

## DLP Modeling – Gray (DMD-R001GY)

### Check:

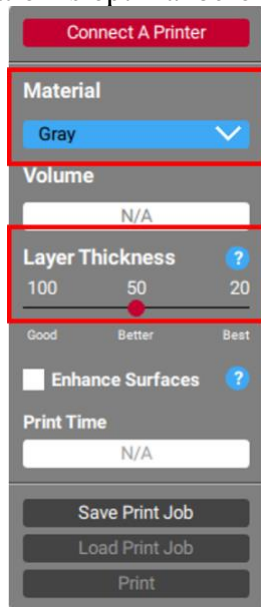
- Resin tank drum and optical path are clean
- Shake resin bottle well before pouring
- Do Not overfill Resin tank's maximum resin line

### RayWare: [MoonRay Printer]

Open RayWare software and connect printer

### Print Setup:

Load 3D model and double check support and orientation is optimal before print



Material Select: **Gray**

Layer Thickness Select: **100, 50 or 20**

Click: 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

Don't keep resin in the tank for more than **3 days**. Filter out all debris in the case of fail print

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