BioModeling Sand
(B-MDL1SD)

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 Sand: resin tank, build platform and wash.

Print Settings:

Brand	Pirnter Model	Settings
Open system MSLA • **Elegoo** • **Phrozen** • **Anycubic**	• Mars 5 ultra, Saturn 4…etc. • Mighty Revo,Sonic mini 8ks, …etc. • Photon M3 Premium …etc.	To get the latest printing settings, simply visit the ApplyLabWork Support page and download the files for your printer model.
Asiga	• Pro 4K UV385 • Max UV385	
HeyGears	Reflex	PARP10 (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
Formlabs	Fast Cure	Intensity=1, 5min
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. Gentally mix remaining resin in resin tank with soft "resin wiper" for color evenness.

Biocompatible Resin