

# forwardam

## Miicraft - 125 405 nm

### 3D Printing Workflow: Ultracur3D® ST 7500 G

Technology: DLP

#### PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	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	Otoflash G171
Settings	N.A.
Atmosphere	Nitrogen
Time (min) or Flashes	6000
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.