

# SolusWax Pro Instructions

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## Software and Resin Profile

Download the latest software update in order to access the SolusWax Pro resin profile. Inside Contour, under the HELP menu, check for the latest update, install it and restart Contour. The new resin profile for SolusWax Pro should be selectable. You may need to enable Beta software downloads from inside the Preferences in order to get the latest Beta version of the software.

## Resin Handling

It's not necessary to warm up the SolusWax Pro for normal printing. However if you just receive the bottle and you live in a cold climate, or if it's winter time, then you may want to warm it up before shaking and mixing the bottle.

Warm up the bottle of SolusWax Pro by submerging into hot water for about 5 minutes, and then shake the bottle really well to mix in any wax that may have settled on the bottom. Shake for 1-2 minutes before pouring some into the resin tank.

## Resin Care and Storage

Keep the resin bottle in a dark, dry and cool place. Do not expose to extreme temperature shifts and do not expose to moisture and high humidity.

**IMPORTANT:** We do not recommend leaving the resin in the resin tank after you're finished printing, because the resin can pull in moisture from the air and that may affect the printing and casting. Also the wax particle can settle and stick to the film, which then will require lots of mixing and scraping to get it off the film, and can cause print failures.

Pour the resin into another container (preferable a dark glass jar or HDPE container) for storage. Then mix and shake really well before pouring back into the vat for printing. You may also pour the resin back into the original bottle, however make sure to strain it first through a fine strainer to capture possible cured particles and prevent contamination.

## Printing

Because of the high wax content, Solus Wax Pro may exhibit poor adhesion to the build plate on some prints, all depending on the support base size, thickness, how well the build plate is scuffed, etc.

For better adhesion to the build plate, a small bottle of adhesion gel is included. We recommend putting a drop or two on the build plate and brushing it on evenly. Let it sit for about 5 minutes before printing. A few drops of other castable resins, applied to the build plate, can also be used as an adhesive.

## Post-cleaning and Curing

Clean the prints using 91% IPA alcohol for not more than 15 seconds. Use two separate containers of alcohol for proper cleaning. Dry the prints using compressed air or hair dryer. Cure the prints for no longer 20-30 minutes under UV lights. Curing is not required for casting, but will make the prints easier to handle and will make the resin stronger if you have very delicate parts that may break during investing.

DO NOT USE WATER FOR CLEANING OR CURING OF SOLUSWAX PRO. WATER MAY DAMAGE THE PRINTS.

## Casting and Investment Types

We recommend casting SolusWax Pro prints shortly after printing and curing. If left for more than a week without casting, oily wax may seep out and will need to be cleaned inside alcohol and dried before casting.

For investment types, we recommend R&R Plasticast or Optima Prestige, but others may work well also. Follow the manufacturer recommended mixing instructions and ratios.

No special burnout schedules are required for SolusWax Pro. We do recommend a quick ramp up from 0F to 1450F and to hold for 2-3 hours at 1450F before ramping down to casting temp, hold for 1-2 hours and cast.

For thicker items, it may be necessary to hold longer at the high end or to slow down the ramp speed a little.