



Siraya Tech

Technical Data Sheet

Siraya Tech Form Laser SLA Resin

Grey



Product Introduction

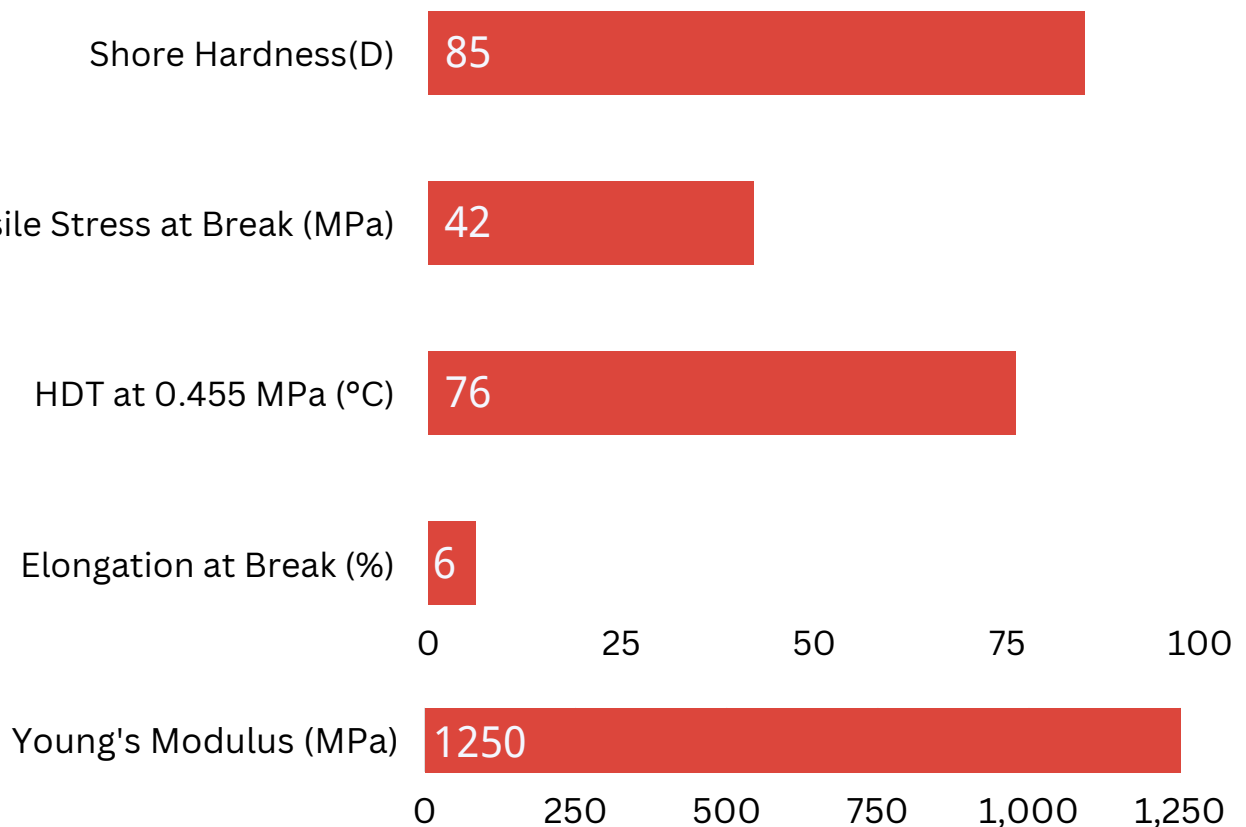
Form Laser SLA Resin

Key Features

- Easy to print
- High Resolution
- Great Surface Finish
- Easy to Clean and Post-process
- VOC-free with no harmful substance
- 12K capable

Application:

- SLA printer like Formlabs and Peopoly Moai
- An affordable alternative to OEM options



Property Data

Mechanical Properties	Measure	Method
Tensile Stress at Yield	40	ASTM D638
Tensile Stress at Break	42	ASTM D638
Young's Modulus	1250	ASTM D638
Elongation at Break	6	ASTM D638
Flexural Modulus	1550	ASTM D790
Flexural Stress at Yield	37	ASTM D790
Flexural Strain at Break	1.3	ASTM D790

Other Properties	Measure	Method
HDT at 0.455 MPa	76	0.455 MPa
IZOD Impact (Notched) J	25	-
Shore Hardness	85D	-
Solid Density	1.15	-
Water Absorption (24hr)	0.5%	-

Liquid Properties	Measure	Method
Viscosity at 25°C (77°F)	380	25°C (77°F)
Liquid Density	1.1	-

Work Flow

Printing

Form resin is an affordable alternative to OEM options, compatible with Photon Ultra DLP and Laser SLA resin printers such as Formlabs and Peopoly Moai, and supports 8K resolution. It is designed to work with both PDMS and FEP vats commonly found in laser printers.

To achieve optimal results with Form Laser SLA Resin, you need to use the appropriate slicer profiles for your printer model and software. You can download the slicer profiles for Chitubox and Lychee slicers from this link: <https://siraya.tech/pages/print-settings-download>

Clean

Here are some tips for cleaning your printed parts:

- Use a painter brush (or any hair brush) to remove excess resin from the printed part.
- Clean the part with 95% concentrated Ethanol or IPA for 2-3 minutes, then dry with a hair dryer or air blower.
- For complex parts with cavities, consider multiple cleaning and drying cycles. Check for stickiness by touching the dried surface.
- Sanding is easy with Form. Use 1000-grit sandpaper and mineral oil or water. Mineral oil adds luster.

Post Curing

Here are some tips for post-curing your printed parts:

- Form achieves optimal strength when the printed part is post-cured with UV light after cleaning.
- Use 395-405nm UV light and cure for about 15 minutes. Ensure the resin is completely cleaned off and the print is dry, with no alcohol residue.
- Submerging the object in water during curing significantly increases curing efficiency.