

EnvisionTec - E1 Printer Settings

Resin: Loctite 3D IND147 HDT230 BK

PRINT SETTINGS

Build layer (µm)	100
Irradiance (mW/cm2)	5
Printer Temperature (°C)	25
Model Exposure (s)	13

PART CLEANING

Make & Model	Elma - Elmasonic S40 H
Agitation	Sonic
Wait time before Post Cure (min)	60
Clean to Post Cure temperature	37°C

WASH CYCLE

Wash Cycle 1		Wash Cycle 2	
Cleaner	Cleaner C	Cleaner	IPA
Cleaning time & temperature	2 min at 25°C	Cleaning time & temperature	1 min at 25°C
Dry Time (s)	60	Dry Time (s)	15-30
Forced Air (psi)	60	Forced Air (psi)	60

POST CURE

Make & Model	EnvisionTEC - PCA4000
Wavelength (nm)	385 & 405 LED
Settings (Watt /Output %)	1
Temperature (°C)	RT
Atmosphere or Immersion Media	Ambient
Time (min/side)	30
Flip and Repeat (Yes/No)	yes

THERMAL CURE

Start Temperature (°C)	170
Temperature (°C)	170
Temperature 1 Hold (h)	3
Cooling Conditions	Cool down in oven