

APPLYLABWORK PRINTING TIPS

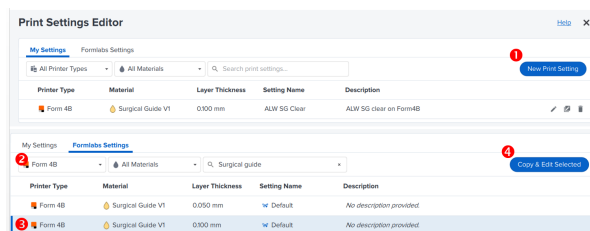
DLP SG Clear (DSP-SG001CR) FormLabs Form 4 (Open Material)

Checks: SG Resin is well shakened, Optical pathways are clean, Resin tank condition.

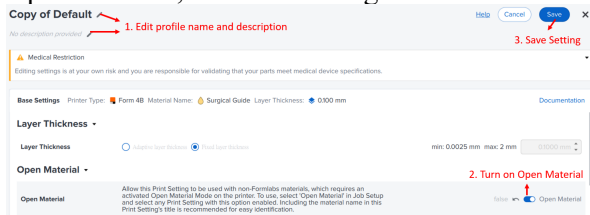
PreForm: version 3.39.0 and later

Open Material Settings:

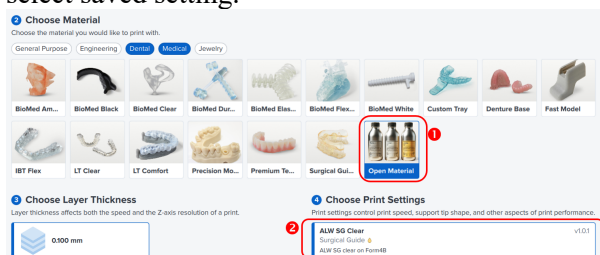
Edit → Print Setting Editor → New Print Setting → Form 4B → Select **Surgical Guide V1 (50/100 µm)** → Copy & Edit Selected



Then edit profile name and description, turn on Open Material, and save setting.



Go back Job Setup, Choose Open Material and select saved setting.



Then import desired STL file, edit and send print job to print.

Cleaning: A&B IPA bath [fresh 95% IPA]

A-bath: Submerge freshed removed parts in A-bath. Swish the parts around in the IPA, with a gentel dental brush to remove uncured resin on the surfaces. Transfer to B-bath.

B-bath: Submerged for **3 mins**.

Total IPA clean time should not exceed 5 minutes.

Drying:

Blow dry the models with compressed air, let models **sit dry completely, 25 mins minimum**, in a shaded airy location. **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.

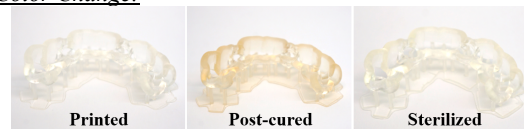
Post-Curing:

- **Form Cure:**
Select **60°C for 30 mins** and start.
- **Fast Cure:**
Select **Light Intensity 5 for 5 mins** and start. Cool Fast Cure for at least 10 minutes between cure cycles.

Sterilization:

- Models must be fully post-cured before autoclave.
- Autoclave: **15 mins at 121°C / 250°F**. No stacking of models in autoclave. If required, can withstand Prion cycle 134°C / 20 mins.

Color Change:



- Allow the print to cool to room temperature. Avoid forces to the models during cooling.

Storage:

Keep the resin in the original bottle, room temperature (15-26°C / 59-79°F) in a dry and dark area. Filter out all debris in the case of fail print jobs.