

## FormLabs SLA Printers Laser EXPERT Black (PT-EX001BK)

### Check:

- UV optical pathways are clean
- Vat is free of defect
- Resin is well shakened

### Open-Mode (Form2 only):

Printer at idle

1. Tap touchscreen “Printer” icon, open “Settings” menu
2. Select Open Mode
3. Select On

### Cartridge:

Refill corresponding cartridge e.g., FormLabs Grey version 4 cartridge. Open air vent, turn cartridge upside down, drip dry through air vent for 5 mins to minimize cross contamination, refill, shake well for 2 mins, insert & print (may work up to 2 refills before locked by FL software)

Other online solution: [Universal Cartridge](#)

### PreForm Setting:

Select Printer: Form2, Form3 or ...

Material Select: **Grey and V4**

**Suggest Layer Thickness 100~25**

The screenshot shows the 'JOB SETUP' dialog box in the PreForm software. It is divided into several sections: 'Printer' with a dropdown menu set to 'VIRTUAL PRINTER Form 3'; 'Material' section with three dropdown menus: 'Resin' set to 'Grey', 'Version' set to 'V4 (FLGPR04)', and 'Print Setting' set to 'Default'; and 'Layer Thickness' section with a slider ranging from 160 microns (Fastest Print) to 25 microns (Highest Resolution), with the current value set at 50 microns. At the bottom, there are 'Cancel' and 'Apply' buttons.

### Washing:

IPA 95%, maximum for up to 5 minutes, gently shake-off / blow-off excess IPA quickly, set print in a shaded airy place to dry completely before curing.

Extended time in IPA causes deformation.

Dried print might be a little tacky to touch.

### Post-curing (Necessary):

For optimal material performance:

FormCure **60 °C / 60 mins**. Start

FormCure from room temperature.

### Storage:

- Keep resin away from heat & light.
- NOT accessible to children.
- Filter used resins before storage.

### Note:

- Keep print environment well ventilated.
- Avoid direct contact to skin or eyes. Rinse cautiously with water / soap and water for several minutes if contact to eyes / skin.
- Wear chemically resistant gloves like nitrile or neoprene (not latex) when handling.
- DO NOT pour uncured resin down the drain. Abandoned resin can be cured by sunlight before discarding.
- Unless specifically indicated, EXPERT resin is NOT approved for use with food, drink, or on/in the human body.

### WARNING:

Contact may cause eye or skin irritation and allergic reaction.