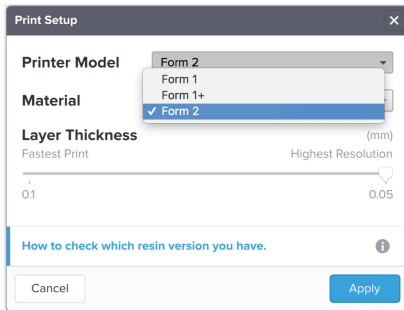


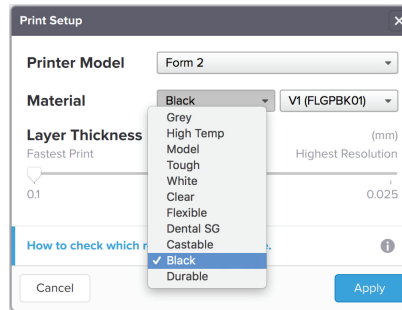
Modeling – black color

- 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

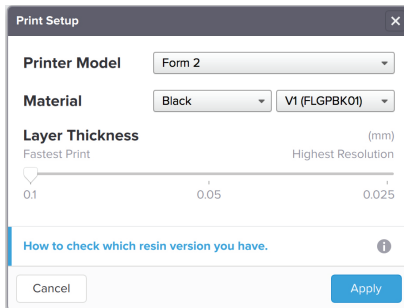
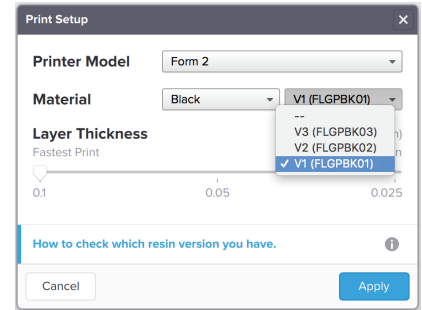
FormLabs' PreForm:



Select desired Printer Model



Material Select: Black and V1 (FLGPBK01)



1. Select desire Layer Thickness
2. Click: Apply
3. 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