

UnionTech - Cute 300

3D Printing Workflow: Ultracur3D® RG 3280

Technology: DLP

PRINT SETTINGS

| Layer Thickness (µm) | Irradiance (mW/cm ²) | Exposure Time (s) |
|----------------------|----------------------------------|-------------------|
| 100 | 4,22 | 1,6 |

| | 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 | Cure Station |
|-----------------------|--------------|
| Settings | N.A. |
| Atmosphere | Ambient |
| Time (min) or Flashes | 22 |
| 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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|----------------------|----------------------------------|-------------------|
| 100 | 4,22 | 1,6 |

| | 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 | Cure Station |
|-----------------------|--------------|
| Settings | N.A. |
| Atmosphere | Ambient |
| Time (min) or Flashes | 22 |
| 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. |