

HORUS

INSTRUCTIONS FOR USE

Product:
Version: 1

HORUS Castable

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1. PRODUCT DESCRIPTION

HORUS Castable is a photopolymerizable resin with low viscosity and high reactivity intended to be used with SLA, DLP or MSLA devices in the range of 365-405 nm. Printed parts offer high dimensional stability for enhanced precision. Furthermore, no residual ash remains after calcination.

2. INDICATION

HORUS Castable is a resin intended to be used by professionals for high-definition castable moulds fabrication.

3. CONTRAINDICATION

HORUS Castable should not be used for purposes other than specified in the previous part (2. INDICATION). Incorrect use and non-compliance with the instructions contained in this IFU may compromise the physico-chemical quality of parts printed from HORUS Castable. HORUS Castable must not be used in case of allergy to any of the components being listed in the safety data sheet (SDS).

4. WARNINGS AND SAFETY INSTRUCTIONS

The following precautions should be taken for HORUS Castable:

- Read and follow the safety data sheet (SDS) before use
- Handling of HORUS Castable including the cleaning step should be done in a sufficiently ventilated room
- When handling HORUS Castable and uncured printed parts, appropriate personal protective equipments (nitrile gloves, protective goggles and clothing) must be worn
- Avoid any contact of HORUS Castable with eyes or skin before the post-polymerization step
- In case of contact with HORUS Castable, follow the recommendations in the safety data sheet (SECTION 4: FIRST AID MEASURES)
- Allergic reactions to components of HORUS Castable may rarely occur
- Spillage of HORUS Castable can be cleaned with standard rinsing solvents such as ethanol or isopropanol
- HORUS Castable must only be used by qualified personnel
- Parts to be printed must be designed using Horus Slicer
- Printing must be carried out from Horus S-One
- Post-processing must be carried out from Clean & Cure S-One

5. PRODUCTION AND POST-PROCESSING

Work in a place as clean as possible. Dirty machine, printing platform or resin tank can lead to print failure and damage the resin tank.

5.1. Designing

Follow the Horus Slicer instruction for use to design parts to be printed with HORUS Castable. Hollow must not be used if post-processing is carried out using the printing platform in order to avoid any failure during post-processing step. In addition, the use of supports is not recommended in this specific case.

5.2. Product handling

Before using HORUS Castable, firmly shake the bottle with a roller bench for at least one hour to redisperse pigments and avoid sedimentation. This step prevents colour change or print failure.

5.3. Filling the resin tank

Pour a sufficient amount of HORUS Castable in the resin tank ensuring the latter is completely clean and free of any residue to prevent print failure or damaging of the resin tank.

5.4. Printing

Follow the Horus S-One instruction for use to print parts with HORUS Castable. Print profiles of the latter can be selected or downloaded from Horus Slicer. Layer thickness can also be selected from Horus Slicer according to precision requirements. The printing platform must be clean to avoid print failure. The flexible plate can be magnetized onto the printing platform to help part removal after printing. The flexible plate must also be clean prior to use.

5.5. Post-processing

Printed parts can be post-processed with or without the printing platform.

With printing platform

5.5.1A. Cleaning, drying and post-polymerization

After printing, remove any HORUS Castable residue from the resin tank using a clean spatula. Remove the printing platform and put it into the Clean & Cure S-One to clean, dry and post-polymerize parts following the Clean & Cure S-One instruction for use. Several cleaning solvents are available, use the appropriate post-processing program to clean, dry and post-polymerize parts in a single program.

5.5.2A. Parts removal

Remove the parts with a metal spatula in a clean place. If the flexible plate is used, it can be grabbed from the printing platform and parts can be removed with a simple flexion.

5.5.3A. Supports removal

If supports are used for printing, they must be removed from the parts using a clamp. Separation should be as close to the parts as possible to reduce the polishing step.

Without printing platform

5.5.1B. Parts removal

After printing, remove any HORUS Castable residue from the resin tank using a clean spatula. Remove the parts with a metal spatula in a clean place. If the flexible plate is used, it can be grabbed from the printing platform and parts can be removed with a simple flexion.

5.5.2B. Supports removal

If supports are used for printing, they must be removed from the parts using a clamp. Separation should be as close to the parts as possible to reduce the polishing step.

5.5.3B. Cleaning, drying and post-polymerization

Printed parts can be placed in the basket of the Clean & Cure S-One. Follow the Clean & Cure S-One instruction for use to clean, dry and post-polymerize printed parts. Several cleaning solvents are available, use the appropriate post-processing program to clean, dry and post-polymerize parts in a single program.

6. STORAGE

HORUS Castable should be kept in the original bottle, closed and stored at a temperature between 10°C and 28°C in a dry place away from light. A small light amount may indeed be sufficient to initiate polymerization. After use, HORUS Castable can be put back in the original bottle using a filter with a maximum mesh size of 200 µm to avoid any contamination. HORUS Castable must not be used after the expiry date.

7. WASTE MANAGEMENT

Fully cured parts can be considered as plastic waste and are not harmful for the environment. However, the liquid resin must be disposed of as a chemical product in accordance with local regulations. Finally, empty packaging must be brought to an approved waste treatment site for recycling or disposal.

8. ADDITIONAL INFORMATION

HORUS Castable is available in 1 kg bottles in orange colour. In addition to this information for use, it is strongly recommended to read the HORUS Castable technical and safety data sheets.

Information provided in this instruction for use are based on our knowledge and experience of HORUS Castable in our dental laboratory at the date of this instruction for use. In order to produce optimum quality parts, the process phases indicated in this instruction for use must be strictly followed.

If defect appear in HORUS Castable within the warranty period, the user may only claim replacement of the material. 2MS is not liable in any way for any loss or damage caused by HORUS Castable, whether direct or indirect damage including collateral damage, regardless of the legal basis. 2MS is only liable for direct material damages of HORUS Castable based on deliberate act or gross negligence of its legal representatives or executive staff for personal damage in accordance with the statutory regulations. 2MS cannot be held responsible for the material or for any damage resulting from its use if the user has not followed the specified procedure.

HORUS is a brand of eco-responsible 3D printing resins designed and manufactured in France. The Coq Vert label from ADEME and BPI France attests to our commitment to the ecological and energy transition while the French Fab, French Tech and French Care labels bear witness to our desire to develop French industry and embody an innovative, ambitious and healthcare France. The HORUS research and development center combines the expertise of chemists and dental 3D printing experts to guarantee continuous improvement of our products and meet all dental needs. Especially, HORUS strives not to use controversial molecules such as bisphenol A (BPA), methyl methacrylate (MMA), tetrahydrofurfyl methacrylate (THFMA) and 2,4,6-Trimethylbenzoyl-diphenylphosphine oxide (TPO) which are still widely used by major actors in the dentistry field.

9. SYMBOLS



Follow instruction for use



Expiry date



Harmful or irritant



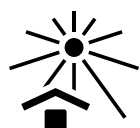
Caution: precaution or restriction of use



Manufacturer



Hazardous to the aquatic environment



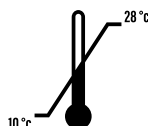
Protect from sunlight or any other light source



Batch code



Corrosive



Temperature limitation



Catalogue number



Health hazard



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2MS

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