

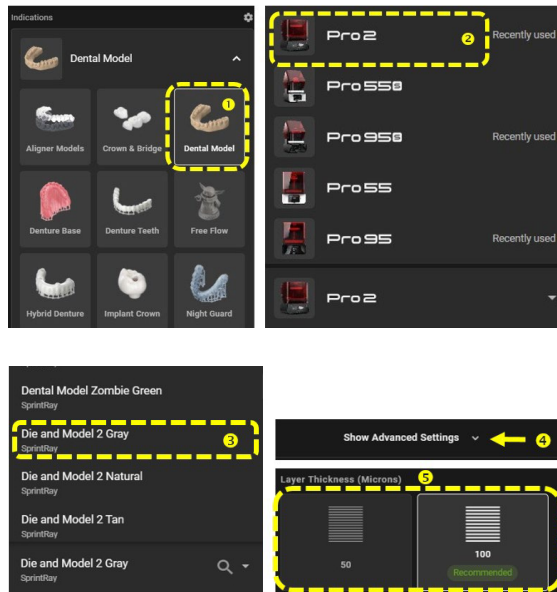
APPLYLABWORK PRINTING TIPS

(Not endorsed by SprintRay)

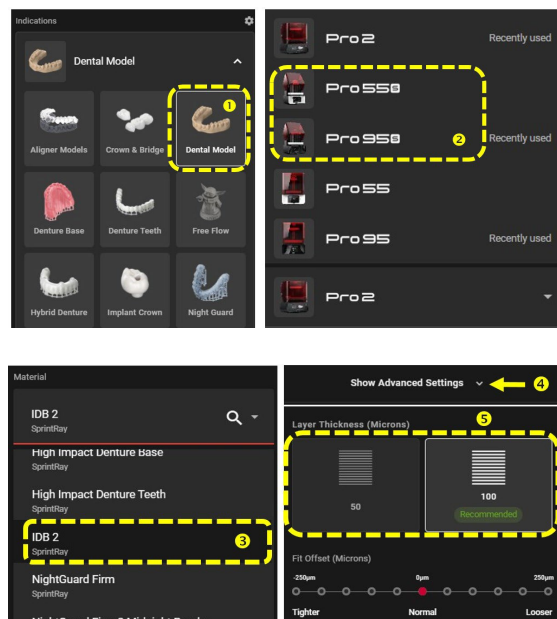
DLP Modeling – Tan V3 (DMD-R003TN) SprintRay (Pro 2, Pro S 95 & 55, Pro95 & 55)

RayWare Cloud:

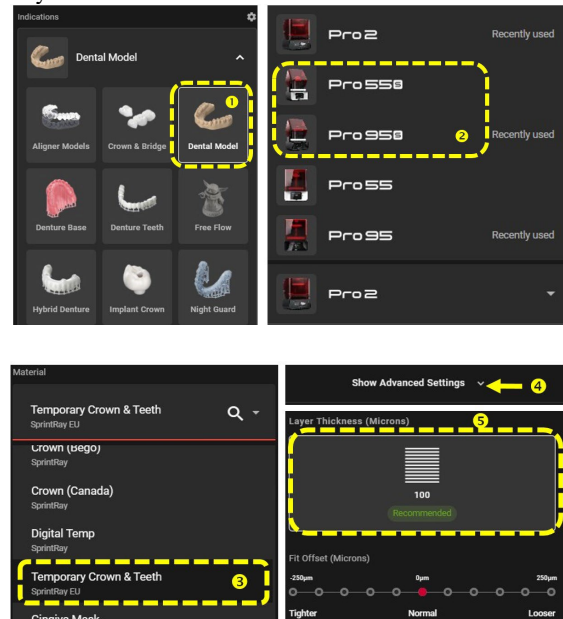
Printer: **Pro 2**
Indications: Dental Model
Material: **SprintRay Die and Model 2 Gray**
Layer Thickness: **50/100 Micron**



Printer: **Pro S 95 & Pro S 55**
Tank: **Normal Tank**
Indications: Dental Model
Material: **SprintRay IDB2**
Layer Thickness: **50/100 Micron**



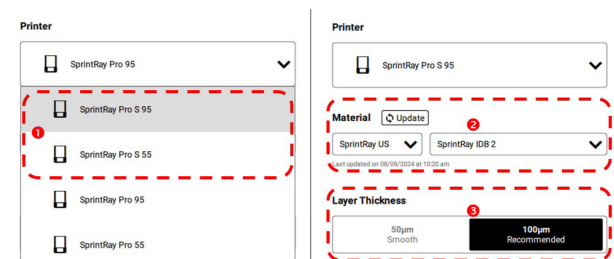
Printer: **Pro S 95 & Pro S 55**
Tank: **Optical Polish V2**
Indications: Dental Model
Material: **SprintRay EU Temporary Crown & Teeth**
Layer Thickness: **100 Micron**



- Offset is an optional function that depends on the printer's intensity variation and the user's application.
- The recommended offset value is 0 µm.

RayWare: version 2.9.2

Printer: **Pro S 95 & Pro S 55**
Tank: **Normal Tank**
Material: **SprintRay IDB2**
Layer Thickness: **50/100 µm**



APPLYLABWORK PRINTING TIPS

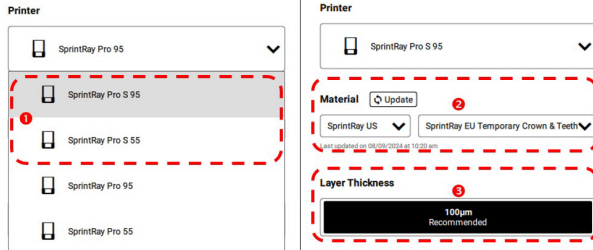
(Not endorsed by SprintRay)

Printer: **Pro S 95 & Pro S 55**

Tank: **Optical Polish V2**

Material: **SprintRay EU Temporary Crown & Teeth**

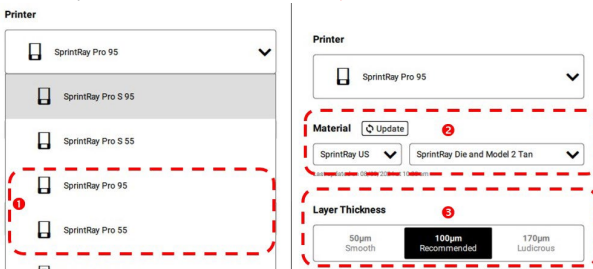
Layer Thickness: **100 µm**



Printer: **Pro 95 & Pro 55**

Material: **SprintRay US → Die and Model 2 Tan**

Layer Thickness: **50/100/170 µm**



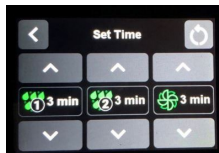
Load 3D model and double check supports and orientation are optimal before print.

- When printing arches directly on build-platform, vertically or horizontally, supports are not needed.
- For detailed calibration, please refer to [Tips](#) for dimension and tolerance testing.

Washing:

Submerge print in clean IPA for **5 minutes** with vigorous stirring (e.g. SprintRay Pro Wash/Dry, FormWash or ultrasonic bath), gently shake-off / blow-off excess IPA, set print in a shaded airy place to dry completely before curing.

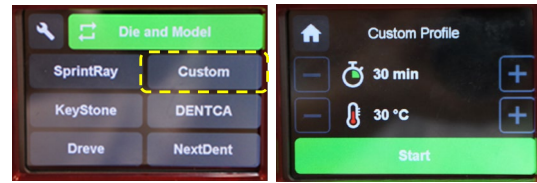
- Pro Wash/Dry: ① 3 min + ② 3 min + Dry 3 min:



Extended wash time could cause deformation. Dried prints may be tacky to touch.

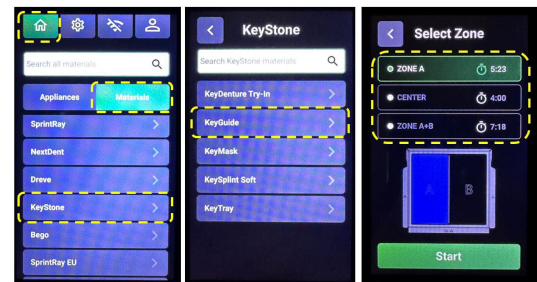
Post-Curing:

- **Pro Cure 1** (Firmware version 1.73 and later)



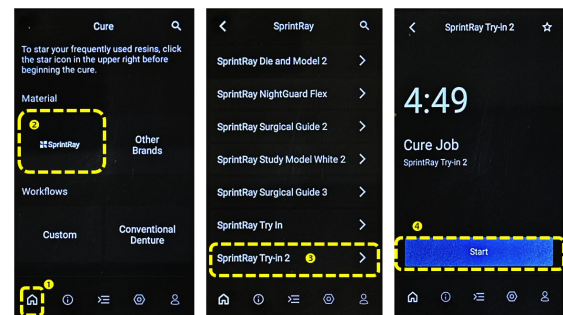
Select **Custom**, and then select the conditions as **30°C for 30 min**.

- **Por Cure 2** (Software version 1.2.23 and later)



Select **Material → KeyStone → KeyGuide**, and then select **exposure zone**

- **Nano Cure** (Software version 1.0.9 and later)



Select **Material → SprintRay → SprintRay Try-In 2**, and then select **Start**.

Storage:

DO NOT keep resin in the tank for more than **2 days**. Filter out all debris in the case of fail print jobs.

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