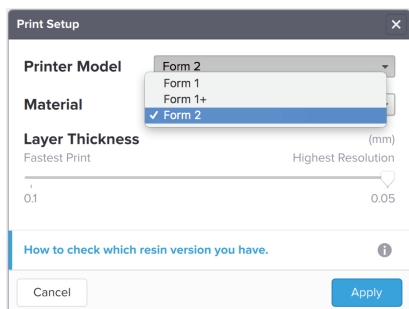


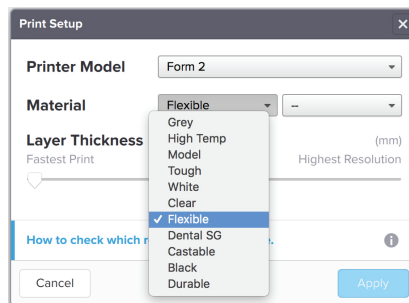
## Flex – Metallic Color

- 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

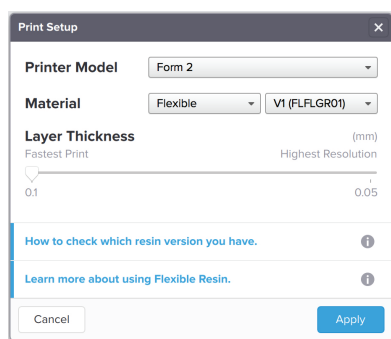
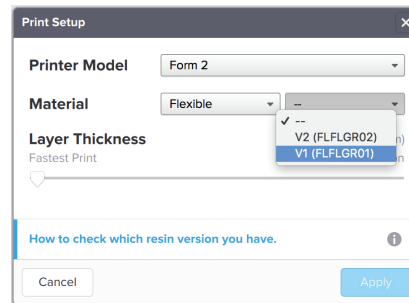
## FormLabs' PreForm:



Select desired Printer Model



Material Select: Flexible and V1 (FLFLGR01)



1. Select desired Layer Thickness
2. Click: Apply
3. Load 3D model

After print is loaded, double check support and orientation is optimal before print.

**\*\*If printed object exceeds 1/3 area of the build plate, it is suggested to refill the resin every 30ml volume printed\*\***

## 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, airy place to dry for 120 minutes before curing
- 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: 486,000mJ/cm<sup>2</sup>
- Place print in clear container and fully immerse in water to cut off oxygen contact for curing
- Example:**
- Light power on the print = 40mW/cm<sup>2</sup>, (higher power per unit area shortens curing time)
- 486,000mJ / 40mW / 60sec = 202.5 minutes of curing time
- Controlled curing chamber temperature between: 30~40° C / 86~104°F

## Storage

- Use spatula to softly scrape out residual resin in the VAT, store leftover resin in a separate container
- Cover VAT lid and store in cool temp (15~26°C/59~79°F), dry and keep away from light
- Filter out all debris in the case of fail print

**\*\*To clean VAT for other resin usage, rains out residual Flex resin in the VAT with clean IPA, do not scrape or brush PDMS (might cause resin to stain onto the PDMS)\*\***