

# Rapidshape - i30+

## 3D Printing Workflow: Ultracur3D® DM 4505 N

Technology: DLP

### PRINT SETTINGS

| Layer Thickness (µm) | Irradiance (mW/cm <sup>2</sup> ) | Exposure Time (s) |
|----------------------|----------------------------------|-------------------|
| 100                  | 2                                | 3.5               |

|                     | 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                 | 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. |