

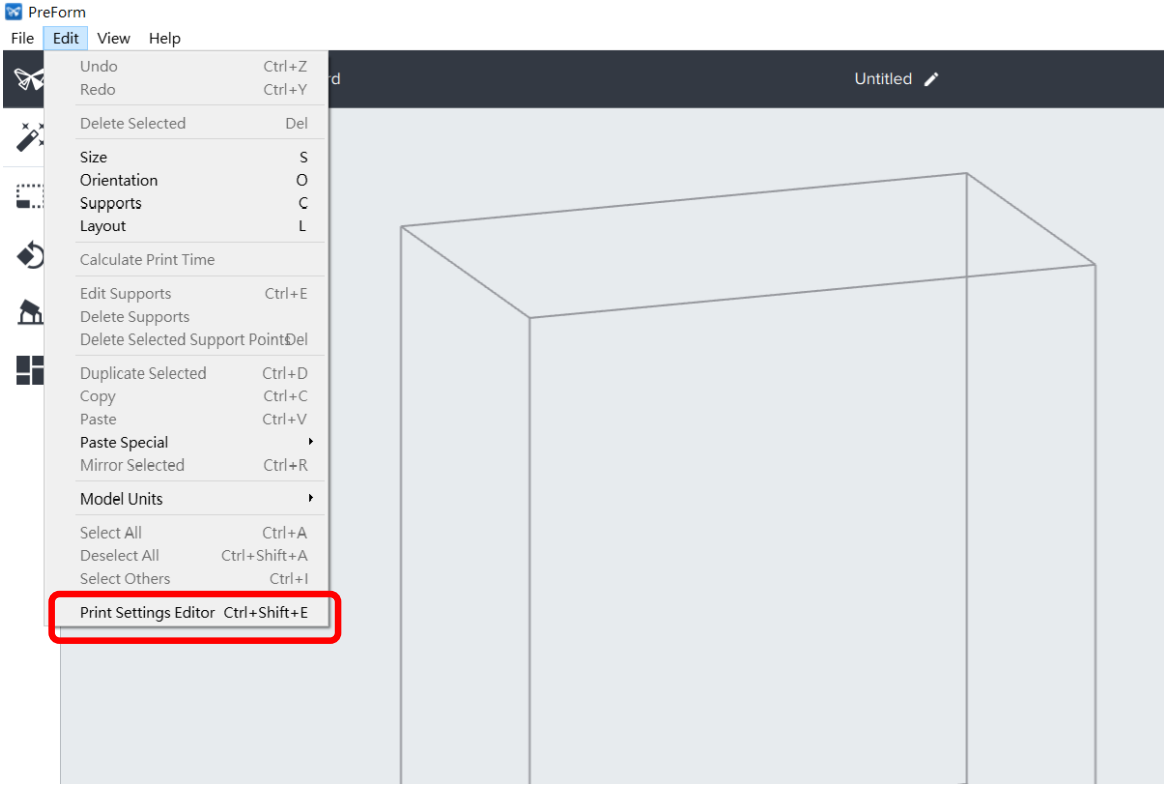
Modeling 200 Gray
with any FL-cartridge
on Form3

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)

Print Settings Editor [Help](#) ✕

My Settings **Formlabs Settings** 1

Form 3/3+ Grey 2 Search print settings... 4 **Copy & Edit Selected**

Printer Type	Material	Layer Thickness	Setting Name	Description
Form 3/3+	Grey V4	0.025 mm	Default	Updated settings that improve support removal and print 20 - 40 % faster than L...
Form 3/3+	Grey V4	0.025 mm	Legacy	The previous Default print settings for this material, to ensure compatibility with ...
Form 3/3+	Grey V4	0.050 mm	Default	Updated settings that improve support removal and print 20 - 40 % faster than L...
Form 3/3+	Grey V4	0.050 mm	Legacy	The previous Default print settings for this material, to ensure compatibility with ...
Form 3/3+	Grey V4 3	0.100 mm	Default	Updated settings that improve support removal and print 20 - 40 % faster than L...
Form 3/3+	Grey V4	0.100 mm	Fast Arch	Settings optimized for solid orthodontic models that print up to 2x faster than d...

Choose Any Grey V4 profile

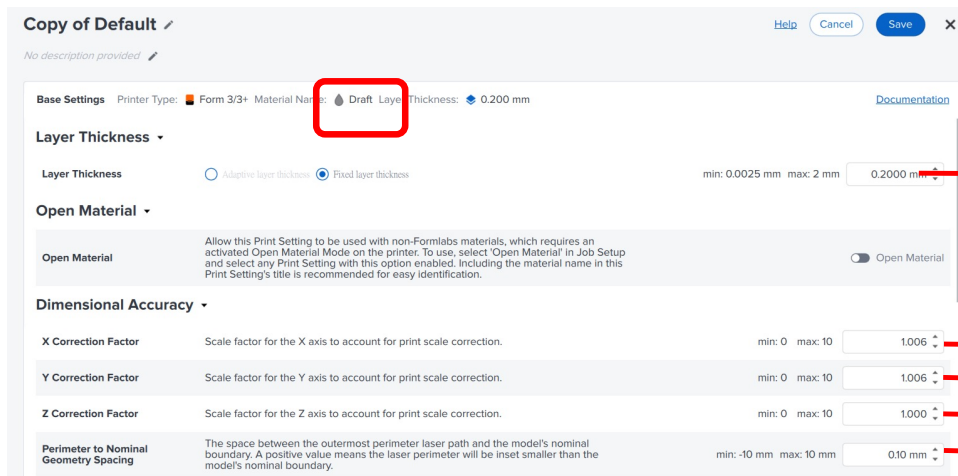
Step3: Open another PreForm window and choose the Draft V2 profile you want to use in the "Print Settings Editor" (Example: Draft V2 Default 0.2mm Layer Thickness profile).

The screenshot shows the 'Print Settings Editor' window. At the top left, there are two tabs: 'My Settings' and 'Formlabs Settings', with the latter highlighted by a red box and labeled '1'. Below the tabs, there are two dropdown menus: the first is set to 'Form 3/3+' and the second is set to 'Draft', both highlighted by red boxes and labeled '2'. To the right of these dropdowns is a search bar labeled 'Search print settings...'. Further right is a blue button labeled 'Copy & Edit Selected', highlighted by a red box and labeled '4'. Below these elements is a table with the following columns: 'Printer Type', 'Material', 'Layer Thickness', 'Setting Name', and 'Description'. The table contains several rows of settings. The row with 'Form 3/3+' as the printer type, 'Draft V2' as the material, and '0.200 mm' as the layer thickness is highlighted in blue and has a red box around the 'Draft V2' material name, labeled '3'. The other rows include 'Draft V1', 'Draft V2' with '0.100 mm' layer thickness, and 'Draft V2' with 'Adaptive' layer thickness.

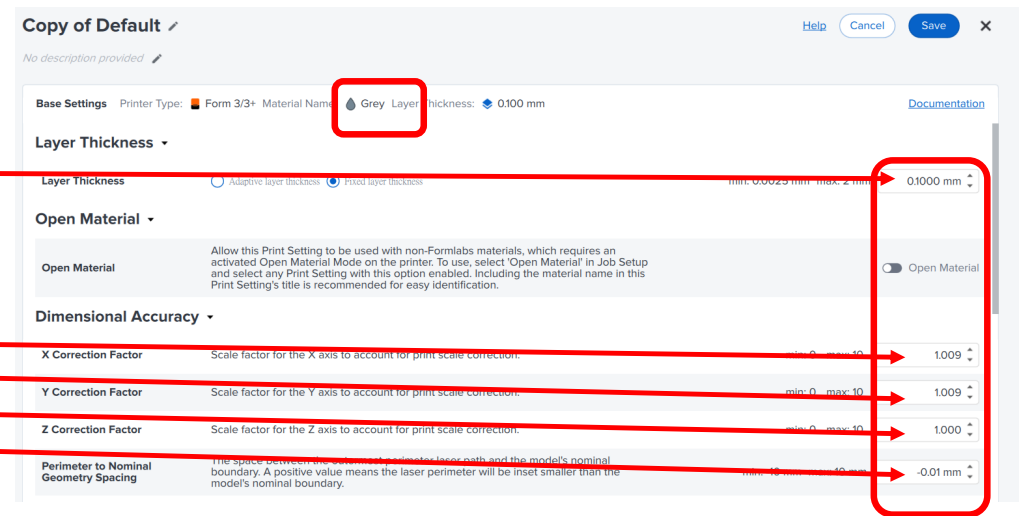
Printer Type	Material	Layer Thickness	Setting Name	Description
Form 3/3+	Draft V1	0.300 mm	Default	No description provided.
Form 3/3+	Draft V2	0.100 mm	Default	Updated settings that improve support removal and print 20 - 40 % faster than L...
Form 3/3+	Draft V2	0.100 mm	Fast Arch	Settings optimized for 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	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.

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 Print Setting's title is recommended for easy identification. Open Material

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 Geometry Spacing The space between the outermost perimeter laser path and the model's nominal boundary. A positive value means the laser perimeter will be inset smaller than the model's nominal boundary. -0.0065 ... ↶ min: -10 mm max: 10 mm **0.07 mm** ▾




Exposure ▾

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

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 Print Setting's title is recommended for easy identification. Open Material

Dimensional Accuracy ▾

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

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

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

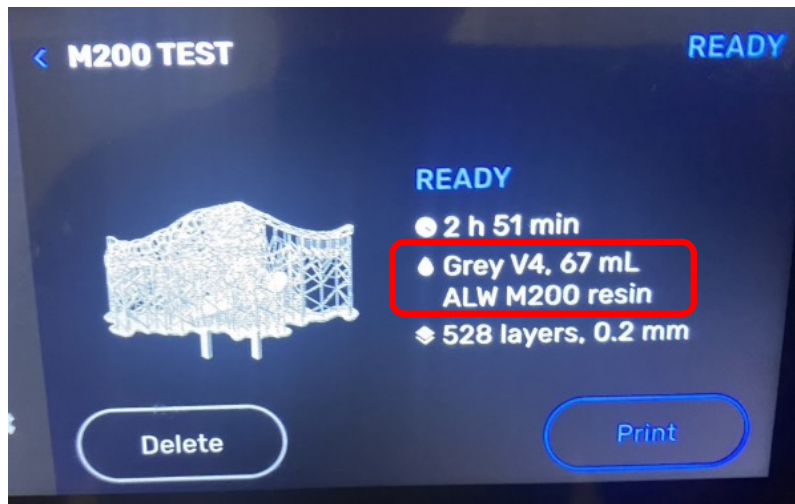
Perimeter to Nominal Geometry Spacing The space between the outermost perimeter laser path and the model's nominal boundary. A positive value means the laser perimeter will be inset smaller than the model's nominal boundary. -0.0065 ... min: -10 mm max: 10 mm

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

The screenshot displays a 3D printing software interface with the following sections:

- Material Selection:** A grid of 16 material profiles. The 'Grey' profile, featuring a bust icon, is highlighted with a red border.
- 3 Choose Layer Thickness:** A section with the subtext 'Layer thickness affects both the speed and the Z-axis resolution of a print.' It contains four options: '0.200 mm Fastest' (highlighted with a red border), '0.160 mm', '0.100 mm', and '0.050 mm'.
- 4 Choose Print Settings:** A section with the subtext 'Print settings control print speed, support tip shape, and other aspects of print performance.' It features a dropdown menu set to 'ALW M200 resin v2.1.7' (highlighted with a red border).
- Other Settings:** A section titled 'Optimized Settings for Build Platform 2 and Form Auto' with a toggle switch that is currently turned off.

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.

