

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: >2.5mm

Recommended Exposure for Phenom

Phenom - Deft - 50um

Machine Resin **Print** Infill Gcode Advanced

Layer Height:	0.05 mm	Bottom Lift Distance:	12 mm
Bottom Layer Count:	6	Lifting Distance:	10 mm
Exposure Time:	12 s	Bottom Lift Speed:	32 mm/min
Bottom Exposure Time:	50 s	Lifting Speed:	48 mm/min
Light-off Delay:	0 s	Retract Speed:	150 mm/min
Bottom Light-off Delay:	0 s		

Phenom L

Phenom L - Deft - 50um

Machine Resin **Print** Infill Gcode Advanced

Layer Height: 0.05 mm Bottom Lift Distance: 15 mm

Bottom Layer Count: 6 Lifting Distance: 10 mm

Exposure Time: 8 s Bottom Lift Speed: 32 mm/min

Bottom Exposure Time: 70 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 - Deft - 50um

Machine Resin **Print** Infill Gcode Advanced

Layer Height: 0.05 mm Bottom Lift Distance: 8 mm

Bottom Layer Count: 6 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 75% 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 complex part with lots cavities, it may be a good idea to clean/dry 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 device unless your print has 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 it doubt, use a hairdryer.

Use 395-405nm UV light and cure for about 1-2 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 UV LED fixture from a trusted source.

Mechanical Properties

Shore D 74

Tensile Strength 35Mpa

Young's Modulus 750Mpa

Elongation At Break: 6%

Viscosity: 105 cps

Heat Deflection Temperature: 60C

[MSDS for Deft resin](#)