



EVOCURE

CAST PRO

User Manual

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PRODUCT DESCRIPTION

EVOCURE CAST PRO is intended as dental casting material suitable for 3D printing all types of castable parts, utilizing both 385nm and 405nm LDC and DLP 3D printing technologies.

BEFORE USE

- This guide provides instructions for printing, post-processing, handling, and safety precautions to ensure safe and effective use of this material.
- Before starting a new print job, it's recommended to thoroughly mix the resin. If resin has settled in the vat, gently stir it with a silicon spatula. For resin bottles, use an automated roller for 15 minutes. If the resin has been stored for a longer period of time, roll the bottle for 30-45 minutes.
- Wear personal protective equipment like gloves, safety goggles, and protective clothing when handling EVOCURE resins.

PRINTING

- Prepare your model using slicing software compatible with your printer. Choose appropriate settings for the resin and printer. Find necessary profiles and instructions at www.syntegre.com
- Ensure your workspace is clean and properly calibrated. Fill the tray between the maximum and minimum levels.
- After raising the platform, let it drip for about 10 minutes.
- You can reuse remaining resin in the tank. Use a filter to remove cured particles and avoid print failures. Pour filtered resin back into the bottle.

WASHING

- Clean resin-coated parts in a two-step process using at least 97% isopropyl alcohol (IPA) or at 96% denatured alcohol (ethanol).
- For effective cleaning, consider using ultrasonic units in a well-ventilated area. Alternatively, clean in separate beakers for about 2 x 3 minutes each.
- If cleaning is insufficient (e.g., shiny areas remain after drying), repeat the process. Use a soft brush moistened with cleaner to remove resin residues.
- Do not exceed a total cleaning time of 6 minutes, as it may damage printed objects.

DRYING

- After washing, remove parts and allow them to air dry at room temperature, or use compressed air for faster drying. Dry times may vary based on part design and ambient conditions.
- Inspect printed parts to ensure no residual solvent, excess resin, or residue particles remain before proceeding to post-curing.

POST-CURING

- This product does not require post curing, only if necessary, no longer than 1 minute.

SUPPORT REMOVAL

- Once cured, peel off large irrelevant areas and then use flush cutters or pliers to remove supports where precision and surface quality are crucial.
- Wear eye protection during support removal to prevent resin from flinging into your face. Proper support settings in your slicer can speed up this process. Refer to www.syntegre.com for more information.

CASTING PROCESS

- EVOCURE CAST PRO can be used in combination with most common dental investment materials, particularly with specifically designed for casting 3D prints.
- General guidelines for metal casting should be followed, with special attention to the parameters and recommendations provided by the manufacturer of used investment material and metal.
- EVOCURE CAST PRO has been tested with materials such as Hinvest RP, Heravest M print+, VarseoVest C&B, VarseoVest P plus, Picocast Speed NF, and Sheravest RP.
- For more details and guidance on casting, refer to the brochure on 3D Printing in Casting.

STORAGE & DISPOSAL

- Store resin bottles between 15-25°C and observe the shelf life printed on the label. Store in tightly closed containers in a well-ventilated, dry area away from sparks and flames.
- Before disposal, fully polymerize by exposing to irradiation. Dispose of contents/container according to official regulations.

HAZARDS IDENTIFICATION

- In uncured form, EVOCURE MODEL and MODEL PRO are sensitizers. When washing with solvent or grinding, do so in a well-ventilated area with proper protective equipment.
- Hazard and safety information can be found on the product label and safety data sheet (SDS).

LOT NUMBER / EXPIRY DATE

- Shelf life is 2 years from production, indicated on each EVOCURE resin packaging.
- When making claims, always provide the product's lot number. Do not use the product after the expiry date.

LABEL SYMBOLS



See the information about the resin on the website
www.syntegre.com



Store in a dark, dry place away from sun and heat sources.



Store the resin at the right temperature.



Mix the resin well before pouring it into the printer tray.

CONTACT INFORMATION

For product support, refer to the information available to you on the website: www.syntegre.com or write to us at: support@syntegre.com



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