

# ORIGINAL INSTRUCTIONS



## CUREBOX USER GUIDE

Version 061020

**Post-Curing, Taken Seriously.**

This user guide will teach you how to safely use your new CUREbox UV post-cure chamber and help you get the most from it. Please use CUREbox safely and enjoy.

Applies to models: CB-4051, CB-4115, CB-4230, CB-5115, and CB-5230

Wicked Engineering, LLC  
support@wickedengineering.com

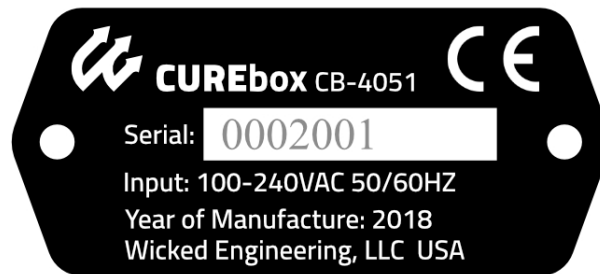
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## Machine Description

CUREbox is an ultra-violet (UV) and visible light (VIS) post-curing chamber. It uses light and heat energy to provide an ideal environment suitable for post-curing SLA and DLP type 3D printed models.

## Machine Designation



CUREbox CB-4051 Shown

## Unpacking

**Note: Open the packaging carefully and retain it for safe transport. Original packaging is a requirement should your CUREbox need warranty repair or replacement.**

CUREbox ships in two boxes (a box in a box) to ensure it arrives to you undamaged. It is easiest to unpack if you have a second person to help.

1. Open the outer box top flaps
2. Remove and retain the foam corner protectors
3. Remove the power cord
4. Remove the inner box
5. Open the inner box top flaps

There is an orange “Important” insert immediately inside the inner box. This insert contains important safety information and should be read thoroughly prior to use of your CUREbox.

6. Remove, read, and retain the orange “Important” insert
7. Remove CUREbox from the inner box
8. Remove CUREbox from the protective poly bag. Take care that the door doesn’t fall open.
9. Place your CUREbox on a solid worksurface
10. Return packaging materials to the outer box and save for safe transport should it be necessary

## Safety

Please read these few important notices before using your new CUREbox.

1. Do not put flammable liquids in the curing chamber. Allow any solvents to completely evaporate from your prints before placing in the curing chamber. Flammable fluids in the curing chamber create a risk of fire and/or explosion.
2. Do not look at the lamps without appropriate eye protection. CUREbox uses high intensity visible (405nm) and ultraviolet (365nm) lamps. CUREbox is equipped with a safety interlock that turns off the lamps when the door is opened. This is for your safety.
3. Do not place items on or around CUREbox. CUREbox gets hot, up to 80C (140F) for CUREbox Plus. Keep flammable liquids away. Do not put liquids on top of CUREbox as a spill could create a risk of electric shock.
4. CUREbox is intended for post-curing 3D printed models. Do not use CUREbox for any other purpose as we cannot ensure safety of the device for unintended uses.
5. Should your CUREbox malfunction in any way, immediately unplug it and contact support at: support@wickedengineering.com. We will help you diagnose the issue in a safe manner. Do not continue to operate a malfunctioning unit as damage or even injury may occur.

If you have any questions about the setup, use, or care of your CUREbox, please contact support at: support@wickedengineering.com

## Set-up

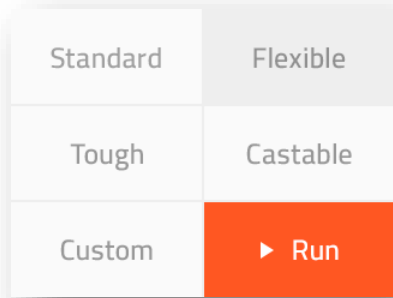
1. Place CUREbox on a secure platform.
2. Make sure the power switch is in the off (O) position
3. Insert the supplied power cord into the power entry module at the back of the unit
4. Plug the power cord into a power outlet

## Operation

1. Switch on (I) CUREbox with the power switch on the back panel
2. The power switch will illuminate red
3. The LCD will display a splash screen for several seconds and then will change to the main screen
4. Open the front door and place the part(s) to be cured into the chamber

## Operation Modes

CUREbox has two operation modes, preset and custom. Preset mode uses resin manufacturer recommended settings. Custom mode allows you to create your own settings.



### Preset Mode

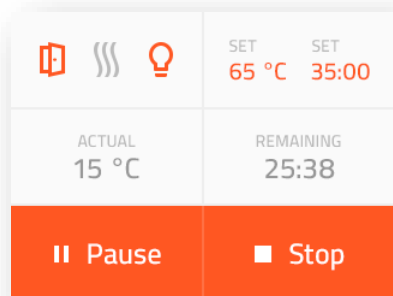
1. Chose a resin from the menu and press Run.
2. CUREbox will wait for the set temperature to be reached and then post-curing will begin
3. When post-curing is complete LEDs and heat will turn off automatically

### Custom Mode

1. Choose Custom from the main menu
2. On the custom setting screen use the up and down arrows to set the time and temperature to the desired settings
3. Press and hold the arrows to move quickly through range of a setting.
4. To use CUREbox without the heat feature use the down arrow until the setting reads "--"
5. When the settings are complete press Run
6. When post-curing is complete LEDs and heat will turn off automatically

### Run Screen

The run screen is full of information about the settings and status of your CUREbox.



1. The status area (top left) shows the status of the door, lamps, and heater.
2. The set area (top right) shows the chosen program time and temperature settings.
3. The actual area (middle) shows the process time remaining and chamber temperature.
4. The pause button (bottom left) pauses the process until the resume button is pressed.
5. The stop button (bottom right) stops the process and returns you to the main screen.

## Care and Maintenance

CUREbox is virtually maintenance free, but it is advisable to keep the work surface clean to allow efficient light passage to the workpiece. If you treat your CUREbox with care, it will last a long time.

The preferred method of cleaning interior and exterior surface is mild detergent and water. Before cleaning, unplug the unit from the electrical outlet. Use a soft cloth dampened (not dripping) with soapy water. Do not soak the CUREbox in water or other liquid. Wipe surfaces until clean and then rinse with a clean cloth dampened with clean water. For resin residue, it is ok to use isopropyl alcohol. If isopropyl alcohol is used, allow it to evaporate with the door open prior to connecting your CUREbox to power. It is also acceptable to use general purpose household cleaners such as 409 and Fantastik, or Windex for mirrored surfaces. Take care when cleaning the Lexan work surface not to allow excess cleaning product to run over the edges where it would be impossible to rinse clean. When all surfaces are dry it is safe to reconnect the CUREbox to the electrical outlet.

**Note: Do not use harsh solvents like acetone, MEK, Toluene, etc. They will damage the unit. When in doubt, contact [support@wickedengineering.com](mailto:support@wickedengineering.com)**

## Spare Parts

CUREbox is not user-serviceable, except for the LED lamps. Replacement LED lamps are available for purchase from your distributor or directly from our web store. Should something break please refer to the warranty section of this guide. If your unit is out of warranty, we will not leave you stranded. Contact your distributor or [support@wickedengineering.com](mailto:support@wickedengineering.com) for help. Your unit can likely be repaired by us, and in some cases, we can ship replacement parts to you if you choose to repair your CUREbox yourself.

## Storage and Transportation

Should it be necessary to transport or store your CUREbox, the following will ensure the safety of the device:

1. Turn off power switch.
2. Unplug unit from power.
3. Wipe down inside and outside of unit with mild detergent and water or isopropyl alcohol to remove excess uncured resin and other debris.
4. Ensure the chamber is empty.
5. Place unit in poly bag (optional)
6. Reinstall the protective foam endcaps that originally shipped with the machine onto the left and right ends of the unit.
7. Slide the bagged unit with endcaps into the original shipping container. Be sure the unit is in upright position.
8. Place the power cord in the open space created by the protective foam endcaps.
9. Close the top of the box by using reinforced paper tape (preferred) or clear adhesive shipping tape (if you do not have access to reinforced paper tape). Tape all box seams.
10. It is not necessary to remove the LED lamps for storage or transportation.
11. CUREbox should be stored and transported in the upright position.

## Warranty

CUREbox has a limited one-year warranty (or greater where required by law) which covers everything but the LED lamps which are considered consumable items. Details on the warranty can be found on the downloads section of the CUREbox website: <https://wickedengineering.com/pages/curebox-downloads>

## Compliance

CUREbox is CE compliant.

**EC DECLARATION OF CONFORMITY**

This declaration is issued under the sole responsibility of the manufacturer

**MANUFACTURER**

Company name: Wicked Engineering, LLC  
Full address: 54 Eastland Road  
Postal code: 01106  
Place: Longmeadow, Massachusetts  
Country: United States of America

**DESCRIPTION AND IDENTIFICATION OF THE MACHINERY**

Generic name: CUREbox  
Function: UV Post-Curing Chamber  
Model: CB-4051, CB-4115, CB-4230, CB-5115, CB-5230  
Serial number: 4051xxxx, 4115xxxx, 4230xxxx, 5115xxxx, 5230xxxx

**COMPLIANCE**

*The manufacturer declares that the above mentioned machinery fulfills all relevant provisions of*

Machinery Directive 2006/42/EC  
Low Voltage Directive 2014/35/EC  
EMC Directive 2014/30/EU

*In conjunction with the following harmonised standards and where appropriate other technical standards and specifications*

EN 14120:2015; EN 614-1:2006+A1:2009; EN 894-1:1997+A1:2008; EN 14118:2018; EN 349:1994+A1:2008; EN 12198-2:2003+A1:2008; EN-IEC 61310-1:2008; EN-IEC 60204-1:2006; EN 12100:2010; IEC 60335:2010; IEC 55014-2:2015

Place: Longmeadow, Massachusetts      Name: Paul McGarr  
Function: President

Date: 24<sup>th</sup> of July 2018      Signature: