



HARDWARE/SOFTWARE

Printer & Cassette	M1	M2	M3, M3 Max
	C2	C2, C5	D1

WASHING

Solvent	99% Isopropanol (IPA)
Exposure	5 MIN max.
Part Washer	No

Notes
- Post treatments recommended immediately following a completed print. - Washing should occur no later than 8 HRS after print completion.

Washing Process
<u>Manual washing</u> - Remove parts from platform. - Place parts in dedicated container of fresh IPA. Solvent should cover ¾ of tallest parts. 3 MIN orbital shaker at 140 RPM and remove parts from washtub. - Place parts in second dedicated container of fresh IPA and wash additional 2 MIN on orbital shaker at 140 RPM. - Transfer to paper towel lined tray. - Wipe entire intaglio surface of each part with IPA-dipped swab. - Air dry for 30 MIN or use compressed air. - If glossy areas remain, repeat swabbing and drying.

STORAGE

Temperature	20 - 25° C (68 - 77° F)
Packaging	Bottle

Notes
Ensure resin is at room temperature before using.

RESIN DISPENSING & PRINTING

Ratio	1 part
Speed	N/A
Mixing tip	N/A
Burn off	N/A
MMD	No
Pot life	N/A Reusable (filtered)
Release film	Not required/ optional

Dispensing Process
- Check the cassette. - Pour required resin amount into cassette using preferred measuring technique. - After printing, reuse, discard or filter and save resin for later use. - Always check liquid resin for solids between prints.

Notes
- Agitate bottle 1 HR before use, allowing time for bubbles to dissipate before dispensing. - Remove parts from platform shortly after printing to prevent deformation.

CURING

Cure start	Recommended directly after parts have dried.
Dreve PCU LED (with Nitrogen)	8 MIN at 80% intensity . Under vacuum recommended. Program Name: Gingiva 80 Available in Configuration File 1
Otoflash G171 (with Nitrogen)	3000 flashes per side . With Nitrogen recommended. Allow parts to cool completely before removal.

Curing Process
- Cure in UV post-cure unit (see left). - Check part for tackiness with a clean glove after curing cycle is complete. - Move part to contamination free zone.

Notes
- Safe for handling after UV curing. - After curing, finish as needed.