

Nexa3D - NXE 200

3D Printing Workflow: Ultracur3D® DM 2505

Technology: LCD

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm ²)	Exposure Time (s)
100	5	3

	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	X Cure
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	8
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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50	Set by Machine maker	Set by Machine maker

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



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