



Rapidshape - i50+

3D Printing Workflow: Ultracur3D® ST 7500 G

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	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	10
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.