

APPLYLABWORK PRINTING TIPS

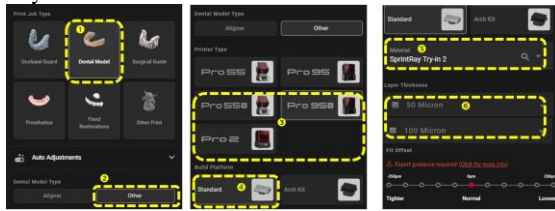
(Not endorsed by SprintRay)

DLP SG Clear (DSP-SG001CR) SprintRay printers (Pro 2, Pro S 95 & 55, Pro95 & 55)

Checks: SG Resin is well shaken, Optical pathways are clean, Resin tank condition.

RayWare Cloud:

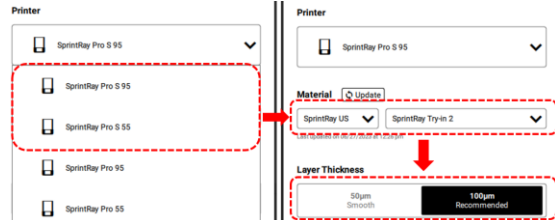
Job Type: Dental Model
Dental Model Type: Other
Printer: **Pro 2, Pro S 95, & Pro S 55**
Material: **SprintRay Try-In 2**
Layer Thickness: **50/100 Micron**



- Offset is an optional function that depends on the printer's intensity variation.
- The recommended offset value is 0 µm.

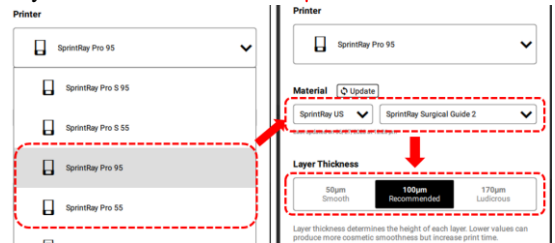
RayWare Desktop: version 2.9.2 and later **Pro S (95 & 55)**

Material: **SprintRay US → Try-In 2**
Layer Thickness : **50/100 µm**



Pro (95 & 55)

Material: **SprintRay US → SprintRay Surgical Guide 2**
Layer Thickness : **50/100/170 µm**



For detailed calibration, please refer to [Tips](#) for dimension and tolerance testing

Avoid placing supports near the guide sleeve holes and on the intaglio surfaces. Inspect support locations to add or remove supports as needed.

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

A-bath: Submerge freshly removed parts in A-bath. Swish the parts around in the IPA, with a gentle 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.

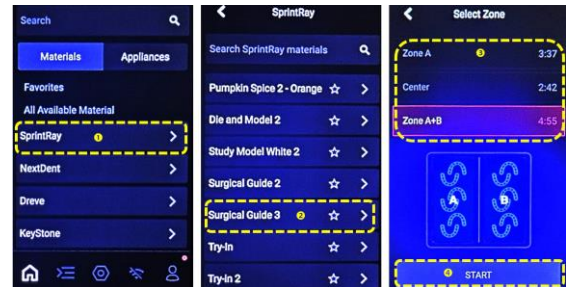
Post-Curing:

- **Pro Cure 1** (version 1.73 and later)



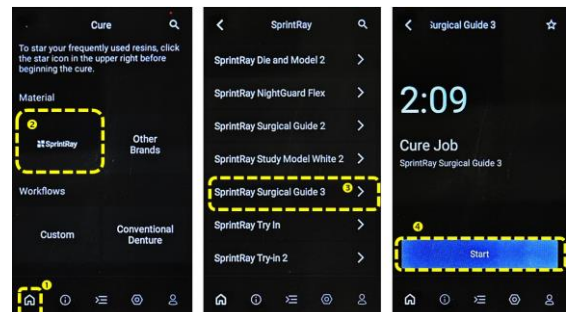
Select **Custom**, then select the conditions as **30°C for 15 mins**.

- **Por Cure 2** (version 1.2.12 and later)



Select **Material → SprintRay → Surgical guide 3**, and then select **exposure zone**.

- **Nano Cure** (Software version 1.0.9 and later)



Select **Material → SprintRay → SprintRay Surgical guide 3**, and then select **Start**.

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Sterilization:

- a. Models must be fully post-cured before autoclave.
- b. Autoclave: **15 mins at 121°C / 250°F**. No stacking of models in autoclave. Longer or hotter autoclave cycle is not needed.

Color Change:



- c. 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.