APPLYLABWORK PRINTING INSTRUCTIONS

Form 2 & 3 series printers Laser Spring Pink (PT-SP001PK)

Check:

- Resin tank and optical path are clean
- Shake resin bottle well before use

Open-Mode (Form2):

Ensure the printer is idle

- 1. Tap **printer icon** on home screen
- 2. Select "Settings" menu
- 3. Select "Open Mode" function
- 4. swipe the bar on top right side to "On"
- * LT tank is required in Form2 printers

Cartridege (Form2 & Form 3 series):

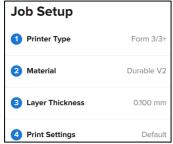
Refill the resin to durable-v2 cartridge. Open air vent, turn cartridge upside down, drip dry through air vent for at least 5 mins to minimize cross contamination, refill, shake well for 2 minutes, insert and print.

Alternative solution: <u>North America</u>, <u>Other Regions</u>

PreForm Setting:

Select Printer: Form2 or Form3 series

Select Material: durable v2 Layer Thickness: 100µm



* please avoid any large aspect-ratio geometry (e.g. thin wall or long rod) in the object to reducre failures.

Washing:

Wipe off excess resin on prints with paper towel, submerge into 95% IPA and place the container in ultrasonic bath, wash for 5 minutes. Replace by clean IPA and repeat ultrasonic washing for another 5 mintes

(total **10 minutes**). Blow off all excess IPA and set parts in a shaded airy place to dry at least 2 hours before curing.

*Dried print will be tacky to touch

Post-curing (Mandatory):

Submerge the parts into **glycerol/glycerin** (CAS # 56-81-5) and start **FormCure** with 60 °C / 30 mins setting. Wash off glycerol in water and dry off with paper towel.

*If prints don't sink completely into glycerol, add water (no more than half of volume) to adjust liquid density.

**If prints are still tacky to touch after post-curing, rinse with acetone (CAS # 67-64-1) for no more than 1 minute will significantly reduce tackiness.

Storage:

- Do NOT keep the resin in the tank more than one week. Pour out the resin and gently wipe the tank with paper towel and IPA.
- Keep resin away from heat and light.
- NOT accessible to children.

Note:

- Keep printing environment well **ventilated**.
- Wear gloves when handling Spring resin and avoid direct contact.
- Vibration of the parts during printing might cause resin splash onto printer 's cover. Use paper towel and IPA to clean immediately.
- Form2 printers usually give better printing quality than Form 3 series using Spring resin.
- Color of printed parts will gradually turn yellow if continuously receive photon energy.
- Spring resin is sensitive to resin tank quality. Please use a new tank to print if repetitive failure occur, even within Form 3 tank lifetime.
- Spring resin should NOT use with food, drink, or on/in the human body unless specifically indicated.