

Tray Orange (B-TY1OG)

Check: Well shaken resin, Clean optical pathways, Good resin tank condition.

Recommendation:

Prevention of cross-contamination with other non-bio resins ensures optimal biocompatibility for printed models. Dedicate accessories for Tray Orange: resin tank, build platform and wash.

Printer Settings:

Brand	Model	Settings
Asiga	Pro 4K UV385, Max UV385	To get the latest printing settings, simply visit the ApplyLabWork Support page and download the files for your printer model.
Formlabs	Form 4B, Form4	
Open system MSLA ● Elegoo ● Phrozen ● Anycubic	● Mars 5 Ultra, Saturn 4 ...etc. ● Mighty 12K, Sonic Mini 8K ...etc. ● M3 Premium ...etc.	
HeyGears	UltraCraft Reflex	PAU20 (100 µm)
SprintRay (Not endorsed by SprintRay)	Pro 2	SprintRay Study Model White 2 (100 µm)
	Pro 95 S	SprintRay IDB 2 (100 µm)
	Pro 95	SprintRay Catable 2 (100 µm)

Note: Each printer is unique, and light intensity can vary even among identical models. Minor adjustments may be necessary, especially true for open-system MSLA printers.

Cleaning: [fill fresh 95% IPA in two baths]

A-bath: Submerge and agitate printed models in IPA. Use toothbrush to gently remove uncured resin quickly on the model surfaces. Transfer cleaned model to B-bath.

B-bath: Submerge cleaned models from A-bath for **3 minutes**.

Total IPA clean time should not exceed 5 minutes.

Drying:

Blow dry the models with compressed air, let models **sit dry 25 minutes minimum** in a shaded airy place. 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.

Biocompatible Resin

UV Post-Curing Setting (Required):

Brand	Post-Curing Chamber Model	Mode / Program	Parameters to Enter or Confirm
Elegoo	Mercury Cure	Manual setting	60 min
Formlabs	Form Cure	Select Custom Profile	30 min 60 °C
HeyGears	UltraCraft Cure	Select Customize	UV: 60 min Heat: Off
NK Optik	Otoflash	Manual setting	Number of flashes: 2,000 (w/o N₂)
SprintRay	NanoCure	Select Custom	Heat cure: On — 30 sec UV cure: 4 min 51 sec Cool cure: Off
SprintRay	ProCure 2	Select Try-In 2	Zone A+B 14 min 39 sec¹

¹Automatically set by the selected program; no manual entry is required.

Allow the models to cool naturally to room temperature after curing. (Avoid external forces, no stacking of models during cooling.)

Storage:

Filter out all debris in used-resin before storage. Keep resin in the original bottle, storage temp (15-26°C / 59-79°F) in a dry and dark area.

Note: Pigment settlement is normal. Gently mix remaining resin in resin tank with soft “resin wiper” for color evenness.