

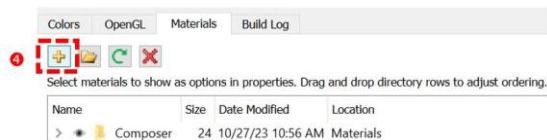
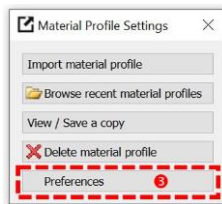
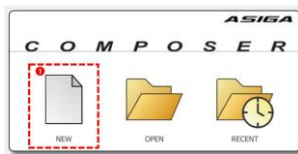
## DLP SG Clear (DSP-SG001CR) Asiga Printers

**Check:** Resin is well shakened, Optical pathways are clean, Resin tank in good condition.

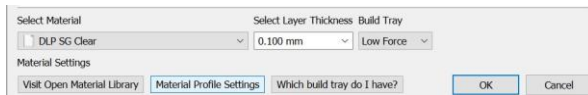
### Print Settings:

Visit ApplyLabWork [Support](#) and download *.ini* printing profile.

Start Composer → NEW → Material Profile Settings → Preferences →  → select the folder where *.ini* was downloaded → select folder → OK



Select **DLP SG Clear** ini using drop-down menu, and then select layer thickness and build tray type.



Note, Do not place supports near the guide sleeve holes or on the intaglio surfaces.

**Cleaning:** A&B IPA bath [fresh 95% IPA]

**A-bath:** Submerge freshed removed parts in A-bath. Swish the parts around in the IPA, with a gental dental brush to remove uncured resin on the surfaces. Transfer to B-bath.

**B-bath:** Submerged for **3 mins**.

**Total IPA clean time should not exceed 5 minutes.**

Blow dry the models with compressed air, let models **sit dry completely, 25 mins minimum**, in a shaded airy location. **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.

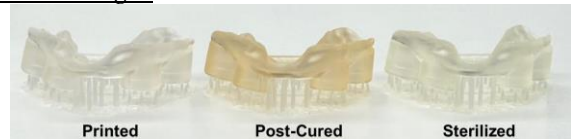
### UV Post-Curing:

UV post-curing is required before sterilization. Curing setting: **Mercury X Bundle (Elegoo) 30 minutes.**

### Steam Sterilization:

- Prints must be fully UV post-cured.
- Autoclave: **15 mins at 121°C / 250°F**. No stacking of models in autoclave. Longer or hotter autoclave cycles is not needed.

### Color change:



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

### Storage:

Keep the resin in the original bottle, room temperature (15-26°C / 59-79°F) in a dry and dark area. Filter out all debris in the case of fail print jobs.