

FLEX BT TRANSLUCENT (B-FBT1TL)

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 Flex BT Translucnet: resin tank, build platform and wash.

Print Settings:

Brand	Printer Model	Settings
SprintRay (Not endorsed by SprintRay)	Pro 2	SprintRay NightGuard Flex 2 Ocean Blue (100 µm)
	Pro S 95, Pro S 55, Pro 95 & Pro 55	SprintRay IDB 2 (50/100 µm)
Formlabs	Form 4B	To get the latest printing settings, simply visit the ApplyLabWork Support page and download the files for your printer model.
Open system MSLA <ul style="list-style-type: none"> AnyCubic Elegoo Phrozen 	<ul style="list-style-type: none"> M3 Premium, Mono X 6K ... etc. Mars 4, Saturn 3 Ultra ... etc. Mighty Revo, Sonic Mini 8K ... etc 	
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	5 min
Formlabs	FormCure	60°C 5 min
Formlabs	Fast Cure	Intensity = 1, 1 min
Phrozen	Phrozen Cure	5 min
SprintRay	Nano Cure	Die and Model 2
SprintRay	Pro Cure 2	Die and Model 2
SprintRay	Pro Cure	50°C 5 min

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

Note: Pigment settlement is normal. Gently mix remaining resin in resin tank with “resin wiper” for color evenness.