

# Stratasys - Origin One

## 3D Printing Workflow: Ultracur3D® EL 4000 B

Technology: DLP

### PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm <sup>2</sup> )	Exposure Time (s)
100	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	Onulis WRAP Cure
Settings	N.A.
Atmosphere	Ambient
Time (min) or Flashes	15
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.