

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	Manual	Make & Model	Manual
Agitation	Hand	Agitation	None
Cleaner	TPM	Cleaner	Acetone
Cleaning time & temperature	0.5 min at 80°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