

Form 3 Series Printers Laser Modeling Clear V2 (MD-R002CR)

Check:

- Resin tank and optical path are clean
- Shake resin bottle well before use

Cartridge:

Refill this resin into Clear-V4 cartridge.
Open air vent, turn cartridge upside down, drip dry through air vent for at least 5 minutes to minimize cross contamination, refill, shake well, insert and print.

Alternative solution: Universal Cartridge
[North America](#) , [Other Regions](#)

PreForm Setting:

Select Printer: Form3 series

Select Material: **Clear V4**

Layer Thickness: 25-100µm

Resin	Clear V4
Layer Thickness	0.050 mm
Print Setting	Default

Washing:

Clean IPA95% or higher, FormWash or ultrasonic cleaner for

5 minutes, after wash shake off or blow off residual IPA, allow print to dry for 60 mins in a shaded & ventilated area before UV post curing. (Dried print might be slightly tacky to touch.)

Post-curing:

Optimal transparency for visual aid models, skip post-curing.

For minimizing yellowing:

FormCure **35 °C / 15 mins**.

To achieve optimal mechanical strength:

FormCure **60 °C / 30 mins**.

Yellow hue from post-curing fades in one week.

Storage:

- Keep resin away from heat and light.
- NOT accessible to children.

Note:

- Keep printing and post-process environment well ventilated.
- Wear gloves when handling resin and avoid direct contact.
- Repetitive printing will cause yellowing of clear-v2 resin. Pour only needed volume for each print job.
- For ease of model removal, apply Default Clear V4 support setting without a raft.