

Asiga 3D Printing Workflow

Printing and post-processing workflow instructions

Max UV 385

- **DM 2505**
- **RG 35 B**
- **RG 1100 B**
- **RG 3280**
- **ST 45 B**
- **ST 7500 G**

Pro 4K

- **RG 1100 B**
- **RG 3280**
- **ST 45 B**
- **ST 7500 G**

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® DM 2505

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	9	5

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Distilled water	Distilled water
Cleaning Time (min)	4	4



WAIT BEFORE POST CURING

Waiting Time (min) 30 Temperature (°C) 40

POST CURING

Model	Otoflash G171
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	3000
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® DM 2505

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	9	5

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Distilled water	Distilled water
Cleaning Time (min)	4	4



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Dymax ECE 2000
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	5
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® DM 2505

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	9	5

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	IPA	IPA
Cleaning Time (min)	5	5



WAIT BEFORE POST CURING

Waiting Time (min) 30 Temperature (°C) 40

POST CURING

Model	Otoflash G171
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	3000
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® DM 2505

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	9	5

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	IPA	IPA
Cleaning Time (min)	5	5



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Dymax ECE 2000
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	5
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® DM 2505

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	9	5

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	IPA	IPA
Cleaning Time (min)	5	5



WAIT BEFORE POST CURING

Waiting Time (min) 30 Temperature (°C) 40

POST CURING

Model	Formcure
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	120
Flip & Repeat	No

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® DM 2505

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	9	5

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Distilled water	Distilled water
Cleaning Time (min)	4	4



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Formcure
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	120
Flip & Repeat	No

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® RG 35 B

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
50	9,7	1,94

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	3	3



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Otoflash G171
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	3000
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® RG 35 B

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
50	9,7	1,94

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	3	3



WAIT BEFORE POST CURING

Waiting Time (min) 30 Temperature (°C) 40

POST CURING

Model	Formcure
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	120
Flip & Repeat	No

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® RG 35 B

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
50	9,7	1,94

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	3	3



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Dymax ECE 2000
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	5
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® RG 1100 B

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
50	9,4	1,6

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	2	2



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Otoflash G171
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	3000
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® RG 1100 B

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
50	9,4	1,6

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	2	2



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Formcure
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	120
Flip & Repeat	No

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® RG 1100 B

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
50	9,4	1,6

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	2	2



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Dymax ECE 2000
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	5
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® RG 3280

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	4,6	1,7

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Rotor / Propeller	Rotor / Propeller
Cleaner	IPA	IPA
Cleaning Time (min)	1	1



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Otoflash G171
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	3000
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	1
Holding Temp. (°C)	150
Holding Time (h)	3
Ramp down (°C / min)	1

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® RG 3280

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	4,6	1,7

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Rotor / Propeller	Rotor / Propeller
Cleaner	IPA	IPA
Cleaning Time (min)	1	1



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Formcure
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	120
Flip & Repeat	No

THERMAL TREATMENT

Ramp up (°C / min)	1
Holding Temp. (°C)	150
Holding Time (h)	3
Ramp down (°C / min)	1

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® RG 3280

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	4,6	1,7

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Rotor / Propeller	Rotor / Propeller
Cleaner	IPA	IPA
Cleaning Time (min)	1	1



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Dymax ECE 2000
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	5
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	1
Holding Temp. (°C)	150
Holding Time (h)	3
Ramp down (°C / min)	1

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® ST 45 B

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
50	10	1,50

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	3	3



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Otoflash G171
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	3000
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® ST 45 B

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
50	10	1,50

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	3	3



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Dymax ECE 2000
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	5
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® ST 7500 G

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	7	4,834

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	3	3



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Otoflash G171
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	2000
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Max UV 385

3D Printing Workflow: Ultracur3D® ST 7500 G

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	7	4,834

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	3	3



WAIT BEFORE POST CURING

Waiting Time (min) 30 Temperature (°C) 40

POST CURING

Model	Dymax ECE 2000
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	4
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Pro 4K

3D Printing Workflow: Ultracur3D® RG 1100 B

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	12	1,733

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	2	2



WAIT BEFORE POST CURING

Waiting Time (min) 30 Temperature (°C) 40

POST CURING

Model	Dymax ECE 5000
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	3
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Pro 4K

3D Printing Workflow: Ultracur3D® RG 1100 B

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	12	1,733

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	2	2



WAIT BEFORE POST CURING

Waiting Time (min) 30 Temperature (°C) 40

POST CURING

Model	Otoflash G171
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	3000
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Pro 4K

3D Printing Workflow: Ultracur3D® RG 3280

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
50	4,6	0,999

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Rotor / Propeller	Rotor / Propeller
Cleaner	IPA	IPA
Cleaning Time (min)	1	1



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Dymax ECE 5000
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	5
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	1
Holding Temp. (°C)	150
Holding Time (h)	3
Ramp down (°C / min)	1

Asiga - Pro 4K

3D Printing Workflow: Ultracur3D® RG 3280

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
50	4,6	0,999

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Rotor / Propeller	Rotor / Propeller
Cleaner	IPA	IPA
Cleaning Time (min)	1	1



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Otoflash G171
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	3000
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	1
Holding Temp. (°C)	150
Holding Time (h)	3
Ramp down (°C / min)	1

Asiga - Pro 4K

3D Printing Workflow: Ultracur3D® ST 45 B

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
50	10	1,50

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	3	3



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Dymax ECE 5000
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	3
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Pro 4K

3D Printing Workflow: Ultracur3D® ST 45 B

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
50	10	1,50

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	3	3



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Otoflash G171
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	3000
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Pro 4K

3D Printing Workflow: Ultracur3D® ST 7500 G

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	7	4,834

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	3	3



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	Dymax ECE 5000
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	3
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.

Asiga - Pro 4K

3D Printing Workflow: Ultracur3D® ST 7500 G

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	7	4,834

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Ultracur3D Cleaner	IPA
Cleaning Time (min)	3	3



WAIT BEFORE POST CURING

Waiting Time (min) 30 Temperature (°C) 40

POST CURING

Model	Otoflash G171
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	3000
Flip & Repeat	Yes

THERMAL TREATMENT

Ramp up (°C / min)	N.A.
Holding Temp. (°C)	N.A.
Holding Time (h)	N.A.
Ramp down (°C / min)	N.A.