

# forwardam

## Miicraft - 125 405 nm

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

Technology: DLP

#### PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	4,5	4,5

#### 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	10
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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### 3D Printing Workflow: Ultracur3D® ST 45 B

Technology: DLP

#### PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
50	5,5	2,25

#### WASH CYCLE 1

#### WASH CYCLE 2

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



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

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