D75, S100, Pro95, & Pro55 DLP Modeling – Clear
(DMD-R001CR)

Check:
- UV optical pathways are clean
- Resin tank is free of defect
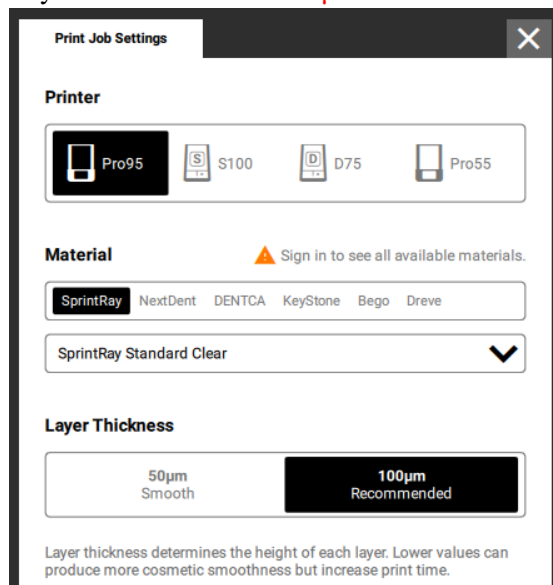- Resin is well shakened

RayWare: [MoonRay Pinter]

Open RayWare software(version 2.8.1 and later) and connect to the printer.

Print Setup:

Select printer model

Material：**SprintRay strandard clear**

Layer Thickness：**50/100 µm**

- When printing arches directly on buid-platform, vertically or horizontally supports are not needed.

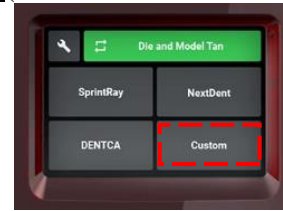- For detail calibration for resin can refer to Dimension and Tolerance.

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 comopletely before curing.

Extended time in IPA causes deformation.
Dried print might be a little tacky to touch.

Post-curing:

Pro Cure: (firmware version 1.51 and later)

Select Custom, and than select the condition as **30ºC for 10 min**.

Form Cure:

Select Custom Profile, and than select the condition as **60ºC for 15 min**.

Other:

Heat prints to 60ºC, depending on the size, adjust time accordingly (15~40 mins). Move warm print to UV-curing chamber for 40 seconds. Yellow tint may appear after UV curing but will subside in a few days

Storage:

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

Design Concept Series