

Rapidshape i30+ Printer Settings

Resin: Loctite 3D 3843 HDT60 HTO BK

PRINT SETTINGS

| | |
|--|-----|
| Build layer (μm) | 50 |
| Irradiance (mW/cm^2) | 2 |
| Printer Temperature ($^{\circ}\text{C}$) | 28 |
| Model Exposure (s) | 7.5 |

PART CLEANING

| | |
|---|------------------------|
| Make & Model | Elma - Elmasonic S40 H |
| Agitation | Sonic |
| Wait time before Post Cure (min) | 70 |
| Cleaning to Post Cure Temp ($^{\circ}\text{C}$) | 22 |

Wash Cycle

| | |
|-----------------------------|--------------------------------|
| Cleaner | IPA |
| Cleaning time & temperature | 10 min at 22°C |
| Dry time (s) | 60 |
| Forced air (psi) | 60 |

POST CURE

| | |
|--|------------------------------------|
| Make & Model | Loctite - EQ CL36 LED Cure Chamber |
| Wavelength (nm) | 405 LED |
| Settings (Watt /Output %) | 100% |
| Irradiance (mW/cm^2) | 80mW/cm ² |
| Atmosphere or Immersion Media | Ambient |
| Placement | Lowest shelf |
| Time (min/side) | 20 |
| Flip and Repeat (Yes/No) | Yes |