

APPLYLABWORK PRINTING TIPS

(Not endorsed by SprintRay)

DLP Modeling – Gray V3 (DMD-R003GY) SprintRay (Pro 2, Pro S 95 & 55, Pro95 & 55)

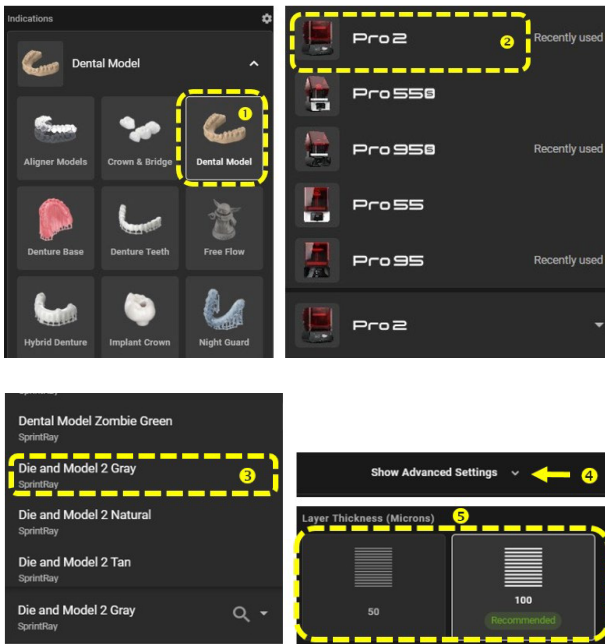
RayWare Cloud:

Printer: **Pro 2**

Indications: Dental Model

Material: **SprintRay Die and Model 2 Gray**

Layer Thickness: **50/100 Micron**



Printer: **Pro S 95 & Pro S 55**

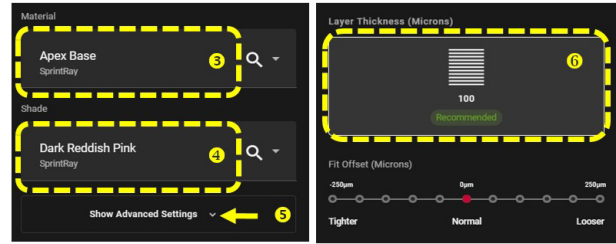
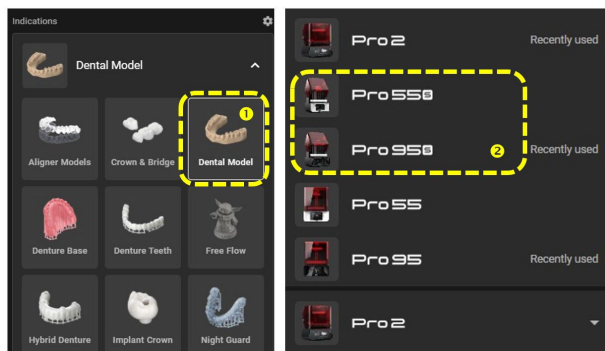
Tank: **Normal Tank & Optical Polish V2**

Indications: Dental Model

Material: **Apex Base**

Shade: **Dark Reddish pink**

Layer Thickness: **100 Micron**



- Offset is an optional function that depends on the printer's intensity variation and the user's application.
- The recommended offset value is 0 µm.

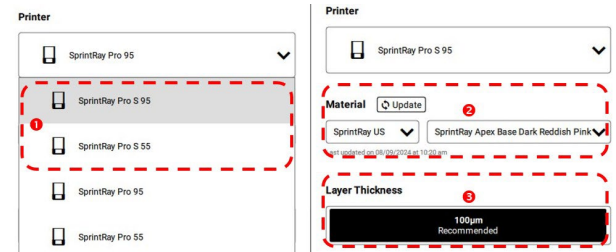
RayWare: version 2.9.2 and later

Printer: **Pro S 95 & Pro S 55**

Tank: **Normal Tank & Optical Polish V2**

Material: **SprintRay Apex Base Dark Reddish Pink**

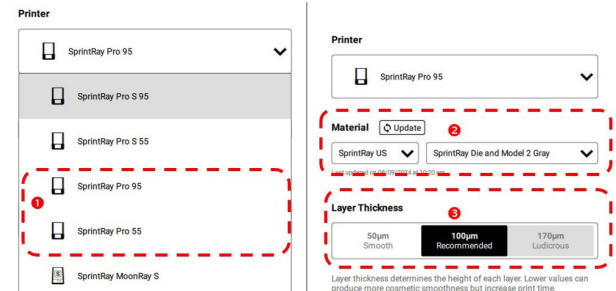
Layer Thickness: **100 µm**



Printer: **Pro 95 & Pro 55**

Material: **SprintRay Die and Model 2 Gray**

Layer Thickness : **50/100/170 µm**



Load 3D model and double check supports and orientation are optimal before print.

- When printing arches directly on build-platform, vertically or horizontally, supports are not needed.
- For detailed calibration, please refer to [Tips](#) for dimension and tolerance testing.

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Washing:

Submerge print in clean IPA for **5 minutes** with vigorous stirring (e.g. SprintRay Pro Wash/Dry, FormWash or ultrasonic bath), gently shake-off / blow-off excess IPA, set print in a shaded airy place to dry completely before curing.

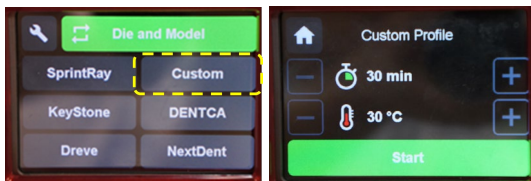
- Pro Wash/Dry: ① 3 min + ② 3 min + Dry 3 min:



Extended wash time could cause deformation. Dried prints may be tacky to touch.

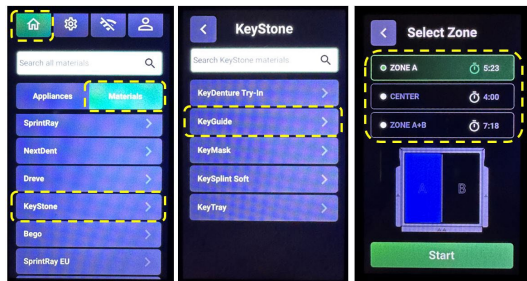
Post-Curing:

- **Pro Cure 1** (Firmware version 1.73 and later)



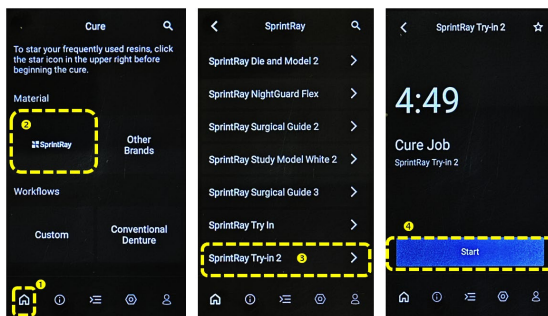
Select **Custom**, and then select the conditions as **30°C for 30 min**.

- **Por Cure 2** (Software version 1.2.23 and later)



Select **Material** → **KeyStone** → **KeyGuide**, and then select **exposure zone**

- **Nano Cure** (Software version 1.0.9 and later)



Select **Material** → **SprintRay** → **SprintRay Try-In 2**, and then select **Start**.

Storage:

DO NOT keep resin in the tank for more than **2 days**. Filter out all debris in the case of fail print jobs.

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