



Crealty - Halot Sky

3D Printing Workflow: Ultracur3D® DM 2505

Technology: LCD

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	2	7

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

THERMAL TREATMENT

Model	Otoflash G171	Ramp up (°C / min)	N.A.
Settings	N.A.	Holding Temp. (°C)	N.A.
Atmosphere	Nitrogen	Holding Time (h)	N.A.
Time (min) or Flashes	2000	Ramp down (°C / min)	N.A.
Flip & Repeat	Yes		

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