

# Stratasys - Origin One

## 3D Printing Workflow: Ultracur3D® RG 3280

Technology: DLP

### PRINT SETTINGS

Layer Thickness (µm)	Irradiance (mW/cm <sup>2</sup> )	Exposure Time (s)
50	3,5	1

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic	Ultrasonic
Cleaner	PLM 403 SUB	PLM 403 SUB
Cleaning Time (min)	1	1



### WAIT BEFORE POST CURING

Waiting Time (min) None

Temperature (°C) None

### 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.

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Settings	N.A.
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Flip & Repeat	Yes

### THERMAL TREATMENT

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

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Agitation Method	Rotor / Propeller	Rotor / Propeller
Cleaner	PLM 403 SUB	PLM 403 SUB
Cleaning Time (min)	1	1



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Temperature (°C) None

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