

APPLYLABWORK PRINTING TIPS

(Not endorsed by SprintRay)

DLP Modeling – Clear (DMD-R001CR) SprintRay (D75, S100, Pro and Pro S)

Check:

- UV optical pathways are clean
- Resin tank is free of defect
- Resin is well shaken
- Do Not overfill resin tank

Print Setup:

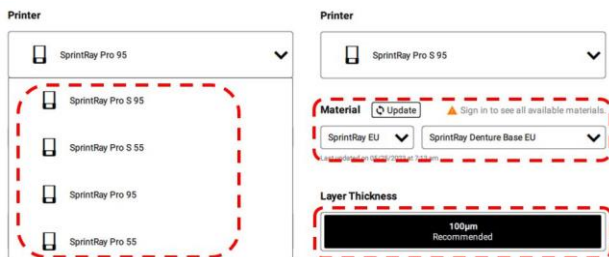
RayWare: Version 2.9.2 and later

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

Select Material:

SprintRay EU → Sprinray Denture Base EU

Layer Thickness: **100 µm**

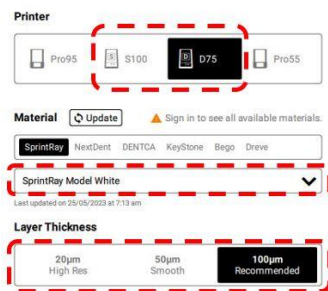


RayWare: [Version 2.8.3](#)

Select Printer: *D75 and S100*

Select Material: **Sprinray Model White**

Layer Thickness: **20/50/100 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 [Dimension and Tolerance](#).

Washing:

Submerge print in clean IPA for **5 minutes** with vigorous stirring (e.g. Sprinray 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.

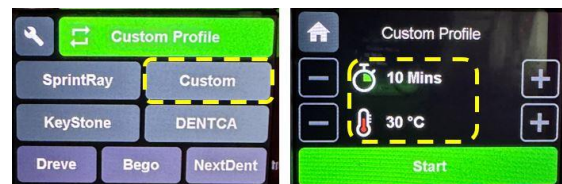
- Pro Wash/Dry: ① 3 min + ② 3 min + Dry 3 min:



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

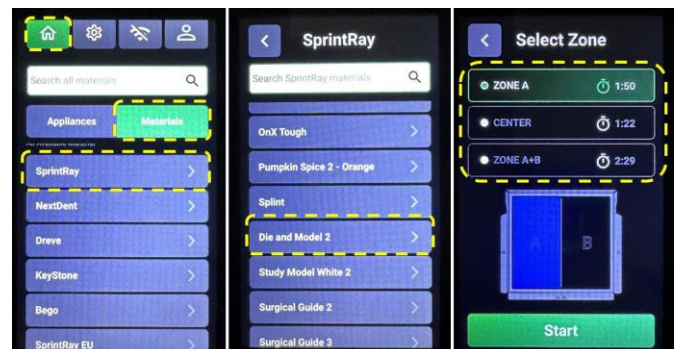
Post-Curing:

- Pro Cure 1 (Firmware version 1.73 and later)



Select **Custom**, and then select the conditions as **30°C for 10 min**.

- Por Cure 2 (Firmware version 1.2.12 and later)



Select **Material → Sprinray → Die and Model 2**, and then select **Exposure Zone**

Storage:

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