

ETEC – E1 Printer Settings

Resin: Loctite 3D 3843 HDT60 HTO BK

PRINT SETTINGS

Build layer	100 µm
Irradiance	5 mW/cm ²
Printer Temperature	23 °C
Model Exposure	22 s

WASH CYCLE

	Cycle 1	Cycle 2	Cycle 3
Make/Model	EnvisionTec - PWA2000	EnvisionTec - PWA2000	N/A
Agitation Method	Orbital	Orbital	N/A
Cleaner	IPA	IPA	N/A
Cleaning time	150 s	150 s	N/A
Cleaner Temperature	20 °C	20 °C	N/A
Dry Time	N/A	N/A	N/A
Forced Air	120 psi	120 psi	N/A

WAIT BEFORE POST CURE

Wait time before Post Cure	10 min
Cleaning to Post Cure Temperature	22 °C

POST CURE

Make & Model	EnvisionTEC - PCA4000
Wavelength	385 nm & 405 nm LED
Settings	300 W
Irradiance	N/A
Temperature	20 °C
Atmosphere or Immersion Media	Ambient
Placement	N/A
Time	15 min
Flip and Repeat (Yes/No)	Yes

Notes: N/A