

Modeling – black color

- Double check VAT is clean and PDMS is free of defect
- Shake Well before pouring resin into VAT
- When adding new resin to printed resin, gently mix resin with a small spatula
- Do Not overfill VAT's maximum resin line

FormLabs' PreForm:

Printer Model	Form 2	
Material	Form 1	L
	Form 1+ ✓ Form 2	U
ayer Thickness		(mm)
astest Print		Highest Resolution
.1		0.05
ow to check which	resin version you have.	0

Form 2	
Black	V1 (FLGPBK01)
Grey	
High Temp	(mn
Model	Highest Resolutio
Tough	
White	
Clear	0.02
Flexible	
	. 0
Black	
	Grey High Temp Model Tough White Clear

Printer Model	Form 2	
Material	Black	V1 (FLGPBK01)
Layer Thickness		V3 (FLGPBK03) V2 (FLGPBK02)
		✓ V1 (FLGPBK01)
0.1	0.05	C
How to check which	resin version you ha	ive.

Select desired Printer Model

Material Select: Black and V1(FLGPBK01)

Print Setup		>
Printer Model	Form 2	•
Material	Black -	V1 (FLGPBK01) +
Layer Thickness Fastest Print		(mm) Highest Resolution
0.1	0.05	0.025
How to check which re	esin version you have.	0
Cancel		Apply

Select desire Layer Thickness
Click: Apply
Load 3D model

After print is loaded, double check support and orientation is optimal before print

Finishing

Submerge print in IPA for up to 5 minutes Lift print out of IPA after 5 minutes (extended period in IPA causes deformation) Gently get rid of excess IPA, set print in a shaded dry airy place to dry Dried print might be a little tacky to touch

Curing

Required curing conditions for optimal material performance: Light wavelength: 405nm Total light energy per unit area required on the print: 648,000mJ/cm² *Example:* Light power on the print = 40mW/cm², (higher power per unit area shortens curing time) 648,000mJ / 40mW / 60sec = 270 minutes of curing time Controlled curing chamber temperature between: 30~40° C / 86~104°F

Storage

Leftover resin may be left in the VAT for next print job without cleaning Filter out all debris in the case of fail print Cover VAT lid and store in cool temp (15~26°C/59~79°F), dry and keep away from light