

D75, S100, Pro 55 & Pro95 DLP Modeling – White V2 (DMD-R002WT)

Check:

- UV optical pathways are clean
- Vat is free of defect
- Resin is well shaken

RayWare: [Sprintray Pinter]

Open RayWare software(version 2.8.1 and later) and connect to the printer.

Print Setup:

Select printer model: **Pro 95 & Pro 55**

Material : **SprintRay Study Model White 2**

Layer Thickness : **50/100/170 μm**

Printer

Pro95 S100 D75 Pro55

Material Sign in to see all available materials.

SprintRay NextDent DENTCA KeyStone Bego Dreve

SprintRay Study Model White 2

Last updated on 29/07/2021 at 5:13 下午

Layer Thickness

50μm Smooth **100μm Recommended** 170μm Ludicrous

Layer thickness determines the height of each layer. Lower values can produce more cosmetic smoothness but increase print time.

Select printer model: **D75 & S100**

Material : **SprintRay Denture Base**

Layer Thickness : **50/100 μm**

Printer

Pro95 S100 D75 Pro55

Material Sign in to see all available materials.

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SprintRay Denture Base

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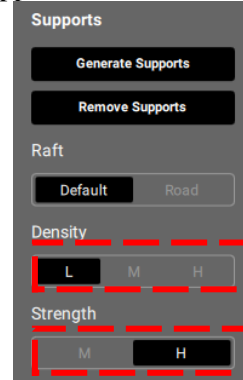
Layer Thickness

50μm Smooth **100μm Recommended**

Layer thickness determines the height of each layer. Lower values can produce more cosmetic smoothness but increase print time.

- When printing arches directly on build-platform, vertically or horizontally supports are not needed.

- When supports are needed, set strength to H



For detail calibration for resin can refer to [Dimension](#) and [Tolerance](#).

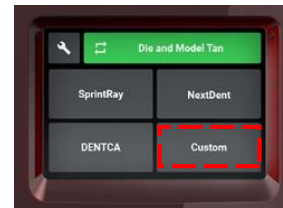
Washing:

IPA 95%, maximum for up to 5 minutes, gently shake-off / blow-off excess IPA quickly, set print in a shaded airy place to dry completely before curing.

Extended time in IPA causes deformation. Dried print might be a little tacky to touch.

Post-curing:

Pro Cure (firmware version 1.51 and later)



Select **Custom**, and then select the condition as **30°C for 30 min**. Modeling-White gains yellowish hue after ProCure but will Naturally diminishes after 5~6 days.

Quickly reducing yellow hue:

1. Place prints into a heat-resistant container.
2. Pour boiled water into the container, submerge the prints in hot water for 5~6 minutes.

Storage:

DO NOT keep resin in the tank for more than **2 days**. Filter out all debris in the case of fail print jobs

Note: Slight pigment settlement is normal. Gently mix remaining resin in resin tank with “resin wiper” for color evenness.