

Rapidshape - i30+

3D Printing Workflow: Ultracur3D® DM 4505 N

Technology: DLP

PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm2)	Exposure Time (s)
100	2	3.5

WASH CYCLE 1

WASH CYCLE 2

Agitation Method	Ultrasonic	Ultrasonic
Cleaner	Distilled water	Distilled water
Cleaning Time (min)	3	3



WAIT BEFORE POST CURING

Waiting Time (min) 30 Temperature (°C) 40

POST CURING

Model	Otoflash G171
Settings	N.A.
Atmosphere	Nitrogen
Time (min) or Flashes	3000
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.