



Build - High Detail Resin

Sonic Grey / Smoky Black

Build Resin: Tappable Precision, Seamless Assemblies.

Build resin combines exceptional high resolution with ultra-low shrinkage, making it the ultimate choice for highly precise fitted models, mold-making masters, and intricate scale trains. Its easy-to-process, low-odor formula strikes the perfect balance between hardness and flexibility.

Ideal for:

- Fitted assemblies
- High-precision models
- Functional prototypes
- Masters for mold making

Property Data

Mechanical Properties	Measure	Method
Tensile Stress at Yield	35	ASTM D638
Tensile Stress at Break	33	ASTM D638
Young's Modulus	850	ASTM D638
Elongation at Break	8	ASTM D638
Flexural Modulus	1450	ASTM D790

Other Properties	Measure	Method
HDT at 0.455 MPa	68	ASTM D648
IZOD Impact (Notched) J	27	ASTM D256
Shore Hardness	77D	ASTM D2240
Solid Density	1.2	ASTM 792
Water Absorption (24hr)	0.75%	ASTM D570

Liquid Properties	Measure	Method
Viscosity at 25°C (77°F)	110	ASTM D7867
Liquid Density	1.1	ASTM D1475

Work Flow

Printing

Material Name	Build - High-Detail Resin (Smoky Black / Sonic Grey)
Primary Printer Compatibility	MSLA / LCD/ DLP 3D Printers
Secondary Printer Compatibility	385nm - 405nm 3D Printers
Hardware Requirement	Access to exposure control is required
Supported Slicer Software	Chitubox, Lychee Slicer, Anycubic Photon Workshop, Blueprint Studio, Elegoo Satellite
Slicer Profiles Download	Siraya Tech Print Settings Download

Clean

Cleaning Step / Category	Instructions & Recommendations
Cleaning Solvents	• Preferred: 95% concentrated Ethanol or IPA. • Alternative: Methanol (must not contain acetone).
Cleaning Time	Submerge parts in the solvents for 2-3 minutes, using the ultrasonic cleaner.
Submersion Limit	Do not submerge parts in alcohol for more than 5 minutes.
Extra Step	For complex model, use a painter brush (or any brush made with hair) to gently remove excess resin from the printed part.

Work Flow

Drying

Drying	Remove alcohol by using an oven for 7-8 minutes (using a hair dryer requires 10 minutes)
	Note: For complex parts with cavities, repeat the clean/dry cycle multiple times.
Quality Check	Touch the dried surface. If it is still sticky, wash and dry the part again until smooth.

Post Curing

Step / Factor	Instructions & Recommendations
Preparation	Ensure the resin is completely cleaned off and absolutely no alcohol is left on the print before curing.
UV Specifications	Use a UV light source with a wavelength of 395-405nm.
Curing Time	Cure for approximately 3-4 minutes to reach optimal strength. Parts must be fully cured before use.
Recommended Method	Direct curing without water for moisture control.