

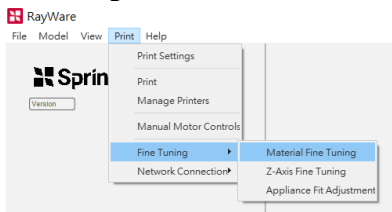
D75, S100, Pro 55 & Pro95 Tolerance and Dimension

1. Tolerance:

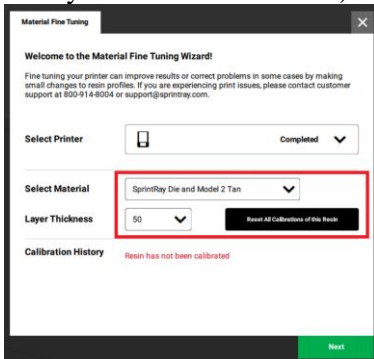
Tolerance Calibration (exposure adjustment), is recommended for first use of new resin. Also as printer age recalibration is necessary to compensate weakening of UV output thus maintaining consistent accuracy.

1.1. Open the RayWare (version 2.8.8 and later) and connected to printer.

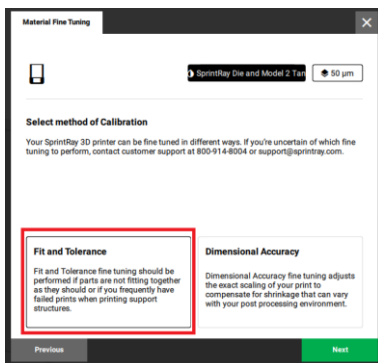
1.2. Select Print → Fine Tuning → Material Fine Tuning:



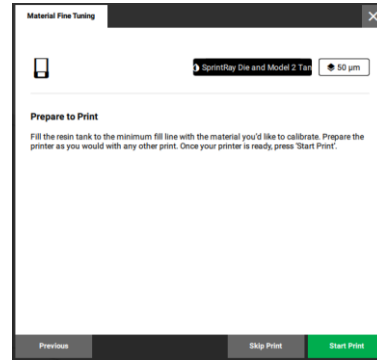
1.3. Select the material and layer thickness for calibration: (Example: ApplyLabWork DLP Modeling Tan v3 used SprintRay Die and Model 2 Tan profile, select Sprintray Die and Model 2 Tan)



1.4. Select **Fit and Tolerance** (this test should always be *performed before* dimensional accuracy):



1.5. Ready printer, resin tank, and build plate, and fill the resin tank to minimum fill line. **Start Print.**



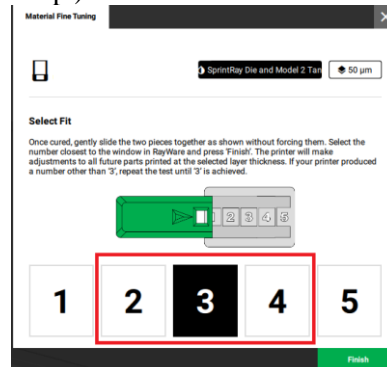
1.6. Clean and postcure the prints following ApplyLabWork printing tips of the selected resin.

1.7. Record the number that the window reaches without forcing them together.

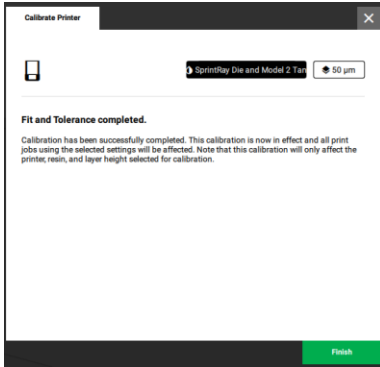


1.8. Entering the fitting score.

After printing is done RayWare will prompt score input. (if disconnected during calibration process, returning to calibration screen by going back through the calibration menu and hitting "Skip print" instead of "Start Print" on the last step.)



APPLYLABWORK PRINTING TIPS



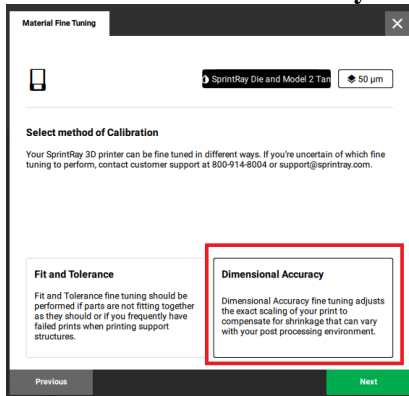
Score of 2-4 indicates that the parts are fitting within the expected tolerances, and you can proceed with normal printing. If score is 1 or 5, please enter score accordingly. Followup to reprint, starting from Step 1.2.. (each repeating cycle should move the fitting closer to score 3)

2. Dimension:

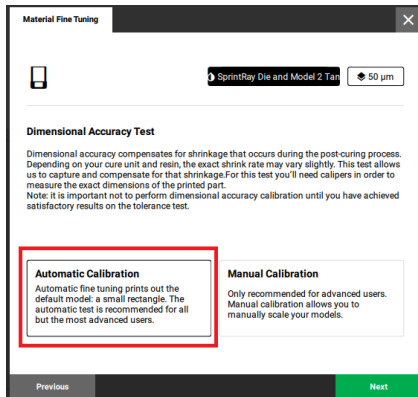
Dialing in X and Y accuracy. It is best to perform the Fit and Tolerance test first before Dimension calibration.

2.1. Select Print → Fine Tuning → Material Fine Tuning on RayWare. Make sure you select the correct Material and Layer Thickness. (ref step 1.1~1.2)

2.2. Select **Dimensional Accuracy**

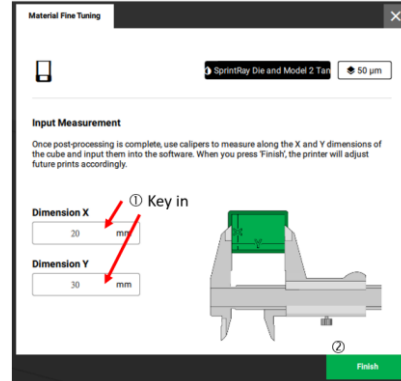


2.3. Select **Automatic Calibration**



2.4. Ready printer then start print. Next, clean and postcure the printed cube. (ref step 1.5~1.7)

2.5. Measure the printed cube and enter the measured value (down to the second decimal place in Metric.) then Click Finish.



Now, your printer is calibrated.