

Form 3 Series Printers Laser Spring Black (PT-SP001BK)

Check:

- Resin tank and optical path are clean
- Shake resin bottle well before use

Cartridge:

Refill this resin into Durable-V2 cartridge.

Open air vent, turn cartridge upside down, drip dry through air vent for at least 5 minutes to minimize cross contamination, refill, shake well, insert and print.

Warning: Resin cross contamination could cause size inaccuracy or wavy line

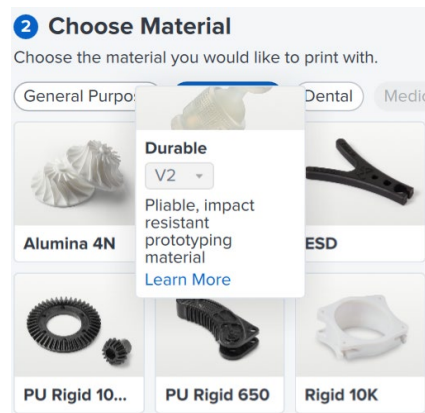
[Open Material Mode for Form 3 generation](#)

PreForm Setting:

Select Printer: Form3 series

Select Material: **Durable V2**

Suggest Layer Thickness: 100µm



* please avoid any large aspect-ratio geometry (e.g. thin wall or long rod) in the object to reduce failures.

Washing:

Wipe off excess resin on prints with paper towel, submerge into 95% IPA and place the container in ultrasonic bath, wash for 5 minutes. Replace by clean IPA and repeat ultrasonic washing for another 5 minutes (total 10 minutes). Blow off all excess IPA and set parts in a shaded airy place to dry at least 2 hours before curing.

* Dried print will be tacky to touch

Post-curing (**Mandatory**):

Submerge the parts into **glycerol/glycerin** (CAS # 56-81-5) and start **FormCure** with **60 °C / 30 mins** setting. Wash off glycerol in water and dry off with paper towel.

*If prints don't sink completely into glycerol, add water (no more than half of volume) to adjust liquid density.

If prints are still tacky to touch after post-curing, rinse with **acetone (CAS # 67-64-1) for no more than 1 minute will significantly reduce tackiness.

Storage:

- Do NOT keep the resin in the tank more than one week. Pour out the resin and gently wipe the tank with paper towel and IPA.
- Keep resin away from heat and light.
- NOT accessible to children.

Note:

- Keep printing environment well **ventilated**.
- Wear gloves when handling Spring resin and avoid direct contact.
- Vibration of the parts during printing might cause resin splash onto printer's cover. Use paper towel and IPA to clean immediately.
- Spring resin is sensitive to resin tank quality. Please use a new tank to print if repetitive failure occur, even within Form 3 tank lifetime.
- Spring resin should NOT use with food, drink, or on/in the human body unless specifically indicated.