FLEX BT TRANLUCENT
(B-FBT1TL)
FormLabs Form 4B
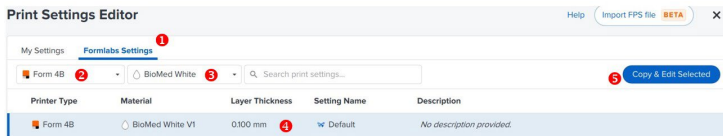### (Open Material Mode)

Checks: Resin is well shakened, Optical pathways are clean, Resin tank condition.
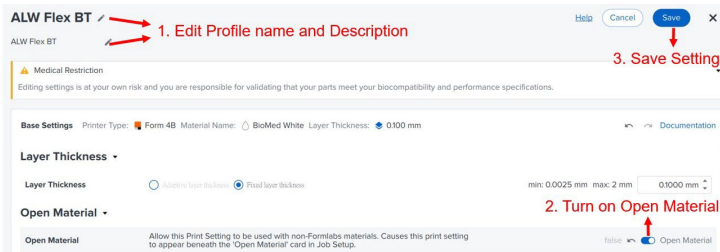
PreForm: Version 3.41.1 and later

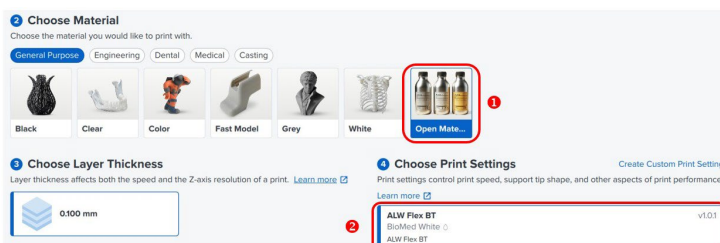### Open Material Settings:
Edit ➜ Print Setting Editor
➜ ❶Formlabs Settings
➜ ❷Form 4B
➜ ❸Select Material: *BioMed White V1*
➜ ❹Select layer thickness: 100 µm
➜ ❺Copy & Edit Selected

Than edit profile name and description (e.g. ALW Flex BT), turn on Open Materail, and save setting.

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

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

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.

Post-Curing:
* **Form Cure:**
  60ºC for 15 mins

* **Fast Cure:**
  Light Intensity 1 for 1 mins

  (Fast Cure needs at least 10 minutes between cure cycles.)

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