Using Castable Resin Successfully

Print. Choose 50 micron layers for the best speed, surface finish, and accuracy. 25 micron layers are available for filigree and other complex details.

Post Cure. Post-cure parts for a minimum of 2 hours in a 36 watt, 405 nm cure chamber. Thicker parts may take longer to post-cure.

Prepare. Remove supports and pour investment according to our guide: formlabs.com/jewelry

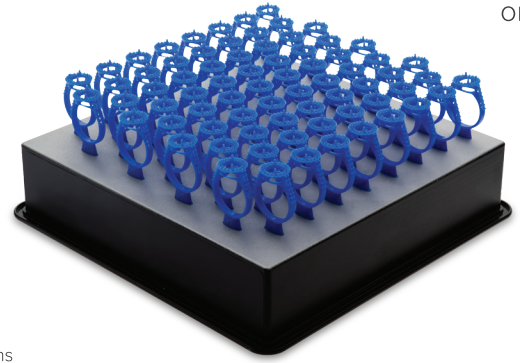
Burnout and Cast. Refer to the burnout curve for temperature settings.

Printing Facts

Castable Resin burns out cleanly without ash or residue and captures crisp, precise detail as well as extraordinary smooth surfaces. Jewelers can go straight from a 3D design to a model suited for direct investment.

1 RING*	COST PER RING
2 h 8 min	$0.12 / €0.10
50 RINGS*	
5 h 8 min	

*Rings printed at 50 microns using Fine Detail Settings.



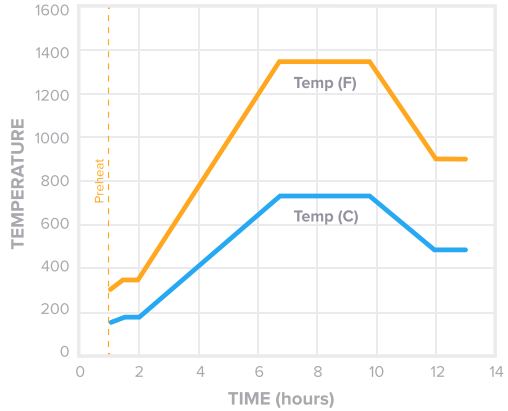
Professional jewelry, 3D printed on your desktop for only $3499.

SourceGraphics

1530 N Harmony Circle Anaheim, CA 92807
sourcegraphics.com
800-791-9042

formlabs

Recommended Burnout Curve



Castable Resin will leave no ash or residue when adhering to the following process.

PROCESS		
PREHEAT	300 °F/h	167 °C/h
INSERT FLASK	300 °F	167 °C
RAMP	100 °F/h	56 °C/h
HOLD	350 °F, 30 min	177 °C, 30 min
RAMP	210 °F/h	117 °C/h
HOLD	1350 °F, 3 h	732 °C, 3 h
RAMP	–200 °F/h	–111 °C/h
HOLD	900 °F/h	482 °C, 1 h

RECOMMENDED INVESTMENT

R&R Plasticast with BANDUST

Castable Resin

Print in Fine Detail for Investment Casting

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