

DLP Modeling Sand

(DMD-R001SD)

SprintRay

(Pro95, Pro55, Pro s 95 & Pro s 55)

Check:

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

RayWare: version 2.9.2 and later

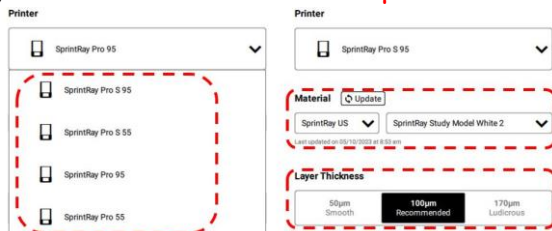
Print Setup:

Select Printer

Select Material :

SprintRay US → SprintRay Study Model White 2

Layer Thickness : 50 / 100 / 170µm



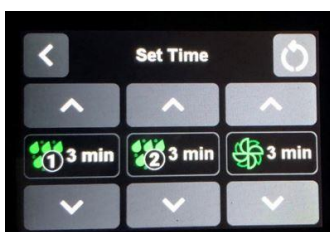
Load 3D model and double check supports and orientation are optimal before print.

- 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. Sprinray 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.

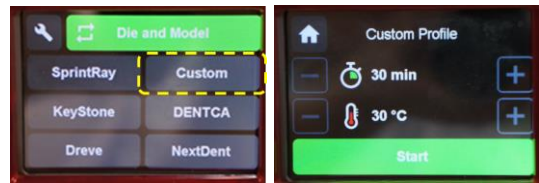
- For Sprinray Pro Wash/Dry, please select **1 3 min + 2 3 min + Dry 3 min:**



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

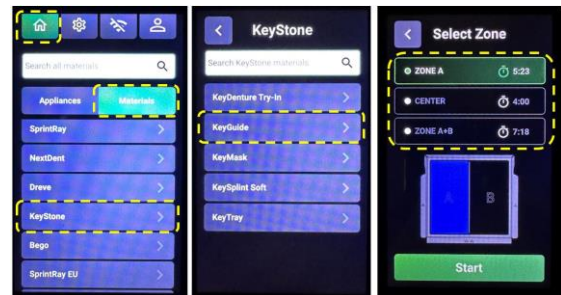
Post-Curing:

- **ProCure 1** (Firmware version 1.73 and later)



Select **Custom**, and then select the conditions as **30°C for 15 min.**

- **PorCure 2** (Firmware version 1.2.12 and later)



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

Models will a visible yellowhue, after ProCure, which diminishes over 3~4 days.

Yellowhue reduction:

Bring tap water to boil, switch heat off, submerge models in hot water for 5 mins.

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 “soft-wiper” for color evenness.