

Stratasys - Origin One

3D Printing Workflow: Ultracur3D® RG 35 B

Technology: DLP

PRINT SETTINGS

| Layer Thickness (µm) | Irradiance (mW/cm ²) | Exposure Time (s) |
|----------------------|----------------------------------|-------------------|
| 100 | 5 | 3 |

| | 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 | Dymax ECE 2000 |
|-----------------------|----------------|
| Settings | N.A. |
| Atmosphere | Ambient |
| Time (min) or Flashes | 15 |
| 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. |