

Neo Resin by Peopoly


Prepare Printing on Phenom:


Heavy support for large prints. It is best to use Chitubox 1.6.4.3 Beta or new as there were support boxes in earlier versions.


Wall thickness: >1.5mm


Recommended Exposure for Phenom


Phenom - Neo - 50um

















Machine	Resin	Print	Infill	Gcode	Advanced
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Layer Height:

0.05

mm

Bottom Layer Count:

6

Exposure Time:

10

s

Bottom Exposure Time:

50

s

Light-off Delay:

0

s

Bottom Light-off Delay:

0

s

Bottom Lift Distance:

8

mm

Lifting Distance:

8

mm

Bottom Lift Speed:

32

mm/min

Lifting Speed:

48

mm/min

Retract Speed:








150

mm/min

Phenom L

Neo Resin by Peopoly

Phenom L - Neo - 50um



Machine	Resin	Print	Infill	Gcode	Advanced
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Layer Height:

0.05

mm

Bottom Lift Distance:

12

mm

Bottom Layer Count:

6

Lifting Distance:

8

mm

Exposure Time:

7

s

Bottom Lift Speed:

32

mm/min

Bottom Exposure Time:

50

s

Lifting Speed:

45

mm/min

Light-off Delay:

0

s

Retract Speed:

150

mm/min








Bottom Light-off Delay:

0

s

Phenom Noir

Phenom Noir - Neo - 50um



Machine	Resin	Print	Infill	Gcode	Advanced
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Layer Height:

0.05

mm

Bottom Lift Distance:

8

mm

Bottom Layer Count:

5

Lifting Distance:

8

mm

Exposure Time:

1.5

s

Bottom Lift Speed:

36

mm/min

Bottom Exposure Time:

20

s

Lifting Speed:

45

mm/min

Light-off Delay:

0

s

Retract Speed:

150

mm/min

Bottom Light-off Delay:

0

s

Cleaning:

Use a hair based brush like painter's brush to remove excess resins on the printed part with Use 10% or higher concentrated Ethanol (preferred) or IPA to clean. Do not submerge the parts in alcohol for more than 30 seconds. After 2-3 minutes of cleaning action, remove alcohol with a hair dryer or air blower. For a complex part with lots cavities, it may be a good idea to clean/dry

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multiple times. User can check by touching the dried surface of the part to see if it is still sticky. If the dried surface is still sticky, wash some more and dry again.

We don't recommend the use of ultrasonic cleaning devices unless your print has a very recessed area that cannot be reached. Do not run it over 2 minutes.

Post Curing:

Make sure resin is completely cleaned off and there is not alcohol or water left (it needs to be dry) on the print before curing. This is very critical for long term use of print. When in doubt, use a hairdryer.

Use 395-405nm UV light and cure for about 1 minutes. Do not use 365nm light as it will cause quick yellowing. There are many counterfeit UV LED that claimed to be 405nm but is actually 385 or 365nm. Best to acquire a UV LED fixture from a trusted source.

Mechanical Properties

Shore D 85

Tensile Strength 33Mpa

Young's Modulus 460Mpa

Elongation At Break: 4.3%

Viscosity: 53 cps

Heat Deflection Temperature: 60C

[MSDS for Neo](#)