

DLP SG Clear (DSP-SG001CR)

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 DLP SG Clear: resin tank, build platform and wash.

Print Settings:

Brand	Printer Model	Settings
SprintRay <small>(Not endorsed by SprintRay)</small>	Pro 2, Pro S 95, & Pro S 55	SprintRay Try-In 2 (50/100 µm)
	Pro 95 & Pro 55	SprintRay IDB 2 (50/100 µm)
Formlabs Open system MSLA <ul style="list-style-type: none"> AnyCubic Elegoo Phrozen 	Form 4B <ul style="list-style-type: none"> M3 Premium, Mono X 6K ... etc. Mars 5 Ultra, Saturn 3 Ultra ... etc. Mighty 12K, Sonic Mini 8K ... 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	PAS10 (50 µm)
	RS	PARP10OC (50 µm)

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	30 min
Formlabs	FormCure	60°C 30min
Formlabs	Fast Cure	Intensity = 5, 1 min
Phrozen	Phrozen Cure	30 min
Phrozen	Phrozen Cure XL	45 min
NK Optik	Otoflash	3000 flashes
SprintRay	Nano Cure	Surgical Guide 3
SprintRay	Pro Cure 2	Surgical Guide 3
SprintRay	Pro Cure	30°C 15 min

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

Sterilization:

- Models must be fully post-cured before autoclave.
- Autoclave: **15 minutes at 121°C / 250°F or 20 minutes at 134°C/273°F**. No stacking of models in autoclave. Longer or hotter autoclave cycle is not needed.

Color Change:



- Allow the print to cool to room temperature. Avoid forces to the 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.