

EnvisionTec - E1 HT Printer Settings

Resin: Loctite 3D 3955 HDT280 FST Black

PRINT SETTINGS

| | |
|----------------------------------|-----|
| Build layer (µm) | 100 |
| Irradiance (mW/cm ²) | 5 |
| Printer Temperature (°C) | 65 |
| Model Exposure (s) | 10 |

PART CLEANING

| | |
|----------------------------------|------|
| Wait time before Post Cure (min) | None |
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WASH CYCLE

| Wash Cycle 1 | | Wash Cycle 2 | |
|-----------------------------|---------------------------------|-----------------------------|---------------|
| Make & Model | Ultrasonic - Proclean 3.0DSP | Make & Model | Manual |
| Agitation | Sonic | Agitation | None |
| Cleaner | Cleaner T | Cleaner | Acetone |
| Cleaning time & temperature | 0.5 min at 60°C | Cleaning time & temperature | Rinse at 25°C |
| Dry Time (s) | 20 | Dry Time (s) | N/A |
| Forced Air (psi) | 30 | Forced Air (psi) | N/A |

OVEN CURE

| | |
|------------------------|-------------------|
| Make & Model | Binder ED115 |
| Start Temperature (°C) | 25 |
| Ramp 1 (°C / min) | 3 |
| Temperature (°C) | 190 |
| Temperature 1 Hold (h) | 6 |
| Ramp 2 (°C / min) | 3 |
| Temperature (°C) | 210 |
| Temperature 2 Hold (h) | 1 |
| Cooling Conditions | Cool down in oven |