

DLP SG Clear (DSP-SG001CR)

Check: Well shaken resin, Clean optical pathways, Good resin tank condition.

Recommendation:

Prevention of cross-contamination with other non-bio resins ensures optimal biocompatibility for printed models. Dedicate accessories for DLP SG Clear: resin tank, build platform and wash.

Printer Settings:

Brand	Model	Settings
Asiga	Pro 4K UV385, Max UV385	To get the latest printing settings, simply visit the ApplyLabWork Support page and download the files for your printer model.
Formlabs	Form 4B	
Open system MSLA ● Anycubic ● Elegoo ● Phrozen	● M3 Premium, Mono X 6K ...etc. ● Mars 5 Ultra, Saturn 3 Ultra ...etc. ● Mighty 12K, Sonic Mini 8K ...etc.	
HeyGears	UltraCraft Reflex	PAS10 (50 µm)
	UltraCraft Reflex RS	PARP100C (50 µm)
SprintRay (Not endorsed by SprintRay)	Pro 2, Pro 95 S, & Pro 55 S	SprintRay Try-In 2 (50/100 µm)
	Pro 95 & Pro 55	SprintRay IDB 2 (50/100 µm)

Note: Each printer is unique, and light intensity can vary even among identical models. Minor adjustments may be necessary, especially true for open-system MSLA printers.

Cleaning: [fill fresh 95% IPA in two baths]

A-bath: Submerge and agitate printed models in IPA. Use toothbrush to gently remove uncured resin quickly on the model surfaces. Transfer cleaned model to B-bath.

B-bath: Submerge cleaned models from A-bath for **3 minutes**.

Total IPA clean time should not exceed 5 minutes.

Drying:

Blow dry the models with compressed air, let models **sit dry 25 minutes minimum** in a shaded airy place. Printed parts must be free of IPA before UV post-curing. Extended wash time and residual IPA (if not dried completely) causes deformation and lower mechanical properties.

Biocompatible Resin

UV Post-Curing Setting (Required):

Brand	Post-Curing Chamber Model	Mode / Program	Settings
Elegoo	Mercury Cure	Manual setting	30 min
Formlabs	Form Cure	Select Custom Profile	30 min 60 °C
Formlabs	Fast Cure	Select Create Custom Preset	Time: 1 min Light intensity: 5
HeyGears	UltraCraft Cure	Select Customize	UV: 15 min Heat: Off
NK Optik	Otoflash	Manual setting	Number of flashes: 3,000 (w/o N₂)
Phrozen	Phrozen Cure	Manual setting	30 min
Phrozen	Phrozen Cure XL	Manual setting	45 min
SprintRay	NanoCure	Select Custom	Heat cure: Off UV cure: 2 min 09 sec Cool cure: Off
SprintRay	ProCure 2	Select Surgical Guide 3	Zone A+B 4 min 55 sec¹
SprintRay	ProCure	Select Custom	15 min 30 °C

¹Automatically set by the selected program; no manual entry is required.

Allow the models to cool naturally to room temperature after curing. (Avoid external forces, no stacking of models during cooling.)

Sterilization:

a. Models must be fully post-cured before autoclave.

b. Autoclave: **15 minutes at 121°C / 250°F or 20 minutes at 134°C/273°F**. No stacking of models in autoclave. Longer or hotter autoclave cycle is not needed.

Color Change:



APPLYLABWORK PRINTING TIPS

c. Allow the print to cool to room temperature. Avoid forces to the models during cooling.

Storage:

Filter out all debris in used-resin before storage. Keep resin in the original bottle, storage temp (15-26°C / 59-79°F) in a dry and dark area.