

DLP-Modeling – Gray V2 (DMD-R002GY)

Check:

- Resin tank and optical path are clean
- Shake resin bottle well before pouring
- Do Not overfill Resin tank's maximum resin line

RayWare: [MoonRay Pinter]

Open RayWare software(version 2.5.0 and later) and connect to the printer

Print Setup:

Select printer model

Material : **SprintRay Die and Model Gray**

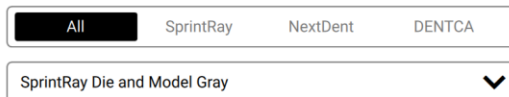
Layer Thickness : **50 or 100 µm**

Printer



Material

▲ Sign in to see all available materials.

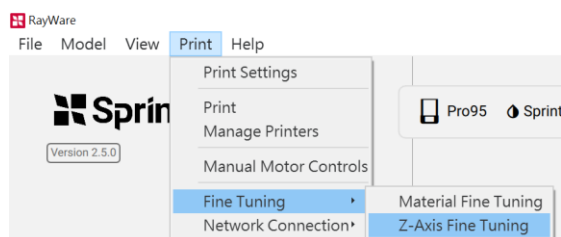


Layer Thickness



Layer thickness determines the height of each layer. Lower values can produce more cosmetic smoothness but increase print time.

Set z-axis position to higher value.



Ref. <https://support.sprinray.com/hc/en-us/articles/360043083273-Z-Axis-Fine-Tuning-Gap-Test>

Recommend for **Z-Offset value** :

+400 ~ +600 µm

(for Pro95, MoonRay D75 & S100)

- When printing arches directly on build-platform, vertically or horizontally supports are not needed.
- When supports are needed, set density/strength to medium/medium or high/high.

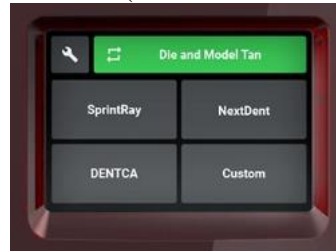
Washing:

Submerge print in clean IPA wash for **5-10 minutes** (e.g. FormWash or Ultrasonic bath), wipe off excess IPA with paper towel, set print in a shaded airy place to dry before curing.

*Dried print might be a little tacky to touch

Curing:

Pro Cure (firmware version 1.11 and later)



Select **SprintRay** and then **Die and Model**

* For optimal mechanical properties, please repeat the procedure again (total time: 30 °C 30 minutes) Single cure procedure (30 °C 15minutes) is enough for heat vacuume form model uses.

Storage:

Do NOT keep resin in the tank for more than **3 days**. Filter out all debris in the case of fail print jobs.

Note: Slight pigment settlement is normal. Gently mix remaining resin in resin tank with “resin wiper” for color evenness.