

Modeling – Gray (MD-R001GY)

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

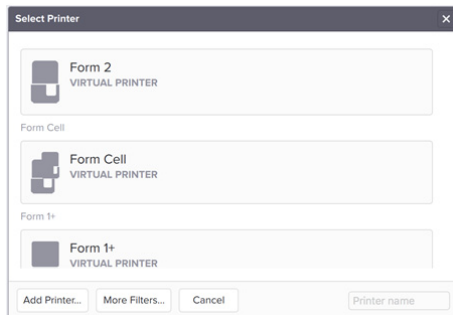
Set Printer to Open Mode:

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:

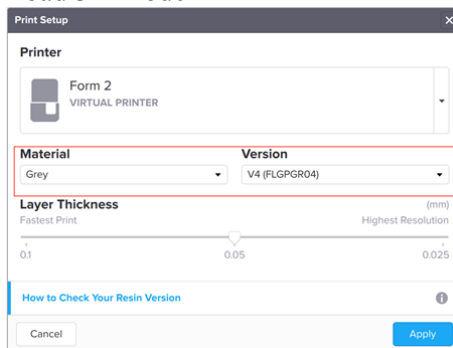
Material Select:

Grey and V4(FLGPGR04) or
Grey and V3(FLGPGR03)

Layer Thickness Select: 0.1, 0.05 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/cm²**

Example:

Light power on the print = 40mW/cm²,
(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