

Pac-Dent Rodin Sculpture Protocol



HARDWARE

Printer	M1	M2	M3 M3 Max
Cassette	C2	C2	D1

WASHING

Supplemental information available.

Solvent	Isopropanol (min.>96%)
Exposure	DO NOT SUBMERGE
Part Washer	No

Washing Process

1. Remove parts from platform.
2. Blow excess uncured resin from parts with compressed air
3. **Do NOT submerge in IPA for any amount of time. To remove resin, wet paper towel or foam swab with 99% IPA and wipe clean. A toothbrush dipped in IPA is also recommended.**
4. Dry with compressed air.
5. Repeat steps 3 & 4 as needed, but try and limit exposure to <30 seconds.
6. Transfer to paper towel lined tray.

Notes

- Post treatments recommended immediately following a completed print.
- Washing should occur no later than **8 hrs** after print completion.
- Stir thoroughly after adding fresh resin to existing resin in cassette

STORAGE

Temperature	5 - 30° C (41 - 86° F)
Packaging	Bottle

Notes

Ensure resin is at room temperature before using.

RESIN DISPENSING & PRINTING

Supplemental information available.

Ratio	1 part
Pot life	N/A Reusable after filtering
Release film	Not required/ optional

Dispensing Process

1. Check the cassette.
2. Pour **at least 2x** the required resin amount into cassette using preferred measuring technique.
3. After printing, reuse, discard or filter and save resin for later use.
4. Always check liquid resin for solids between prints.

Notes

Manufacturer recommends using a plastic spatula to stir the bottom of the bottle for several minutes before dispensing or mix using an automated bottle roller for 30 minutes.

Remove parts from platform shortly after printing to prevent deformation.

CURING

Supplemental information available.

Cure start	Recommended directly after parts have dried.
Otoflash G171 (with Nitrogen)	4500 flashes without flipping, under Nitrogen. Allow parts to cool completely before removal.
Dreve PCU LED	Cure parts for 15 MIN at 40% intensity, with Nitrogen. Program Name: Rodin Sculp • Available in Configuration File 1

Curing Process

- Apply light cured stains and/or glaze prior to cure
- 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, polish/finish as needed.
- Wash with soap and water before delivery to patient.