

# APPLYLABWORK PRINTING TIPS

(Not endorsed by SprintRay)

## DLP Modeling Sand (DMD-R001SD) SprintRay (Pro 2, Pro S 95 & 55, Pro95 & 55)

### Check:

- UV optical pathways are clean
- Resin tank is free of defect
- Resin is well shakened
- Do Not overfill resin tank

### RayWare Cloud:

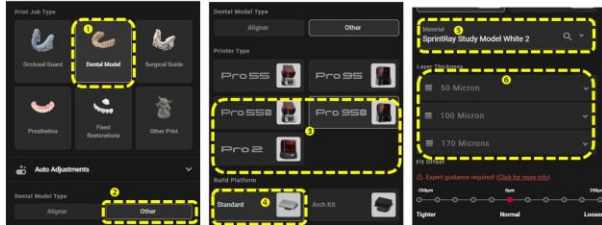
Job Type: Dental Model

Dental Model Type: Other

Printer: **Pro 2, Pro S 95, & Pro S 55**

Material: **SprintRay Study Model White 2**

Layer Thickness: **50/100/170 Microns**



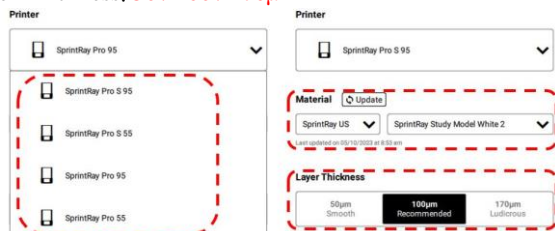
- Offset is an optional function that depends on the printer's intensity variation and the user's application.
- The recommended offset value is 0 µm.

### RayWare: version 2.9.2 and later

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

Material: **SprintRay US → SprintRay Study Model White 2**

Layer Thickness: **50 / 100 / 170µm**



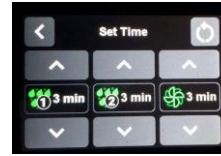
Load 3D model and double check supports and orientation are optimal before print.

- 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.

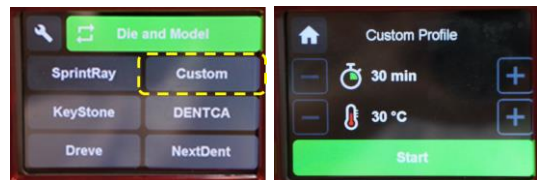
- Pro Wash/Dry: **1** 3 min + **2** 3 min + Dry 3 min:



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

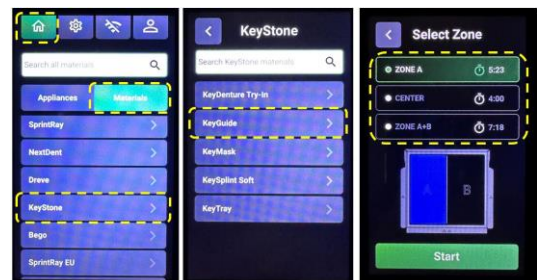
### Post-Curing:

- **ProCure 1** (Firmware version 1.73 and later)



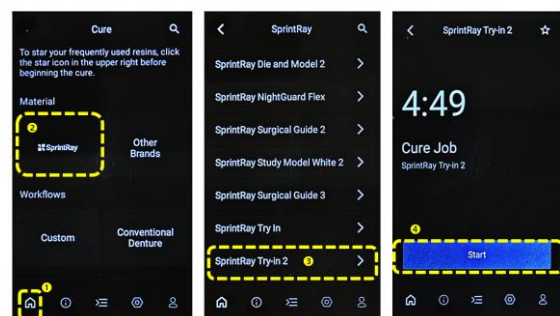
Select **Custom**, and then select the conditions as **30°C for 30 min**.

- **PorCure 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**.

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Models will have a visible yellowhue, after ProCure, which diminishes over 3~4 days.

### **Yellowhue reduction:**

Bring tap water to broil, switch heat off, submerge models in hot water for 5 mins.

### **Storage:**

**DO NOT** store resin in the tank for more than **3 days** if not printing. Filter out all debris in the case of failed print jobs.

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