

forwardam.

Rapidshape - i50+

3D Printing Workflow: Ultracur3D® ST 45 B

Technology: DLP

PRINT SETTINGS

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



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature (°C) 40

POST CURING

Model	RS Cure XL
Settings	90% power
Atmosphere	Vaccum
Time (min) or Flashes	20
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.

Workflow N.: 2024-LFS-WF-0112