

## MSLA-Modeling – Dental (MMD-Roo1DN)

### Check

- Vat and LCD screen are clean
- Shake well before pouring, 60 sec
- Vat & platform are tighten properly
- Do Not overfill vat

### Setting recommendation Chart

#### MSLA Dental & MSLA Gray

#### Recommended Setting Parameters

Printer	Layer Thickness	Exposure		
		Normal Exposure Time (sec)	Bottom (Burn-In) Layers	Time (sec) for Bottom (Burn-In)
Photon	50 μm	10	8	45
Photon	100 μm	15	10	50
Photon S	50 μm	5	8	40
Photon S	100 μm	8	10	45
Shuffle	50 μm	10	8	40
Shuffle	100 μm	15	10	45
Shuffle XL	50 μm	8	8	40
Shuffle XL	100 μm	12	10	45
Sonic	50 μm	2.5	8	30
Sonic	100 μm	4	10	30
Sonic Mini	50 μm	4	6	30
Sonic Mini	100 μm	6	6	30

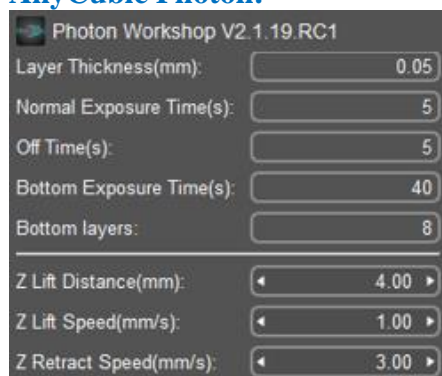
Each printer is unique, light intensity varies from printer to printer eventhough they are the same model and make. Please adjust normol exposure time from our recommended setting ±3 (±0.5 for sonic) second for your printer and print geometry.

For size calibration, download the stl file:

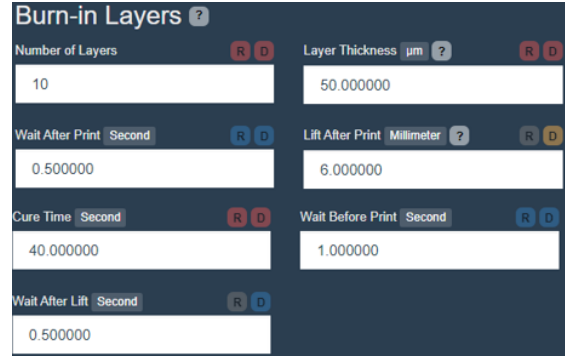
<https://www.thingiverse.com/thing:1586206>

Setting Example:

#### **AnyCubic Photon:**



#### For Prozen Shuffle:



### Washing

Submerge print in clean IPA for up to **5 minutes**, gently shake-off / blow-off excess IPA, set print in a shaded airy place to dry before curing. **(extended period in IPA causes deformation)**

Dried print might be a little tacky to touch

### Curing

Post-curing required for optimal material performance: Light wavelength: 405 nm Total light energy per unit area required on the print: **162,000 mJ/cm<sup>2</sup>**

Example:

Light power on the print = 40mW/cm<sup>2</sup>, (higher power per unit area shortens curing time) 162,000 mJ / 30 mW / 60 sec = 90 minutes of curing time.

Controlled curing chamber temperature between: 30~40°C / 86~104°F

### Storage

Don't keep resin in the vat for more than **2 days**. Filter out all debris in the case of fail print.

**Note:** Slight pigment settlement is normal. Gently mix remaining resin in resin vat with soft wiper for color evenness.