

BioModeling Gray

(B-MDL1GY)

Check: Well shaken resin, Clean optical pathways, Good resin tank condition.

Recommendation:

Prevention of cross-contamination with other non-bio resins ensures optimal biocompatibility for printed models. Dedicate accessories for BioModeling Gray: resin tank, build platform and wash.

Printer Settings:

Brand	Model	Settings
Formlabs	Form 4B	To get the latest printing settings, simply visit the ApplyLabWork Support page and download the files for your printer model.
Open system MSLA <ul style="list-style-type: none"> ● Elegoo ● Phrozen ● Anycubic 	<ul style="list-style-type: none"> ● Mars 5 Ultra, Saturn 4 ...etc. ● Mighty Revo, Sonic Mini 8K S ...etc. ● Photon M3 Premium ...etc. 	
Asiga	Pro 4K UV385, Max UV385	
HeyGears	Reflex	PAS10 Black (100µm)
SprintRay (Not endorsed by SprintRay)	Pro 2	OnX Tough 2 A1 (100µm)
	Pro 95 S	Study model white 2 (100µm)

Note: Each printer is unique, and light intensity can vary even among identical models. Minor adjustments may be necessary, especially true for open-system MSLA printers.

Cleaning: [fill fresh 95% IPA in two baths]

A-bath: Submerge and agitate printed models in IPA. Use toothbrush to gently remove uncured resin quickly on the model surfaces. Transfer cleaned model to B-bath.

B-bath: Submerge cleaned models from A-bath for **3 minutes**.

Total IPA clean time should not exceed 5 minutes.

Drying:

Blow dry the models with compressed air, let models **sit dry 25 minutes minimum** in a shaded airy place. Printed parts must be free of IPA before UV post-curing. Extended wash time and residual IPA (if not dried completely) causes deformation and lower mechanical properties.

Biocompatible Resin

UV Post-Curing Setting (Required):

Brand	Post-Curing Chamber Model	Settings
Elegoo	Mercury Cure	45 min
Formlabs	FormCure	35°C 30min
NK Optik	Otoflash	2500 flashes
HeyGears	UltraCraft Cure	PAP10
SprintRay	ProCure 2	Try In 2

Allow the models to cool naturally to room temperature after curing. (Avoid external forces, no stacking of models during cooling.)

Storage:

Filter out all debris in used-resin before storage. Keep resin in the original bottle, storage temp (15-26°C / 59-79°F) in a dry and dark area.

Note: Pigment settlement is normal. Gently mix remaining resin in resin tank with soft “resin wiper” for color evenness.