

## DLP Modeling – Gray V3 (DMD-R003GY) SprintRay (Pro95, Pro55, Pro S 95 & Pro S 55)

### Check:

- UV optical pathways are clean
- Resin tank is free of defect
- Resin is well shaken
- Do Not overfill resin tank

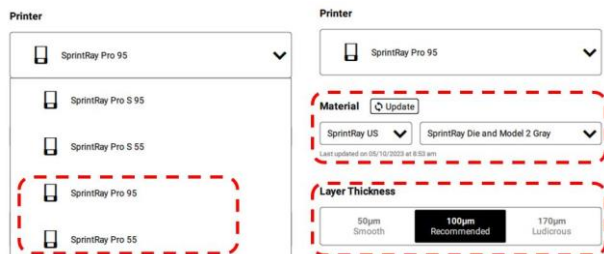
**RayWare:** version 2.9.2 and later

### Print Setup:

Select Printer: **Pro 95 & Pro 55**

Select Material:

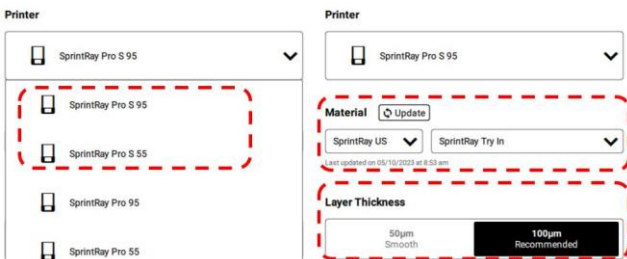
**SprintRay US → Sprintray Die and Model 2 Gray**  
Layer Thickness : 50/100/170 µm



Select Printer: **Pro S 95 and Pro S 55**

Select Material: **SprintRay US → Try In**

Layer Thickness : 50/100 µm



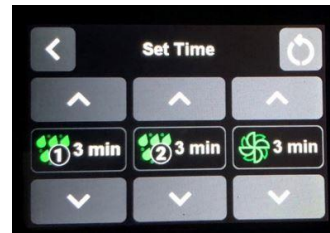
Load 3D model and double check supports and orientation are optimal before print.

- When printing arches directly on build-platform, vertically or horizontally, supports are not needed.
- For detailed calibration, please refer to [Dimension and Tolerance](#).

### Washing:

Submerge print in clean IPA for **5 minutes** with vigorous stirring (e.g. Sprintray Pro Wash/Dry, FormWash or ultrasonic bath), gently shake-off / blow-off excess IPA, set print in a shaded airy place to dry completely before curing.

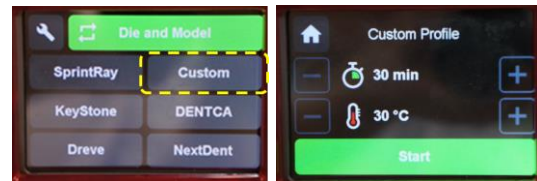
- Pro Wash/Dry: ① 3 min + ② 3 min + Dry 3 min:



Extended wash time could cause deformation. Dried prints may be tacky to touch.

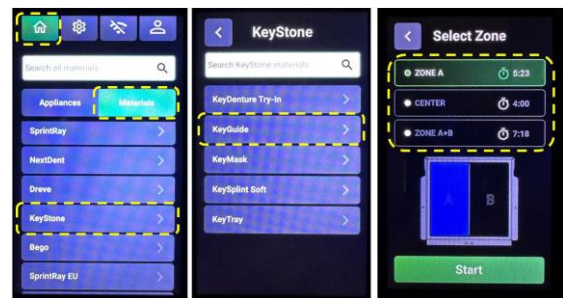
### Post-Curing:

- Pro Cure 1 (Firmware version 1.73 and later)



Select **Custom**, and then select the conditions as **30°C for 30 min**.

- Por Cure 2 (Firmware version 1.2.12 and later)



Select **Material → KeyStone → KeyGuide**, and then select **exposure zone**

### Storage:

DO NOT keep resin in the tank for more than **2 days**. Filter out all debris in the case of fail print jobs

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