



TECHNICAL DATA SHEET
REVISION: 0
DATE: 20/01/2022



KLEBENRAD PU 50

3D PRINTING RESIN

CHARACTERISTICS

DESCRIPTION

KLEBENRAD PU 50 is a high-quality rigid polyurethane resin for 3D printing. Sensitive to 405nm UV wavelength.

Compatible with most DLP/LCD 3D printers.

PHYSICAL PROPERTIES

Norm

Shore D hardness **50**

MAIN FEATURES

- **Rigid finish**
- **High tenacity**
- **Low yellowing**
- **High print speed**
- **High chemical resistance post curing**
- **Color range**
- **High finishing precision**
- **Sharp and defined edges**
- **Mind odor**
- **Solvent free**
- **Low toxicity**
- **Easy to clean with Isopropanol**

PRINTING PARAMETERS

- Layer thickness recommended between 50 – 100 microns per layer.
- Exposure time recommended between 5 – 10 seconds, depending on the thickness of the layer.
- The first 6 layers are recommended with a minimum thickness of 50 microns and an exposure time of 30 seconds per layer to secure the model to the printing platform. For large pieces, increase the number of layers.
- Minimum distance of rise/fall of the axis between layers: 10 mm.
- Minimum delay time before exposure: 2 seconds.

POST CURING PARAMETERS

- Between 15 and 30 minutes, with a 200 W 405 nm UV LED light, depending on the thickness and color of the piece.

RECOMMENDATIONS

- Shake well before use to homogenize the content.
- Recommended temperature: 20 – 25 °C. At lower temperatures the viscosity of the resin will increase and make the printing process more difficult.
- Always wear gloves, in case of staining the skin, wash it with plenty of warm water and soap.
- Use it in well-ventilated areas.
- Store protected from direct sunlight and keep it out of the children`s reach.
- If the resin inside the printing tank is not going to be used for a long period of time, it is recommended to pour it into the original container using a fine filter to prevent remains of polymerized resin or contamination. After, close the container and store it in a clean and dry place.
- Keep the machine's protective cover protecting the print reservoir, even when printing is not working.

SUPPLY/ STORAGE

In recyclable plastic containers of 0.5, 1 and 5 kg.

It can be stored for 1 year in its original closed container.

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