

D75, S100 & Pro95 DLP Modeling – White (DMD-R001WT)

Check:

- UV optical pathways are clean
- Vat is free of defect
- Resin is well shakened

RayWare: [MoonRay Pinter]

Open RayWare software (version 2.5.0 and later) and connect to the printer.

Print Setup:

Select printer model

Material : **SprintRay Try In**

Layer Thickness : **50 or 100 µm**

Printer

Pro95 S100 D75

Material ▲ Sign in to see all available materials.

All SprintRay NextDent DENTCA

SprintRay Try In

Layer Thickness

50µm Recommended 100µm Fast

Layer thickness determines the height of each layer. Lower values can produce more cosmetic smoothness but increase print time.

- When printing arches directly on build-platform, vertically or horizontally supports are not needed.
- When supports are needed, set density/strength to (M/M) or (L/L).

Supports

Generate Supports

Remove Supports

Raft

Default Road

Density

L M H

Strength

L M H

For detail calibration for resin can refer to [Dimension](#) and [Tolerance](#).

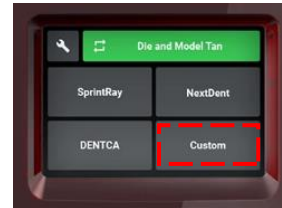
Washing:

IPA 95%, maximum for up to 5 minutes, gently shake-off / blow-off excess IPA quickly, set print in a shaded airy place to dry completely before curing.

Extended time in IPA causes deformation. Dried print might be a little tacky to touch.

Post-curing:

Pro Cure (firmware version 1.11 and later)



Select **Custom**, and then select the condition as **30°C for 10 min**. Modeling-White gains yellowish hue after ProCure but will Naturally diminishes after 3~4 days.

Quickly reducing yellow hue:

1. Place prints in a heat-resistant container.
2. Pour boiled water into the container, submerge the prints in hot water for 5~6 minutes.

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.