

DLP-Modeling – Clear (DMD-R001CR)

Check:

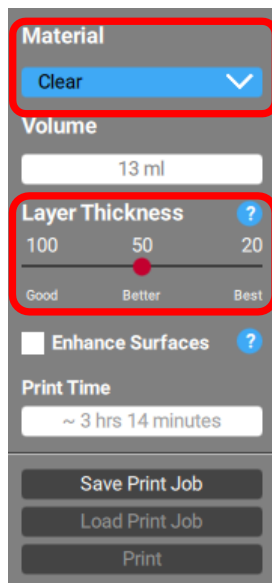
- Resin tank drum and optical path are clean
- Shake resin bottle well before pouring
- Do Not overfill resin tank's maximum resin line

RayWare: [MoonRay Pinter]

Open RayWare software and connect printer

Print Setup:

Load 3D model and double check support and orientation are optimal before print.



Material Select: **Clear**
Layer Thickness Select: **100, 50 or 20**
Click: Print

Washing

Submerge print in clean IPA for up to **5 minutes**, gently shake-off / blow-off excess IPA, set print in a shaded airy place to dry before curing. (**extended period in IPA causes deformation**)

Dried print might be a little tacky to touch

Curing

Post-curing for optimal performance:

1. Heat prints to 60°C, depending on the size, adjust time accordingly (15~40 mins). Move warm print to UV-curing chamber for 40 seconds. Yellow tint may appear after UV curing but will subside in a few days.

or

2. FormCure 60°C, 15min.

Storage

Do Not keep resin in the tank for more than **3 days**. Filter out all debris in the case of failed print

Note: Avoid high power UV light for post curing to minimize prints from yellowing