

FORM 2 & 3 PRINTER Laser Modeling – Gray (M200-R001GY)

Check:

- UV optical pathways are clean
- Vat is free of defect
- Resin is well shakened

Open-Mode (Form2):

Printer at idle

1. Tap touchscreen “Printer” icon, open “Settings” menu
2. Select Open Mode
3. Select On

Cartridge (Form2 & 3):

Refill corresponding cartridge e.g. FormLabs Draft version 2 cartridge. Open air vent, turn cartridge upside down, drip dry through air vent for 10 mins to minimize cross contamination, refill, shake well for 2 mins, insert & print (may work up to 2 refills before locked by FL software)

Warning: Cross contamination of resins could cause size inaccuracy or wavy line.

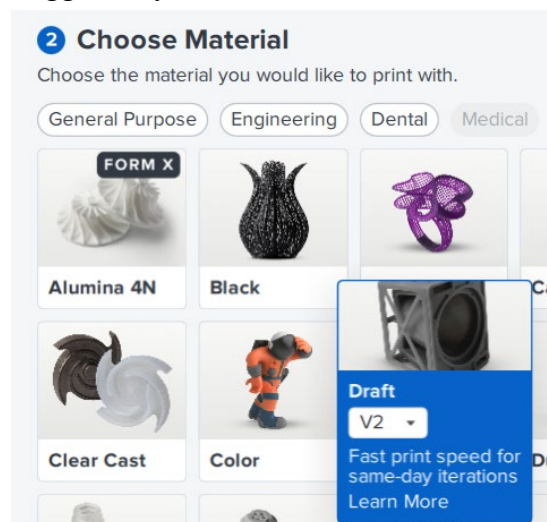
[Open Material Mode for Form 3 generation](#)

PreForm Setting:

Select Printer: Form2 or Form3

Material Select: **Draft and V2**

Suggest Layer Thickness 200~100



Washing:

IPA 95%, maximum for up to 5 minutes, gently shake-off / blow-off excess IPA quickly, set print in a shaded airy place to dry completely before curing.

Extended time in IPA causes deformation.

Dried print might be a little tacky to touch.

Post-curing (Necessary):

For optimal material performance:

FormCure **60 °C / 5 mins**. Start FormCure from room temperature.

Storage:

- Keep resin away from heat & light.
- NOT accessible to children.
- Filter used resins before storage.

Note:

- Keep print environment well ventilated.
- Avoid direct contact to skin or eyes. Rinse cautiously with water / soap and water for several minutes if contact to eyes / skin.
- Wear chemically-resistant gloves like nitrile or neoprene (not latex) when handling.
- DO NOT pour uncured resin down the drain. Abandoned resin can be cured by sunlight before discarding.
- Unless specifically indicated, Modeling200 resin is NOT approved for use with food, drink, or on/in the human body.

WARNING:

Contact may cause eye or skin irritation and allergic reaction.