

## Modeling – Black V2 (MD-R002BK)

### Check:

- VAT and bottom optical window is clean
- PDMS or film-coated elastic layer is free of defect
- Shake resin bottle well before pouring
- Do Not overfill VAT's maximum resin line

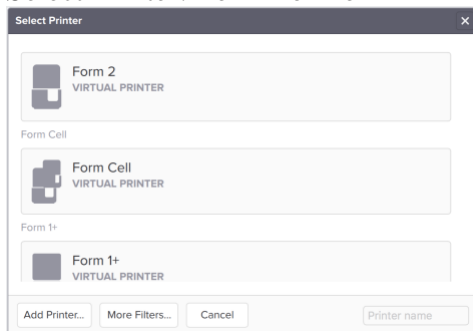
### Set Printer to Open Mode:

Printer must be at idle

1. Tap touchscreen “Gear” icon, open “Settings” menu
2. Select Open Mode
3. Select On

### PreForm:

Select Printer: Form2 or Form1+



### Print Setup:

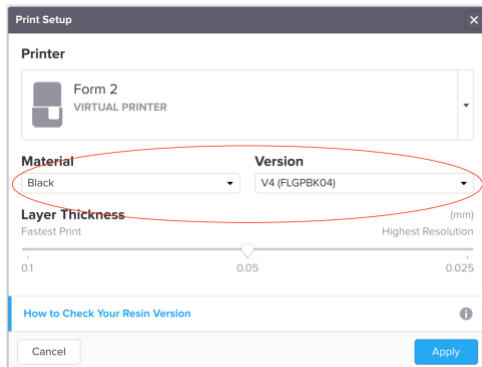
Material Select:

Black and V4(FLGPBK04) or  
Black and V3(FLGPBK03)

Layer Thickness Select: 0.1 or 0.025

Click: Apply

Load 3D model



After print is loaded, double check support and orientation is optimal before print

### Washing

Submerge print in clean IPA for up to **5 minutes**, gently shake-off / blow-off excess IPA, set print in a shaded airy place to dry before curing. (**extended period in IPA causes deformation**)

Dried print might be a little tacky to touch

### Curing

Post-curing required for optimal material performance: Light wavelength: 405nm  
Total light energy per unit area required on the print: **684,000mJ/cm<sup>2</sup>**

Example:

Light power on the print = 40mW/cm<sup>2</sup>,  
(higher power per unit area shortens curing time) 648,000mJ / 40mW / 60sec = 270 minutes of curing time.

Controlled curing chamber temperature between: 30~40° C / 86~104°F

### Storage

Leftover resin may be left in the VAT for next print job without cleaning, no more than **1 month for general VAT**, no more than **2 months for LT VAT**

Filter out all debris in the case of fail print  
Cover VAT lid and store in cool temp (15~26° C/59~79° F), dry and keep away from light

**Note:** Slight pigment settling may occur after 20 hrs. Gently stir resin in VAT with spatula for color evenness.