

# APPLYLABWORK PRINTING TIPS

(Not endorsed by SprintRay)

## FLEX BT TRANLUCENT (B-FBT1TL)

### SprintRay printers

(Pro 2, Pro S 95 & 55, Pro95 & 55)

**Checks:** Resin is well shaken, Optical pathways are clean, Resin tank condition.

### RayWare Cloud:

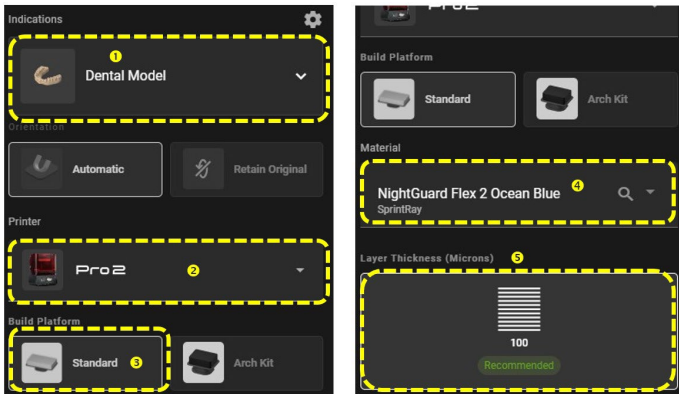
#### Pro 2

Indications: Dental Model

Material:

**SprintRay NightGuard Flex 2 Ocean Blue**

Layer Thickness: 100 Microns

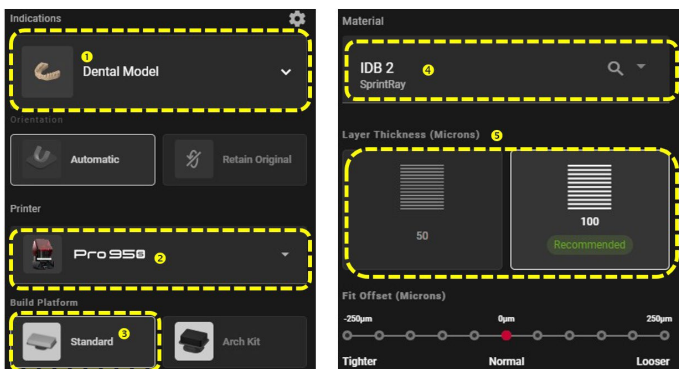


#### Pro S (95 & 55)

Indications: Dental Model

Material: **SprintRay IDB2**

Layer Thickness: 100/50 Microns



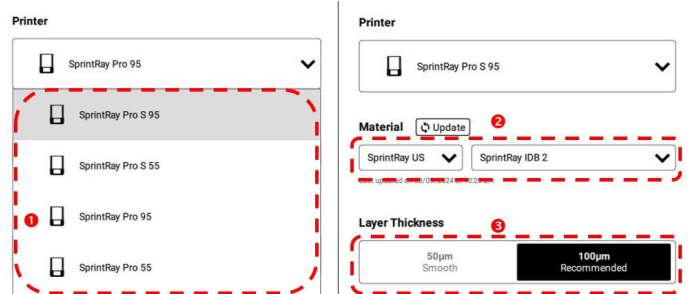
- Offset is an optional function that depends on the printer's intensity variation.
- The recommended offset value is 0 µm.

**RayWare Desktop:** version 2.9.2 and later

#### Pro S (95 & 55) & Pro (95 & 55)

Material: **SprintRay US** → **IDB2**

Layer Thickness: 50/100 µm



For detailed calibration, please refer to [Tips](#) for dimension and tolerance testing

**Cleaning:** [fresh 95% IPA]

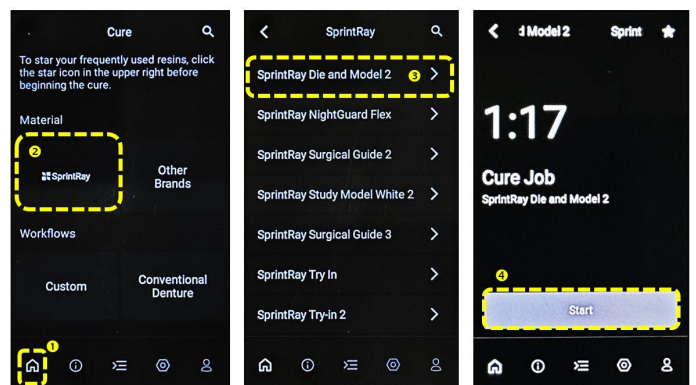
**A-bath:** For fresh removed parts. Submerge & swish the parts around in the IPA with a gentral dental brush to remove uncured resin on the surfaces.

**B-bath:** Submerged models from A-bath for 3 mins.

**Total IPA clean time should not exceed 5 minutes.**

### Post-Curing:

- **Nano Cure** (Software version 1.0.9 and later)



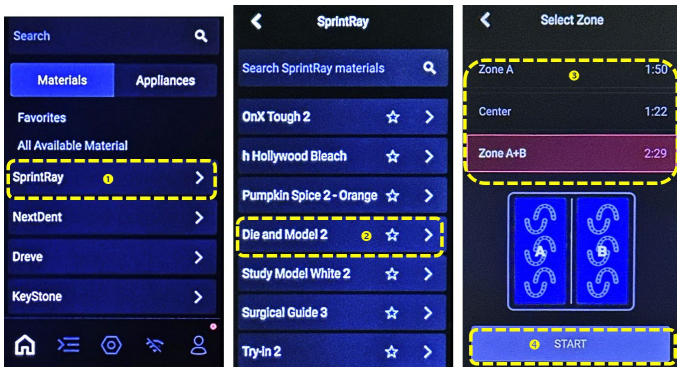
Select **Material** → **SprintRay** → **SprintRay Die and Model 2**, and then select **Start**.

## Biocompatible Resin

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- **Por Cure 2** (version 1.2.12 and later)



Select **Material** → **Sprintray** → **Die and Model 2**, and then select exposure zone.

## 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.