FORM 2 & 3 PRINTER
Laser Spring Black
(PT-SP001BK)

Check:
- Resin tank and optical path are clean
- Shake resin bottle well before using

Open-Mode (Form 2):

Ensure the printer is idle
1. Tap **printer icon** on home screen
2. Select "**Settings**" menu
3. Select "**Open Mode**" function
4. swipe the bar on top right side to "**On**"
* LT tank is required for Form2 printers

Cartridege (Form 2 & 3):

Refill resin to corresponding cartridge (Durable-V2). Open air vent, turn cartridge upside down, drip dry through air vent for at least 5 mins to minimize cross contamination, refill, shake well for 2 minutes, insert and print.

Alternative Solution: North America , Other Regions

PreForm Setting:

Printer: Form 2 or Form 3

Material: **Durable V2**

Layer Thickness: 100µm

* Please avoid any large aspect-ratio geometry (e.g. thin wall or long rod) in the object to reduce failures.

Washing:
Wipe off excess resin on prints with paper towel, submerge into 95% IPA and place the container in ultrasonic bath, wash for 5 minutes. Replace by clean IPA and repeat ultrasonic wash for another 5 mintues (total **10 minutes**). Blow off excess IPA and set prints in shaded airy place to dry for at least 2 hours before curing.

*Dried prints will be tacky to touch.

Post-Curing (Mandatory):
For optimal material performance:
Place prints in a clear plastic container and submerge prints in **glycerol/glycerin** (CAS # 56-81-5). Set **FormCure** at 60 °C / 30 mins. Wash off glycerol in water and dry off with paper towel.

*If prints don't sink completely into glycerol, add water (no more than half of volume) to adjust liquid density.

If prints are still tacky to touch after post-curing, rinse with **acetone (CAS # 67-64-1) for no more than 1 minute will significantly reduce tackiness.

Storage:
- Keep resin away from heat and light.
- NOT accessible to children.

Note:
- Keep printing environment **well ventilated.**
- Wear gloves when handling Spring resin and avoid direct contact.
- Vibration of the parts during printing might cause resin splash onto printer cover. Use paper towel and IPA to clean immediately.
- Form 2 printers usually give better printing quality than Form 3 using Spring resin.
- Spring resin is sensitive to resin tank quality. Please use a new tank to

print if repetitive failures occur, even within Form 3 tank lifetime.

- Spring resin should NOT be used with food, drink, or on/in the human body unless specifically indicated.