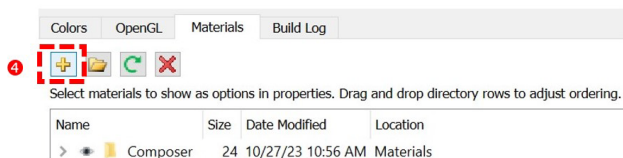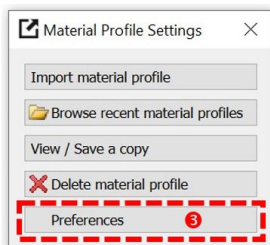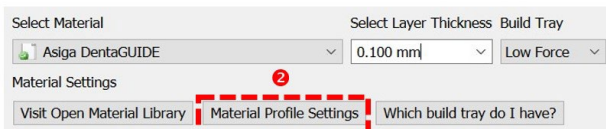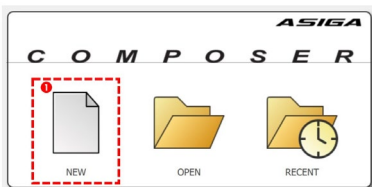# FLEX BT TRANLUCENT
(B-FBT1TL)
Asiga Printers

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

Print Settings:
Visit ApplyLabWork **Support** and download *.ini* printing profile.

Start Composer ➜ NEW ➜ Material Profile Settings ➜ Preferences ➜ ➕ ➜ select the folder where *.ini* was downloaded ➜ select folder ➜ OK

Select **ALW-FLEX-BT** ini using drop-down menu, and then select layer thickness and build tray type.
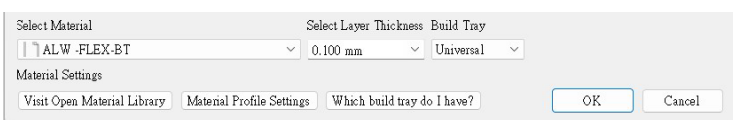
Cleaning: [fresh 95% IPA]

A-bath: For freshed removed parts. Submerge & swish the parts around in the IPA with a gental dental brush to remove uncured resin on the surfaces.

B-bath: Submerged 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 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 (^{o}C)	Time (min)
ProCure (Sprintray)	50	5
Phrozen cure (Phrozen)	--	5
Mercury × Cure (Elegoo)	--	5
FormCure (FormLabs)	60	5
FastCure (FormLabs)	--	1 (Intensity = 1)

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. Gentally mix remaining resin in resin tank with "resin wiper" for color evenness.

Biocompatible Resin