



# Atum3D - DLP Station 405

## 3D Printing Workflow: Ultracur3D® ST 45 B

Technology: DLP

### PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	Set by Machine Maker	1,8

### 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	Atum Post cure unit
Settings	N.A.
Atmosphere	Vaccum
Time (min) or Flashes	30
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.