



# Phrozen - Mega 8K S

## 3D Printing Workflow: Ultracur3D® RG 1100 B

Technology: LCD

### PRINT SETTINGS

| Layer Thickness (µm) | Irradiance (mW/cm2)  | Exposure Time (s) |
|----------------------|----------------------|-------------------|
| 100                  | Set by Machine maker | 17                |

### 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                 | Mega Cure S |
|-----------------------|-------------|
| Settings              | N.A.        |
| Atmosphere            | Ambient     |
| Time (min) or Flashes | 60          |
| 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. |