

## BioModeling Gray

(B-MDL1GY)

**Check:** Well shakened resin, Clean optical pathways, Good resin tank condition.

### Recommendation:

Prevention of cross-contamination with other non-bio resins ensures optimal biocompatibility for printed models. Dedicate accessories for BioModeling Gray: resin tank, build platform and wash.

### Print Settings:

Brand	Printer Model	Settings
Formlabs	Form4B	To get the latest printing settings, simply visit the <a href="#">ApplyLabWork Support</a> page and download the files for your printer model.
<b>Open system MSLA</b> <ul style="list-style-type: none"> <li>● Elegoo</li> <li>● Phrozen</li> <li>● Anycubic</li> </ul>	<ul style="list-style-type: none"> <li>● Mars 5 ultra, Saturn 4...etc.</li> <li>● Mighty Revo, Sonic mini 8ks, ...etc.</li> <li>● Photon M3 Premium ...etc.</li> </ul>	
Asiga	<ul style="list-style-type: none"> <li>● Pro 4K UV385</li> <li>● Max UV385</li> </ul>	
HeyGears	Reflex	PAS10 Black (100um)

Note: Each printer is unique, and light intensity can vary even among identical models. Minor adjustments may be necessary, especially true for open-system MSLA printers.

**Cleaning:** [fill fresh 95% IPA in two baths]

**A-bath:** Submerge and agitate printed models in IPA. Use toothbrush to gently remove uncured resin quickly on the model surfaces. Transfer cleaned model to B-bath.

**B-bath:** Submerge cleaned models from A-bath for **3 mins**.

**Total IPA clean time should not exceed 5 minutes.**

### Drying:

Blow dry the models with compressed air, let models **sit dry 25 minutes minimum** in a shaded airy place. Printed parts must be free of IPA before UV post-curing. Extended wash time and residual IPA (if not dried completely) causes deformation and lower mechanical properties.

## Biocompatible Resin

## UV Post-Curing Setting(Required):

Brand	Post curing Chamber Model	Settings
Elegoo	Mercury Cure	45 min
Formlabs	FormCure	35°C 30min
NK Optik	Otoflash	2500 flashes
HeyGears	UltraCraft Cure	PAP10

Allow the models to cool naturally to room temperature after curing. (Avoid external forces, no stacking of models during cooling.)

## Storage:

Filter out all debris in used-resin before storage. Keep resin in the original bottle, storage temp (15-26°C / 59-79°F) in a dry and dark area.

Note: Pigment settlement is normal. Gently mix remaining resin in resin tank with soft “resin wiper” for color evenness.