

# ETEC - Einstein Pro XL

## 3D Printing Workflow: Ultracur3D® RG 3280

Technology: DLP

### PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm <sup>2</sup> )	Exposure Time (s)
100	5	1,25

	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) None

Temperature (°C) None

### POST CURING

Model	PCA 4000
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	15
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.

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Cleaner	IPA	IPA
Cleaning Time (min)	1	1



### WAIT BEFORE POST CURING

Waiting Time (min) None      Temperature (°C) None

### POST CURING

Model	PCA 4000
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	15
Flip & Repeat	Yes

### THERMAL TREATMENT

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