Version: 1.0
Last update: 15-12-2022

PRUSA POLYMERS by JOSEF PRUSA

Technical datasheet

Prusament Resin Flex80 Transparent Clear by Prusa Polymers

Identification

Name	**Prusament Resin Flex80 Transparent Clear**
Manufacturer	**Prusa Polymers a.s., Prague, Czech Republic**
Usage	**3D printing**

Recommended print settings

Layer height [mm]	Printing time SL1 [s]	Printing time SL1S [s]
0.025	10	4
0.05	15	5
0.1	20	6
First layer	30	15 – 25

Recommended curing after print:
Washing - 3 minutes in isopropyl alcohol (>90%)
Drying - 10 minutes at 45 °C
Curing - 5 minutes minimal, 60 minutes optimal

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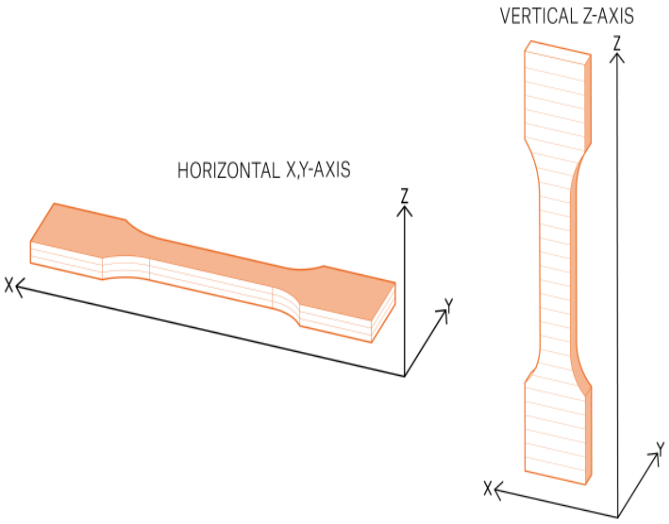
Mechanical properties

Property/print direction	Uncured XY	Cured XY	Method
Tensile strength [MPa]	2.1 ± 0.17	8.87 ± 0.58	ISO 527-1
Elongation [%]	26.25 ± 2	60.25 ± 2.46	ISO 527-1
Tensile modulus [MPa]	9.30 ± 0.06	17.87 ± 1.23	ISO 527-1
Hardness - Shore A	75	82	Prusa Polymers

Viscosity (25 °C)	200 – 400 mPa.s	ISO 2431

Original Prusa SL1 and SL1S Speed 3D printers were used to make testing specimens. PrusaSlicer-2.5.0 was used to create G-codes with the following settings: Prusament Resin Flex80; layer 0,05mm; faded layers: 3; exposure times: 10/30 (SL1), 4/25 (SL1S), without supports and pad; other parameters set the default



Basic safety information

This resin is not meant for contact with food, drinks, or medical use on or in the human body. Always read the material safety data sheet thoroughly.

Resins are classified as dangerous chemicals and must be disposed of properly in designated containers.

Resin bottles (empty or full) must never be disposed of or poured into the general waste.

Manipulation directions

Shake well before use.

Store at room temperature away from direct sunlight.

Use protective equipment for manipulation.

Do not pour the contents of the canister into general waste. Dispose of empty bottles and unused resin at designated places.

Disclaimer:

The results presented in this data sheet are just for your information and comparison. Values are significantly dependent on print settings, operator experiences, and surrounding conditions. Everyone has to consider suitability and possible consequences of printed parts usage. Prusa Polymers corp. can not carry any responsibility for injuries or any loss caused by using Prusament Tough Resin. Before the use of Prusament Tough Resin material read properly all the details in the available safety data sheet (SDS).

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This project is co-financed with the state support of the Technology Agency of the Czech Republic and the Ministry of Industry and Trade within the **TREND Program**.

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