

Rapidshape - i50

3D Printing Workflow: Ultracur3D® RG 3280

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	Rotor / Propeller	Rotor / Propeller
Cleaner	IPA	IPA
Cleaning Time (min)	1	1



WAIT BEFORE POST CURING

Waiting Time (min) None

Temperature (°C) None

POST CURING

Model	RS Cure XL
Settings	90% power
Atmosphere	Vaccum
Time (min) or Flashes	3
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.

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Agitation Method	Rotor / Propeller	Rotor / Propeller
Cleaner	IPA	IPA
Cleaning Time (min)	1	1



WAIT BEFORE POST CURING

Waiting Time (min) None

Temperature (°C) None

POST CURING

Model	RS Cure XL
Settings	90% power
Atmosphere	Vaccum
Time (min) or Flashes	3
Flip & Repeat	No

THERMAL TREATMENT

Ramp up (°C / min)	1
Holding Temp. (°C)	150
Holding Time (h)	3
Ramp down (°C / min)	1