. Handling & Storage**Delivery**

Check upon receipt:

- Integrity of the packaging and bottle.
- Intact seal.
- Correct quantity and matching shipping documents.
- Use-by date is valid.

Storage

- Store in **original, sealed containers**.
 - Keep away from **sunlight and UV exposure** to avoid premature curing.
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9. Repeat Use Note

- Before reuse, **top up the resin** to the max line and **mix remaining resin manually**.
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10. Hazard Information**Hazard Statements**

- H302: Harmful if swallowed
- H314: Causes severe skin burns and eye damage
- H315: May cause skin irritation
- H317: May cause allergic skin reaction
- H319: Causes serious eye irritation
- H361: Suspected of damaging fertility or the unborn child
- H411: Toxic to aquatic life with long-lasting effects

Precautionary Measures

- P202, P261, P264, P272, P273, P280: Refer to label for full prevention instructions.
 - P302+P352, P305+P351+P338, P304+P340, P337+P313, P312: For emergency measures.
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11. Disposal

- Liquid resin is hazardous. Dispose of unused material and containers at **authorized hazardous waste facilities**.

- Contaminated items should be treated as chemical waste.
 - Follow **local and national regulations** for disposal.
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15. Legal Notice

Structo assumes no liability for misuse of this product, including:

- Use of non-validated equipment
 - Deviation from the instructions provided Such actions may affect the performance, safety, or effectiveness of the final restoration.
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16. Packaging Information

Available Variant: Color: Clear

Unit Size: 1 kg bottle

17. Label Symbols



Warning



Use-by date



Consult Instructions for use



Manufacturer



Batch Code



Keep away from sunlight

17. Contact Information

Distribution & Manufacturer

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