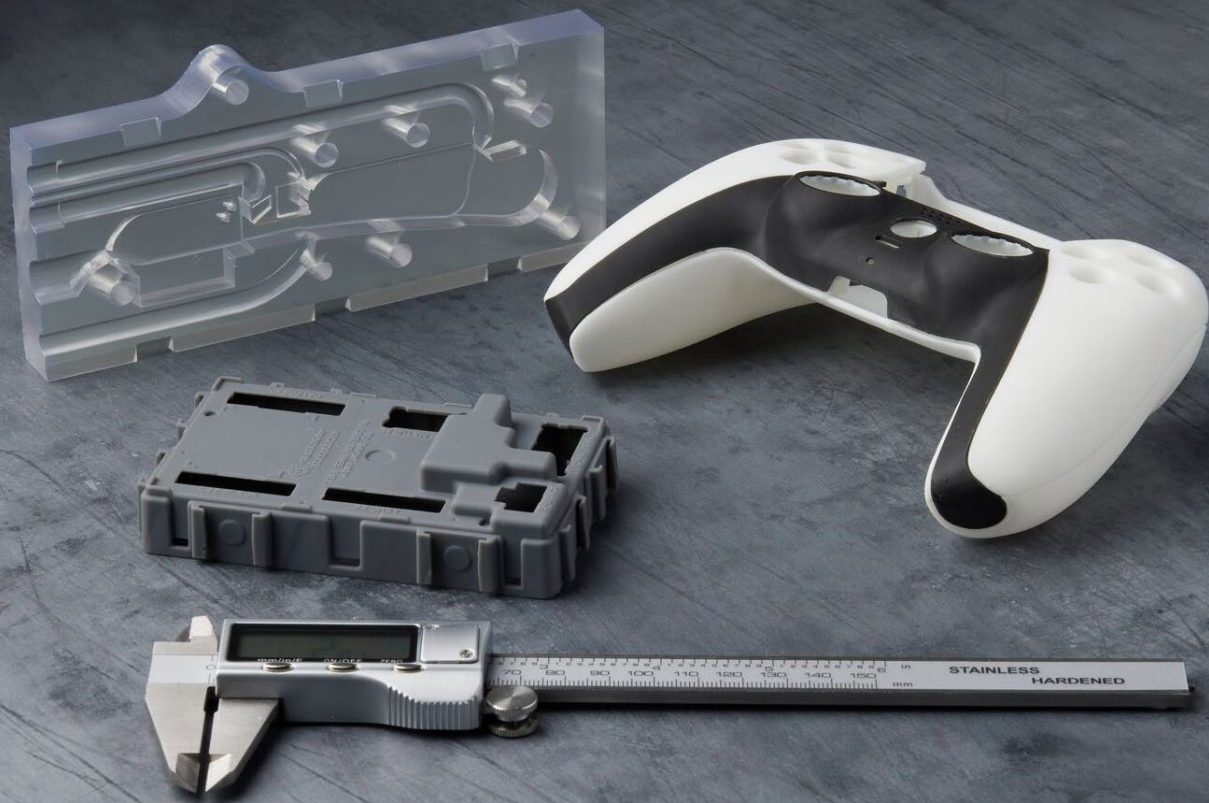




INSTRUCTIONS

Printing Instructions: Using Formlabs Resins on Low Cost Resin Printers

Learn how to use Formlabs Resins on low cost resin printers, including instructions for the validated printer settings, resin handling, and washing and curing steps to achieve the optimal 3D printed parts.

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Clear Resin V5

Clear Resin is an exceptionally clear and color-neutral 3D printing resin, offering an optimal balance of fast print speed, high accuracy, transparency, strong mechanical properties, and an easy, reliable workflow.

Clear Resin creates highly transparent and colorless parts that can be polished to near optical transparency. Create parts that are stiff and strong with a smooth surface finish that rivals acrylic.

Note: The optimal printing temperature is between 25 and 35°C.

Printing Instructions:

1. Remove the vent cap from the top of the resin cartridge. Carefully pour resin into the resin tank, below the fill line.
2. Use the provided print settings files with your preferred slicer, such as Chitubox or Lychee.
3. After the print finishes, wash the parts in >99% Isopropyl Alcohol for 10 minutes in an Anycubic Wash/Cure Combo or similar machine.
4. Allow the parts to fully dry.
5. Post-cure parts for 5 minutes in an Anycubic Wash/Cure Combo or similar machine.



White Resin V5

White Resin V5 is an exceptionally bright white General Purpose Resin, offering an optimal balance of fast print speed, high accuracy, presentation-ready appearance, strong mechanical properties, and an easy, reliable workflow.

Create parts that are stiff and strong with a surface finish that rivals injection molding. White Resin has a bright, matte shade that captures fine features accurately.

Note: The optimal printing temperature is between 25 and 35°C.

Printing Instructions:

1. Remove the vent cap from the top of the resin cartridge. Carefully pour resin into the resin tank, below the fill line.
2. Use the provided print settings files with your preferred slicer, such as Chitubox or Lychee.
3. After the print finishes, wash the parts in >99% Isopropyl Alcohol for 10 minutes in an Anycubic Wash/Cure Combo or similar machine.
4. Allow the parts to fully dry.
5. Post-cure parts for 5 minutes in an Anycubic Wash/Cure Combo or similar machine.



Grey Resin V5

Grey Resin is an exceptionally versatile General Purpose Resin, offering an optimal balance of fast print speed, high accuracy, presentation-ready appearance, strong mechanical properties, and an easy, reliable workflow.

Create parts that are stiff and strong with a surface finish that rivals injection molding. Grey Resin has a rich, matte color that captures fine features accurately.

Note: The optimal printing temperature is between 25 and 35°C.

Printing Instructions:

1. Remove the vent cap from the top of the resin cartridge. Carefully pour resin into the resin tank, below the fill line.
2. Use the provided print settings files with your preferred slicer, such as Chitubox or Lychee.
3. After the print finishes, wash the parts in >99% Isopropyl Alcohol for 10 minutes in an Anycubic Wash/Cure Combo or similar machine.
4. Allow the parts to fully dry.
5. Post-cure parts for 5 minutes in an Anycubic Wash/Cure Combo or similar machine.



Black Resin V5

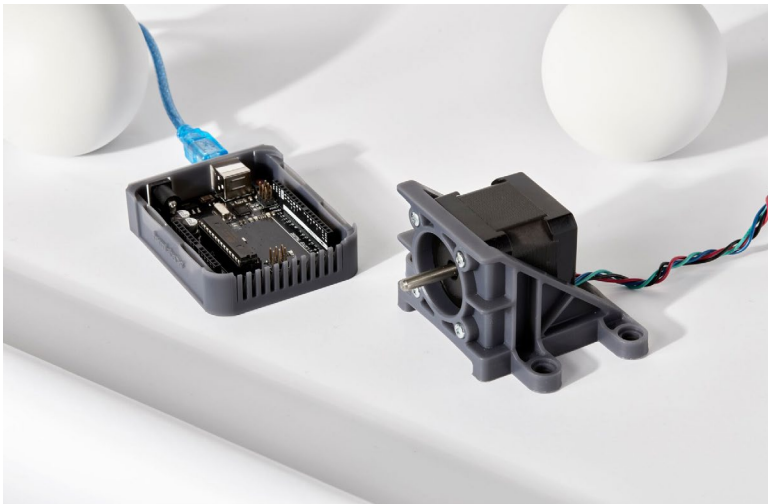
Black Resin is an exceptionally rich, deep black General Purpose Resin, offering an optimal balance of fast print speed, high accuracy, presentation-ready appearance, strong mechanical properties, and an easy, reliable workflow.

Create parts that are stiff and strong with a surface finish that rivals injection molding. Black Resin has a rich, matte shade that captures fine features accurately.

Note: The optimal printing temperature is between 25 and 35°C.

Printing Instructions:

1. Remove the vent cap from the top of the resin cartridge. Carefully pour resin into the resin tank, below the fill line.
2. Use the provided print settings files with your preferred slicer, such as Chitubox or Lychee.
3. After the print finishes, wash the parts in >99% Isopropyl Alcohol for 10 minutes in an Anycubic Wash/Cure Combo or similar machine.
4. Allow the parts to fully dry.
5. Post-cure parts for 5 minutes in an Anycubic Wash/Cure Combo or similar machine.



Tough 2000 Resin V1.1

Tough 2000 Resin has similar strength and stiffness to ABS plastics, making it ideal for functional parts that are difficult to bend and will hold up with extended use.

Choose Tough 2000 Resin for prototyping strong and sturdy parts that should not bend easily, as well as jigs and fixtures requiring minimal deflection.

Note: The optimal printing temperature is between 25 and 35°C.

Printing Instructions:

1. Remove the vent cap from the top of the resin cartridge. Carefully pour resin into the resin tank, below the fill line.
2. Use the provided print settings files with your preferred slicer, such as Chitubox or Lychee.
3. After the print finishes, wash the parts in >99% Isopropyl Alcohol for 10 minutes in an Anycubic Wash/Cure Combo or similar machine.
4. Allow the parts to fully dry.
5. Post-cure parts for 10 minutes in an Anycubic Wash/Cure Combo or similar machine. Mechanical properties will be +/-20% of those listed on the technical data sheet.
 - a. To achieve the same properties as listed on the technical data sheet, post-cure parts for 60 minutes at 70°C in a Form Cure unit or similar machine.