

DLP SG Clear (DSP-SG001CR) MSLA Open System Printers

Check: Resin is well shaken, Optical pathways are clean, Resin tank in good condition.

Print Settings:

Examples:

Printer	Layer thickness (mm)	Normal layer exposure time (s)	Bottom layer exposure time (s)
Elegoo Mars 3	0.1	7	15
Elegoo Mars 3 Pro	0.1	7	15
Elegoo Mars 4 DLP	0.1	7	15
Elegoo Saturn S	0.1	9	25
Elegoo Saturn 3 Ultra	0.1	7	15
Phrozen Mighty 4K	0.1	9	15
Phrozen Mighty 8K	0.1	8.5	15
Phrozen Sonic 4K 2022	0.1	7.5	12
Phrozen Sonic Mini	0.1	7	10
Anycubic Photon M3 Premium	0.1	6	15
AnyCubic Mono X 6K	0.1	4.5	15

Ref. to ApplyLabWork [Support](#) and download [LCD/LED Settings Worksheet](#) for lab tested settings details. Note, each printer is unique, light intensity varies from printer to printer even with the identical model and make, minor adjustment might be necessary.

Note, Do not place supports near the guide sleeve holes or on the intaglio surfaces.

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

A-bath: Submerge fresh removed parts in A-bath. Swish the parts around in the IPA, with a gent 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.

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.

UV Post-Curing:

UV post-curing is required.

Curing settings:

Post Curing Chamber	Temperature (°C)	Time (min)	Intensity
FormCure (FormLabs)	60	30	--
Fast Cure (FormLabs)	--	5	5
ProCure 1 (Sprintray)	30	15	--
Phrozen Cure (Phrozen)	--	30	--
Phrozen Cure XL (Phrozen)	--	45	--
Mercury X Bundle (Elegoo)	--	30	--

Steam Sterilization:

- Prints must be fully UV post-cured.
- Autoclave: **15 mins at 250°F / 121°C**. No stacking of models in autoclave. Longer or hotter autoclave cycles is not needed.

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.