

## DLP Modeling – Gray V3 (DMD-R003GY) for SprintRay (D75, S100, Pro95, & Pro55)

### Check:

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

**RayWare:** version 2.7.2 and later

### Print Setup:

Select Printer Model

Material : **SprintRay Die and Model 2 Gray**

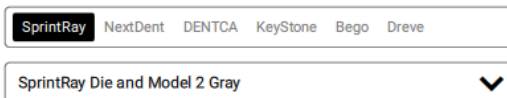
Layer Thickness : **50 / 100 / 170µm**

#### Printer

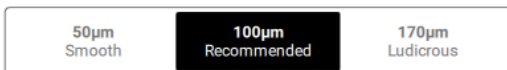


#### Material

▲ Sign in to see all available materials.



#### Layer Thickness



Layer thickness determines the height of each layer. Lower values can produce more cosmetic smoothness but increase print time.

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](#).

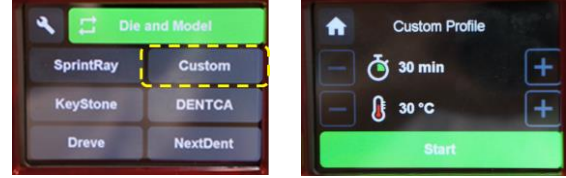
### Washing

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

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

### Post-Curing

Pro Cure (Firmware version 1.51 and after)



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

### Storage

**DO NOT** store resin in the tank for more than **3 days** if not printing. Filter out all debris in the case of failed print jobs.

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