

EnvisionTec - E1 Printer Settings

Resin: Loctite 3D IND405 HDT50 HE CL

PRINT SETTINGS

Build layer (µm)	100
Irradiance (mW/cm ²)	5
Printer Temperature (°C)	23
Model Exposure (s)	16

PART CLEANING

Make & Model	Envisiontec - PWA2000
Agitation	Orbital
Wait time before Post Cure (min)	10
Cleaning to Post Cure Temperature (°C)	RT

WASH CYCLE

Wash Cycle 1		Wash Cycle 2	
Cleaner	IPA	Cleaner	IPA
Cleaning time & temperature	2.5 min at 20°C	Cleaning time & temperature	2.5 min at 20°C
Dry Time (s)	N/A	Dry Time (s)	N/A
Forced Air (psi)	120	Forced Air (psi)	120

POST CURE

Make & Model	EnvisionTEC - PCA4000
Wavelength (nm)	386 & 405 LED
Settings (Watt /Output %)	300W
Temperature (°C)	20°C
Atmosphere or Immersion Media	Ambient
Time (min/side)	20
Flip and Repeat (Yes/No)	Yes