

## FLEX BT TRANSLUCENT (B-FBT1TL)

**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 FLEX BT TRANSLUCENT: resin tank, build platform and wash.

### Printer Settings:

Brand	Model	Settings
<b>Formlabs</b>	<b>Form 4B</b>	To get the latest printing settings, simply visit the ApplyLabWork <a href="#">Support</a> page and download the files for your printer model.
Open system MSLA ● <b>Anycubic</b> ● <b>Elegoo</b> ● <b>Phrozen</b>	● M3 Premium, Mono X 6K ...etc. ● Mars 4, Saturn 3 Ultra ...etc. ● Mighty Revo, Sonic Mini 8K ...etc.	
<b>Asiga</b>	<b>Pro 4K UV385, Max UV385</b>	
<b>HeyGears</b>	<b>Reflex</b>	<b>PAS10</b> (50µm)
	<b>RS</b>	<b>PARP100C</b> (50µm)
<b>SprintRay</b> (Not endorsed by SprintRay)	<b>Pro 2</b>	<b>SprintRay NightGuard Flex 2 Ocean Blue</b> (100 µm)
	<b>Pro 95 S, Pro 55 S, Pro 95 &amp; Pro 55</b>	<b>SprintRay IDB 2</b> (50/100 µm)

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	5 min
Formlabs	FormCure	60°C 5 min
Formlabs	Fast Cure	Intensity = 1, 1 min
Phrozen	Phrozen Cure	5 min
SprintRay	Nano Cure	Die and Model 2
SprintRay	ProCure 2	Die and Model 2
SprintRay	ProCure	50°C 5 min

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.