

DLP Modeling – Tan (DMD-R001TN)

Check:

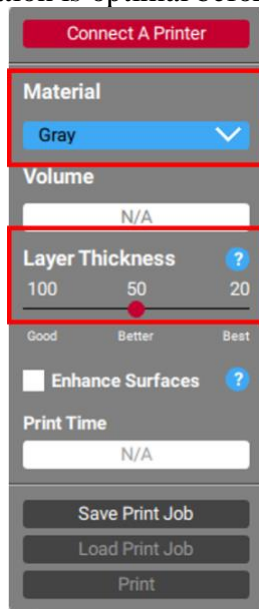
- Resin tank drum and optical path are clean
- Shake resin bottle well before pouring
- Do Not overfill Resin tank's maximum resin line

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/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

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.