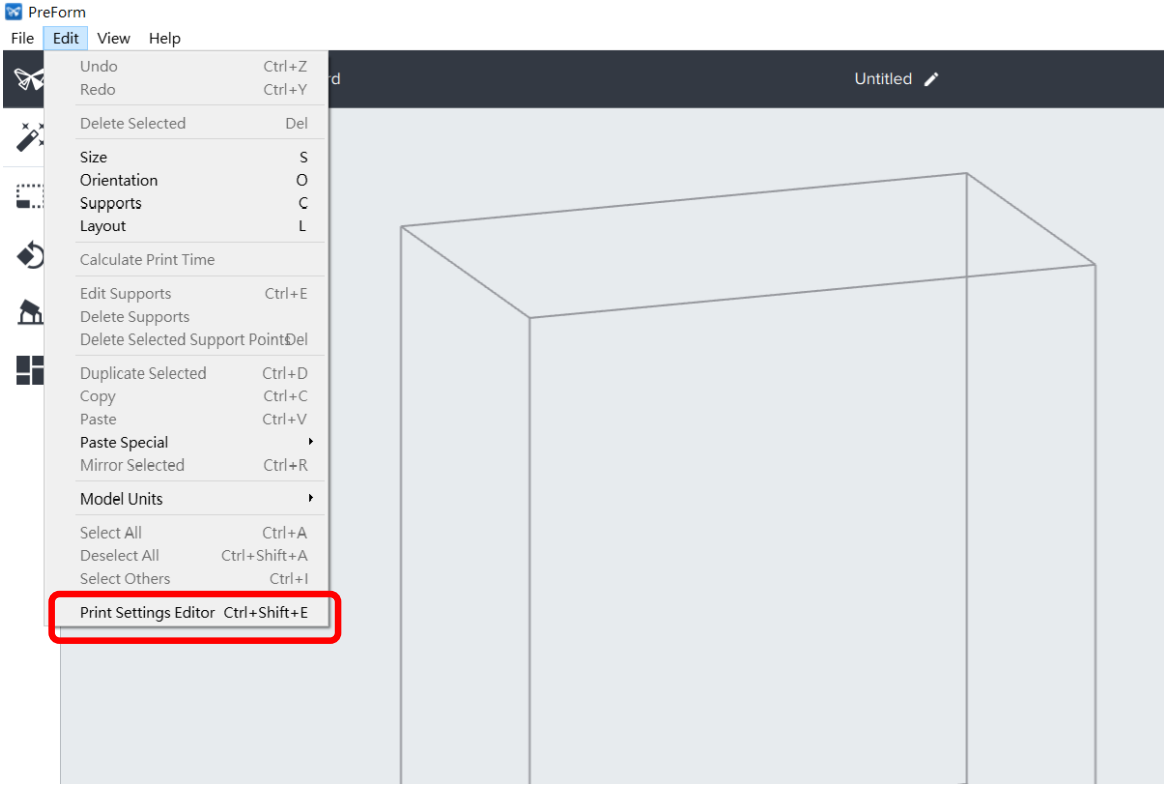# Modeling 200 Gray
with any FL-cartridge
on Form3

20240822

Material:

1. Any Form3 (clean empty) cartridge, recognized by Form3 printer
2. ALW Modeling 200 Gray resin

Step1: Open PreForm "Print Settings Editor"

Step2: Choose the profile consistent with the cartridge you have (Example: Grey V4 cartridge)


Choose Any Grey V4 profile

Step3: Open another PreForm window and choose the Draft V2 profile you want to use in the "Print Settings Editor" (Example: Draft V2 Default 0.2mm Layer Thickness profile).

Print Settings Editor   Help   ✕

My Settings   **Formlabs Settings**   4

[■ Form 3/3+ ▼] [💧 Draft ▼] [🔍 Search print settings...]   [Copy & Edit Selected]

Printer Type	Material	Layer Thickness	Setting Name	Description
■ Form 3/3+	💧 Draft V1	0.300 mm	✖ Default	*No description provided.*
■ Form 3/3+	💧 Draft V2	0.100 mm	✖ Default	Updated settings that improve support removal and print 20 - 40 % faster than L...
■ Form 3/3+	💧 Draft V2	0.100 mm	✖ Fast Arch	Settings optimized for solid orthodontic models that print up to 2x faster than d...
■ Form 3/3+	💧 Draft V2	0.100 mm	✖ Legacy	The previous Default print settings for this material, to ensure compatibility with ...
■ Form 3/3+	💧 Draft V2 3	0.200 mm	✖ Default	Updated settings that improve support removal and print 20 - 40 % faster than L...
■ Form 3/3+	💧 Draft V2	0.200 mm	✖ Fast Arch	Settings optimized for solid orthodontic models that print up to 2x faster than d...
■ Form 3/3+	💧 Draft V2	0.200 mm	✖ Legacy	The previous Default print settings for this material, to ensure compatibility with ...
■ Form 3/3+	💧 Draft V2	Adaptive	✖ Legacy	The previous Default print settings for this material, to ensure compatibility with ...

Step4: Edit data in your profile (from step2) to mirror Draft V2 profile (from step3)

FormLabs Draft V2 resin profile from step3
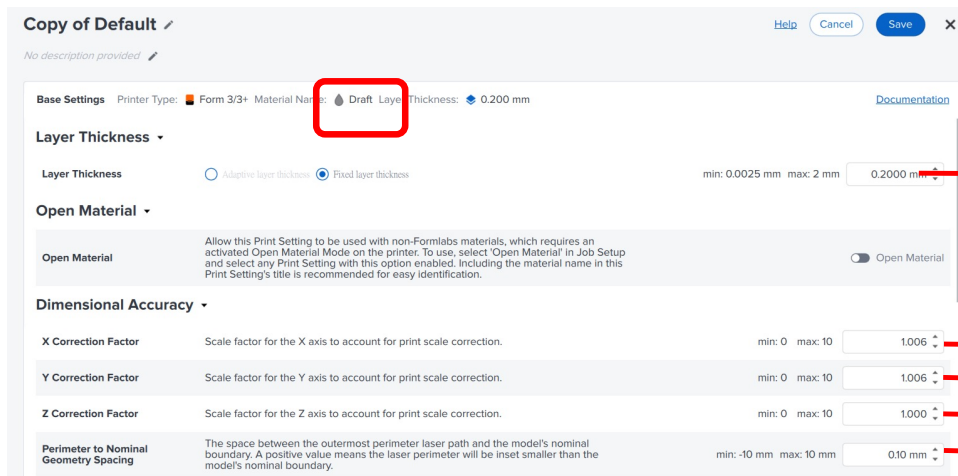
Your profile from step2
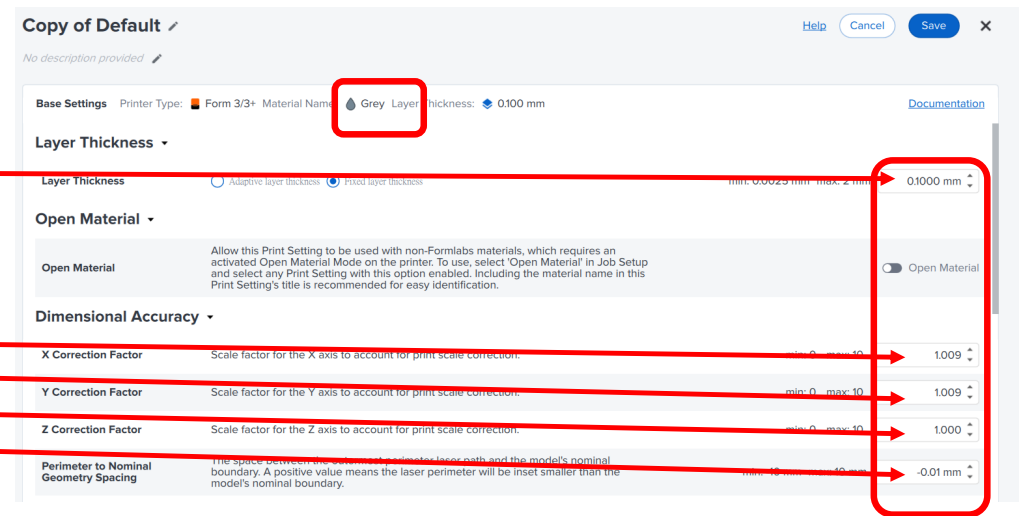
All settings should be edited, including "Layer thickness," "Dimensional accuracy," "Exposure," "Adhesion,"…etc. Moderately adjustment on the parameters helps to achieve optimal print size.

A perimeter to nominal geometry spacing of 0.07 mm is recommended for better print accuracy when using the Draft V2 Default 0.2mm profile to print with ALW Modeling 200 Gray resin.

Step5: Save your profile after renaming it

ALW M200 resin ✏️   Help   Cancel   **Save**   ✕

No description provided ✏️

Base Settings   Printer Type: ■ Form 3/3+   Material Name: 🖤 Grey   Layer Thickness: ◆ 0.100 mm   Documentation

Layer Thickness ▾

Layer Thickness   ○ Adaptive layer thickness ◉ Fixed layer thickness   false, 0.100 mm ↰ min: 0.0025 mm max: 2 mm   [0.2000 mm ⇕]

Open Material ▾

Open Material   Allow this Print Setting to be used with non-Formlabs materials, which requires an
                         activated Open Material Mode on the printer. To use, select 'Open Material' in Job Setup
                         and select any Print Setting with this option enabled. Including the material name in this   ⬤ Open Material
                         Print Setting's title is recommended for easy identification.

Dimensional Accuracy ▾

X Correction Factor   Scale factor for the X axis to account for print scale correction.   1.0091 ↰ min: 0   max: 10   [1.006 ⇕]

Y Correction Factor   Scale factor for the Y axis to account for print scale correction.   1.0091 ↰ min: 0   max: 10   [1.006 ⇕]

Z Correction Factor   Scale factor for the Z axis to account for print scale correction.   min: 0   max: 10   [1.000 ⇕]

**Perimeter to Nominal   The space between the outermost perimeter laser path and the model's nominal
Geometry Spacing**   boundary. A positive value means the laser perimeter will be inset smaller than the   -0.0065 ... ↰ min: -10 mm max: 10 mm   [0.07 mm ⇕]
                                model's nominal boundary.

Step6: Upload the print job by selecting the profile you created

Step7: Insert your (clean empty) cartridge into the Form3 printer, pour ALW Modeling 200 Gray resin into the tank, and start printing.
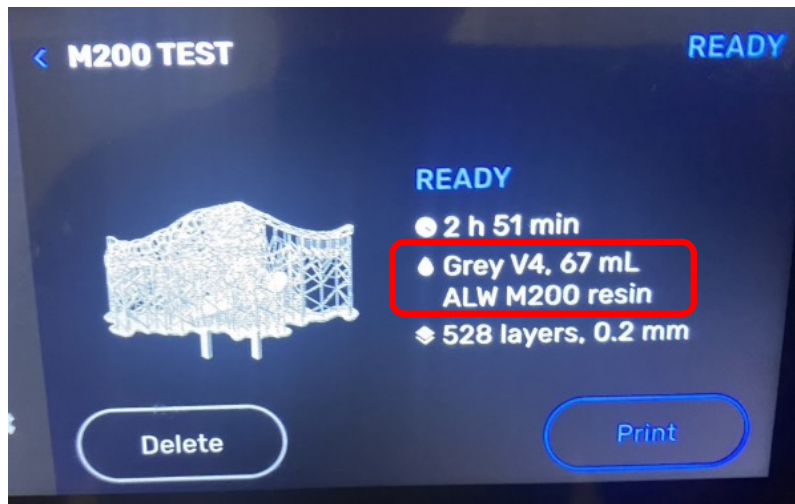
Modeling 200 Gray resin prints successfully on the Form3 using an empty FormLabs Grey V4 cartridge.