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ApplyLabWork MPT-SP001BK MSLA Spring Black Instructions

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ApplyLabWork

ApplyLabWork MPT-SP001BK MSLA Spring Black



Check

- Resin tank and LCD screen are clean
- Shake resin bottle well before use
- Tank and platform are properly fastened

Printer Settings Recommendation:

Brand	Model	Layer height (mm)	Bottom Layer counts	Exposure time (s)	Bottom Exposure (s)	Lifting Speed (mm/min)	Lifting Distance (mm)	Retract Speed (mm/min)
Phrozen	Sonic	0.1	6	4	30	60	8	120
	Sonic mini	0.1	6	5.5	30	60	8	120
	Sonic Mighty 4K	0.1	10	4	60	60	8	120
	Mars2 Pro	0.1	6	3.6	30	60	8	120
Elegoo	Mars3	0.1	6	3.6	30	60	8	120

Brand	Model	Layer height (mm)	Bottom Layer counts	Exposure time (s)	Bottom Exposure (s)	Lifting Speed (mm/s)	Lifting Distance (mm)	Retract Speed (mm/s)
Anycubic	MonoX	0.1	6	2.2	30	1	8	2

Light-off Delay = 15s under current lift-retract motion.

[When printing large object, increase Lifting Distance and recalculate Light-off Delay]

For Sonic Mighty 4K, please set Transition Layer Count to 20

Light intensity varies each printer. Please adjust exposure time $\pm 0.1 \sim 0.5$ second and/or XY dimension ratio according to printing result and part application.

Parts Recommendation:

- Avoid large aspect-ratio geometry (e.g. thin wall or long thin rod) in the structure to reduce failures.
- If support is needed, please set contact diameter > 1.2(mm), and density > 60%

Washing:

Wipe off excess resin on printed parts with paper towel, submerge into 95% IPA and place the container in ultrasonic bath, wash for 5 minutes. Replace by clean IPA and repeat ultrasonic washing for another 5 minutes (total 10 minutes). Blow off all excess IPA and set parts in a shaded, ventilated place to dry at least 2 hours before curing.

Dried print will be tacky to touch

APPLYLABWORK PRINTING INSTRUCTIONS

Post-curing (Mandatory):

Submerge the parts into glycerol/glycerin(CAS # 56-81-5) and start FormCure with 60 °C / 30 mins setting. Wash off glycerol in water and dry off with paper towel.

If prints don't sink completely into glycerol, add water (no more than half of volume) to adjust liquid density.

If prints are still tacky to touch after post-curing, rinse with acetone (CAS # 67-64-1) for no more than 1 minute will significantly reduce tackiness.

Storage:

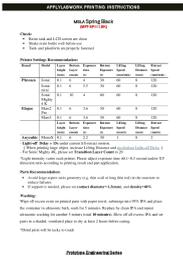
- Keep resin away from heat and light.
- NOT accessible to children.

Note:

- Keep printing environment well ventilated.
- Wear gloves when handling Spring resin and avoid direct contact.
- Vibration of the parts during printing process might cause resin splash onto printer's cover. Use paper towel and IPA to clean immediately.

- Don't leave the parts on building platform after printing for more than one day.
- Spring resin should NOT use with food, drink, or on/in the human body unless specifically indicated.

Documents / Resources



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