

## BioModeling Sand (B-MDL1SD)

**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 Sand: resin tank, build platform and wash.

### Printer Settings:

Brand	Model	Settings
Open system MSLA ● Elegoo ● Phrozen ● Anycubic	● Mars 5 Ultra, Saturn 4 ...etc. ● Mighty Revo, Sonic Mini 8K S ...etc. ● Photon M3 Premium ...etc.	To get the latest printing settings, simply visit the <a href="#">ApplyLabWork Support</a> page and download the files for your printer model.
Asiga	Pro 4K UV385, Max UV385	
HeyGears	Reflex	PARP10 (100µm)
<b>SprintRay</b> <small>(Not endorsed by SprintRay)</small>	Pro 2, Pro 95 S	Surgical Guide 3 (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
Formlabs	Fast Cure	Intensity = 1, 5 min
NK Optik	Otoflash	2500 flashes
HeyGears	UltraCraft Cure	PAP10
SprintRay	Nano Cure	NightGuard Firm 2 Midnight Purple

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.