

APPLYLABWORK PRINTING TIPS


MSLA Modeling Sand (MMD-R001SD)

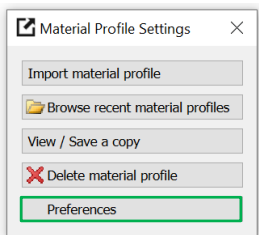
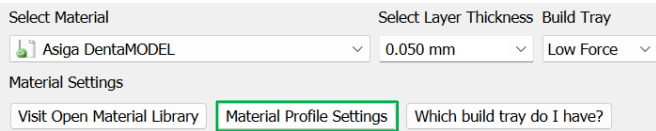
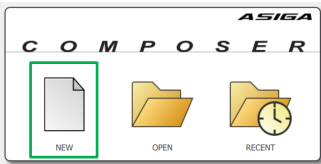
For Asiga Max UV385 & PR04K UV385

Resin is well shakened & Optical pathways are clean.


Print Settings:

Download .ini from ApplyLabWork [support page](#).

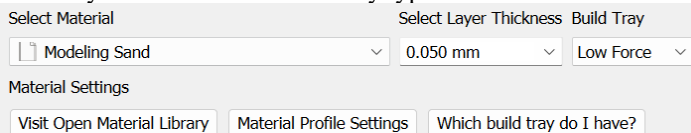
Start Composer → NEW → Material Profile Settings
→ Preferences →  → select the folder where ini was downloaded → Select Folder → ok



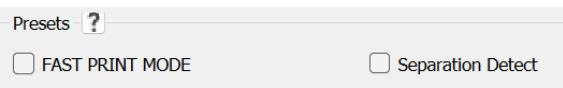
Select materials to show as options in properties. Drag and drop

Name	Size	Date Modified	Location
>  Composer	24	4/29/24 6:07 AM	Materials

Select **Modeling Sand** in drop-down menu, and then select layer thickness and build tray type.



Note, both **FAST PRINTING MODE** and **Separation Detect** are **NOT recommended** with Modeling Sand. **Keep them unchecked** in Build Wizard before sending file



Washing

Submerge print in clean IPA bath for **5 minutes**, blow off excess IPA, set print in a shaded, well ventilated place to dry before curing.

Curing

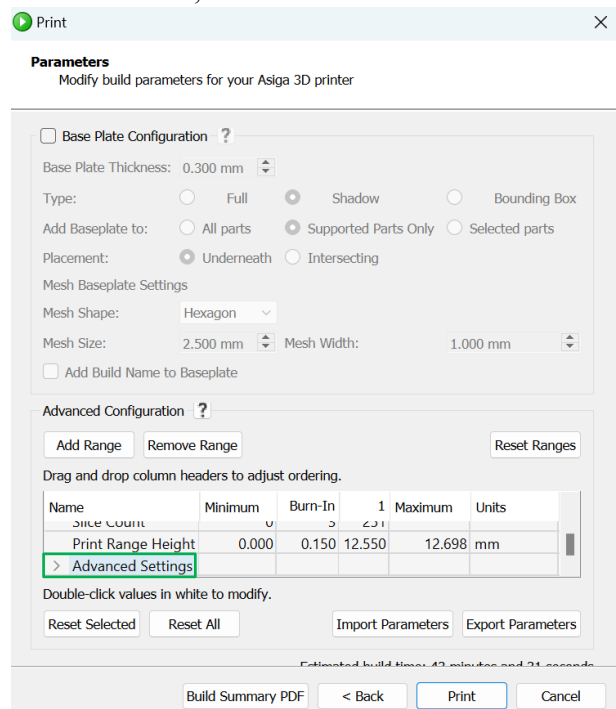
Asiga Flash 30 minutes or
Mercury X(Elegoo) 30minutes

Storage and Handling

- Keep environment 15-26°C / 59-79°F
- Not accessible to children
- Filter resin in case of fail prints.
- Slight pigment settlement is normal. Gently mix remaining resin in resin tray with **rubber spatula** for color evenness.

Dimension Fine Tuning

Printer varies from one to another. If there's slight deviation in dimension, open **Advanced Settings** and adjust **XY compensation** value in "1" column before sending to printer. The larger the negative number, the smaller the size, and vice versa.



Name	Minimum	Burn-In	1	Maximum	Units
Slice Count	0	3	251		
Print Range Height	0.000	0.150	12.550	12.698	mm
Advanced Settings					
Heater Temperature	0.0	27.0	27.0	50.0	°C
Minimum Temperature	0.0	27.0	27.0	50.0	°C
Heater Enable	0	1	1	1	
Light Intensity	0.01	10.00	10.00	11.28	mW/cm ²
Light Intensity Control	0	1	1	1	
Exposure Time	0.017	3.690	1.150		s
Fill Exposure	25.00	100.00	100.00	400.00	%
Z Compensation	0.000	0.170	0.060	5.000	mm
XY Compensation	-2.000	-0.040	-0.040	2.000	mm