

## FORM 2 & 3 PRINTER Modeling – Gray (MD-R001GY)

### 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 Grey 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.

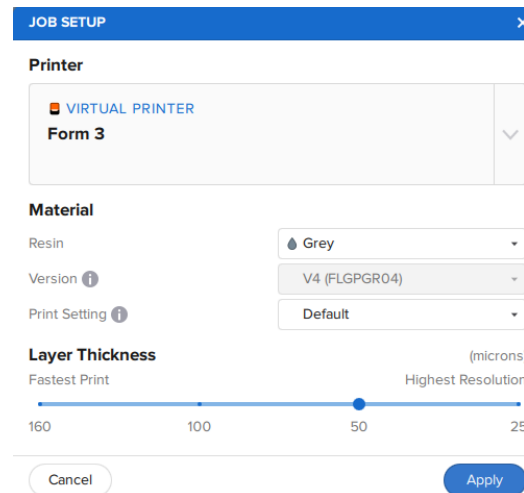
Alternative Solution: [North America](#) , [Other Regions](#)

### PreForm:

Select Printer: Form 2 or Form 3

Material: **Grey V4 (FLGPR04)**

Suggest Layer Thickness 100~25



### 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.