

PRUSA SL1S Speed Printer Settings

Resin: LOCTITE 3D PRO476 HDT60 (Black)

PRINT SETTINGS

Build layer	100 µm
Irradiance	2.2 mW/cm ²
Printer Temperature	22 °C
Model Exposure	9 s

Wash Cycle

	Cycle 1	Cycle 2	Cycle 3
Make/Model	Prusa - CW1S	Prusa - CW1S	N/A
Agitation Method	Rotor (speed)	Rotor (speed)	Sonic
Cleaner	Cleaner C	Cleaner C	IPA
Cleaning time	2 min	2 min	60 s
Cleaner Temperature	30 °C	30 °C	22 °C
Dry Time	60 s	60 s	60 s
Forced Air	50 psi	50 psi	50 psi

Wait Before Post Curing

Wait time before Post Cure	60 min
Cleaning to Post Cure Temperature	22 °C

POST CURE

Make & Model	Prusa - CW1S
Wavelength	405 nm LED
Settings	N/A
Irradiance	N/A
Temperature	N/A
Atmosphere or Immersion Media	Ambient
Placement	Rotary Table
Time	15 min
Flip and Repeat (Yes/No)	Yes

Notes:

Workflow also available in 50µm, email loctite3dp@henkel.com for details.

