



Explore endless creativity with the Tiger 3D

## Orange Resin – Technical Data Sheet

### Photopolymer resin for direct investment casting

Tiger3D Orange 78-5003 is a Photopolymer resin suitable for direct investment casting in jewelry. The resin can be like normal casting wax and specifically formulated for producing investment casting in accurate patterns.

#### General Specifications:

Liquid Properties		
Parameter	Condition	Specification
Appearance	---	Orange
Viscosity	ASTM D2983	83CPS @ 28°C
Density	ASTM D1475-60	1.12 G/ML @ 25°C
Mechanical Properties		
Hardness	ASTM D2204-05	50 Shore D @ 25°C

Suggested curing time for the Tiger3D Printer per layer:

- Thickness 40um : 3.5 sec
- Thickness 50um : 6.0 sec

#### Applications:

This is used for direct investment casting as well as lost wax casting process.

#### Packaging:

The Tiger3D Orange Resin 78-5003 is packed in 250 gram black plastic containers.