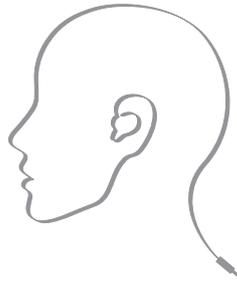


Inear Resin INR-1

Instructions



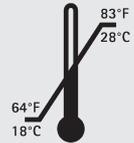
pro3dure
medical

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Product description:
photopolymerizable
resin for production
of earpieces by image
projection systems

Technical data:

- Colour: various
- Density:
ca. 1.1 g/ml
- Viscosity:
ca. 0,7 Pa s
- Post cured
material: (depends
on postcuring unit)
Elastic modulus:
ca. 1700 MPa
Flexural strength:
ca. 90 MPa
Elongation at break:
ca. 10 %
Hardness:
ca. 80 Shore D
- Storage:



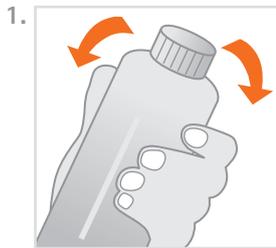
Ordering information:

Standard Packing:
500 g

amber*
item no.: A1000205
olive*
item no.: A1000223
pink-transparent*
item no.: A1000287
smoke grey*
item no.: A1000275
blue-transparent*
item no.: A1000204
blue-grotto transparent*
item no.: A1000214
green-transparent*
item no.: A1000206
neon-yellow translucent*
item no.: A1000283
neon-green translucent*
item no.: A1000281
neon-orange translucent*
item no.: A1000284
neon-pink translucent*
item no.: A1000285
petrol-transparent*
item no.: A1000215
purple-transparent*
item no.: A1000213
purple-transparent B*
item no.: A1000212
red-transparent*
item no.: A1000202
black-opaque*
item no.: A1000226
schwarz-transparent*
item no.: A1000276
white-opaque*
item no.: A1000225
red-opaque*
item no.: A1000208

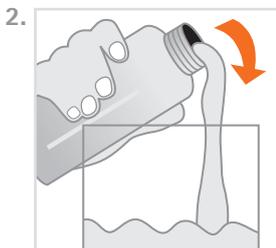
smoke grey-transp. B**
item no.: A1000282
clear-transparent**
item no.: A1000200

These data result from
measurements of a represen-
tative sample, which were
determined within the scope
of our quality assurance.



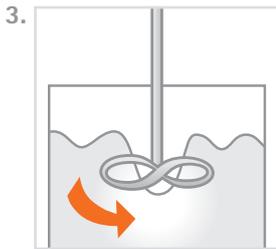
1. Product description

pro3dure's inear resin **INR-1** is a methacrylate based resin for DLP Systems with 405 or 385 nm light source for the production of IEM-shells and ear-moulds. The formulation of **INR-1** is optimized for the requirements of a robust production guaranteeing constant high quality. The **INR-1** is successfully tested for biocompatibility, certainly meets all mechanical and application demands. The material can be used for build processes with layer thicknesses from 10 up to 100 µm. It is recommended to use the pro3dure medical curing device **CD-1** or **CD-2** for post curing.



2. Processing

- **INR-1** bottles should be well shaken before use (fig 1).
- Make sure that **INR-1** material is temperature adjusted up to 23 °C to 30 °C.
- Carefully pour **INR-1** into the vat of the image projection-unit (fig 2).
- Bubbles can be removed with a cleaned spatula or by a recoater routine.
- For the machine parameter adjustment please refer to the Technical Data Sheet.
- After the build process is finished a direct post treatment is recommended. If this cannot be guaranteed leave the produced objects in the liquid **INR-1** resin.
- After cleaning of the parts with isopropanol ≥ 97 % (approx. 3-5 min. in an ultrasonic bath) the objects are postcured in an adequate light curing unit (e.g. pro3dure's **CD-1** or **CD-2** for a period of 3-4 min.) in a protective gas atmosphere (N₂).
- The earmoulds and shells generated out of the generative resin **INR-1** can be coated and repaired as usual. For this purpose the pro3dure products e.g. L-1 UV lacquer are recommended.
- Impurities due to operation mistakes cannot be excluded. With respect to the low viscosity of the resin it is possible to filtrate the **INR-1**. It is recommended to filtrate and stir up the resin on a regular base. If opaque material is used additionally mix the content with a propeller mixer carefully. To avoid bubbles let **INR-1** rest for 30 min. before usage.



Contains: Alkoxilated bisphenole-A-dimethacrylate, initiators, dyes, stabilisers, and pigments

3. Important

- To avoid detrimental effects on material quality do not expose the liquid material to irradiation under any circumstances.
- Deviations from the described manufacturing process may lead to different mechanical and optical properties of the **INR-1** material.
- Ensure personal protective gear during processing.
- Caution: Polymerised resins are chemically resistant - avoid stains on clothing!
- Avoid any contact with skin and eyes. In case of accidental contact, rinse with adequate running water, consulting a doctor if necessary.
- The lot number and the best before date are indicated on each **INR-1** packaging. In case of claims please always indicate the lot number of the product. Do not use the product after expiry of the best before date.

Safety advice

pro3dure medical GmbH is not liable for any damages caused by improper application of the material. To be used by trained specialist personnel for the purpose indicated only.

INR-1

idea to product.

* 385/405 nm
** 385 nm