

# Nexa3D - XiP

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

Technology: LCD

### PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm <sup>2</sup> )	Exposure Time (s)
200	5	6,1

	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	Wash + Cure
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	30
Flip & Repeat	No

### THERMAL TREATMENT

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