

## FLEX BT TRANLUCENT (B-FBT1TL) MSLA

(Open System Printers)

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

### Print Settings:

Examples:

Printer	Layer thickness (mm)	Normal layer exposure time (s)	Bottom layer exposure time (s)
Elegoo Mars 3 Pro	0.1	7.8	15
Elegoo Mars 4 DLP	0.1	7.8	15
Elegoo Mars 4	0.1	7.8	16
Elegoo Saturn S	0.1	9.6	25
Elegoo Saturn 3 Ultra	0.1	7.8	15
Phrozen Mighty 14K REVO	0.1	9	15
Phrozen Mighty 12K	0.1	9.5	15
Phrozen Sonic 4K 2022	0.1	8.5	12
Phrozen Sonic Mini 8K	0.1	7.8	10
Anycubic Photon M3 Premium	0.1	6.8	15
AnyCubic Mono X 6K	0.1	5	15

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

**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 Setting:

Post Curing Chamber	Temperature (°C)	Time (min)
ProCure (Sprintray)	50	5
Phrozen cure (Phrozen)	--	5
Mercury × Cure (Elegoo)	--	5
FormCure (FormLabs)	60	5
FastCure (FormLabs)	--	1 (Intensity = 1)

Allow the print to cool to room temperature. (Avoid external forces, no stacking of 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.

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