

FORM 2 & 3 PRINTER Laser Modeling – Black V2 (MD-R002BK)

Check:

- UV optical pathways are clean
- Vat is free of defect
- Resin is well shakened

Open Mode (Form2):

Printer at idle

1. Tap touchscreen “Gear” icon, open “Settings” menu
2. Select Open Mode
3. Select On

Cartridge (Form2 & 3):

Refill corresponding cartridge
e.g. FormLabs Black version 4 cartridge.
Open air vent, turn cartridge upside down,
drip dry through air vent for 10 mins to
avoid cross contamination, refill, shake
well for 2 mins, insert & print (may work
up to 2 refills before locked by FL
software).

Warning: Cross contamination of resins
could cause size inaccuracy or wavy line.

Alternative Solution: [North America](#) , [Other Regions](#)

PreForm:

Select Printer: Form 2 or Form 3

Material: **Black V4 (FLGPBK04)**

Layer Thickness Select: 100~25

The screenshot shows the PreForm software interface. At the top, the printer is identified as 'VIRTUAL PRINTER Form 3'. Under the 'Material' section, 'Resin' is set to 'Black', 'Version' is 'V4 (FLGPBK04)', and 'Print Setting' is 'Default'. The 'Layer Thickness' section shows a slider between 'Fixed' and 'Adaptive' modes, with the value set to 50 microns. The slider also indicates 'Fastest Print' at 100 microns and 'Highest Resolution' at 25 microns. 'Cancel' and 'Apply' buttons are visible at the bottom.

Washing

IPA 95%, maximum for up to 5 minutes,
gently shake-off / blow-off excess IPA
quickly, set print in a shaded airy place to
dry completely before curing.

Extended time in IPA causes deformation.
Dried print might be a little tacky to touch.

Post-curing

For optimal material performance, the
condition of FormCure is **60°C / 45 mins.**

Storage:

- Keep resin away from heat & light.
- NOT accessible to children.
- Filter used resins before storage.

Note:

- Keep print environment well ventilated.
- Avoid direct contact to skin or eyes. Rinse cautiously with water / soap and water for several minutes if contact to eyes / skin.
- Wear chemically-resistant gloves like nitrile or neoprene (not latex) when handling.
- DO NOT pour uncured resin down the drain. Abandoned resin can be cured by sunlight before discarding.

WARNING:

Contact with uncured resin may cause eye or skin irritation and allergic reaction.