



ApplyLabWork S100 DLP Modeling Instructions

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**D75, S100, Pro95, & Pro55
DLP Modeling – Clear
(DMD-R001CR)**

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APPLYLABWORK PRINTING TIPS

Check:

- UV optical pathways are clean
- The resin tank is free of defect
- Resin is well shaken

RayWare: [MoonRay Pinter]

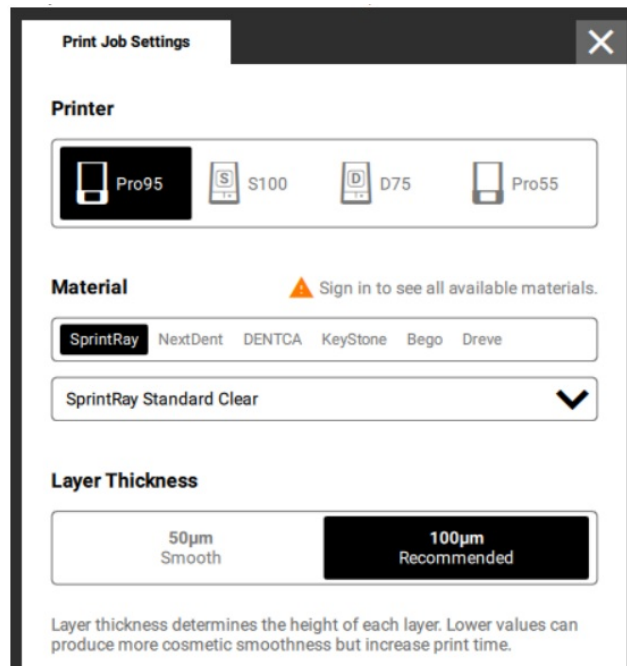
Open RayWare software(version 2.8.1 and later) and connect to the printer.

Print Setup:

Select printer model

Material SprintRay standard clear

Layer Thickness 50/100 µm



- When printing arches directly on the build platform, vertically or horizontally supports are not needed.
- For detailed calibration for resin can refer to [Dimension](#) and [Tolerance](#).

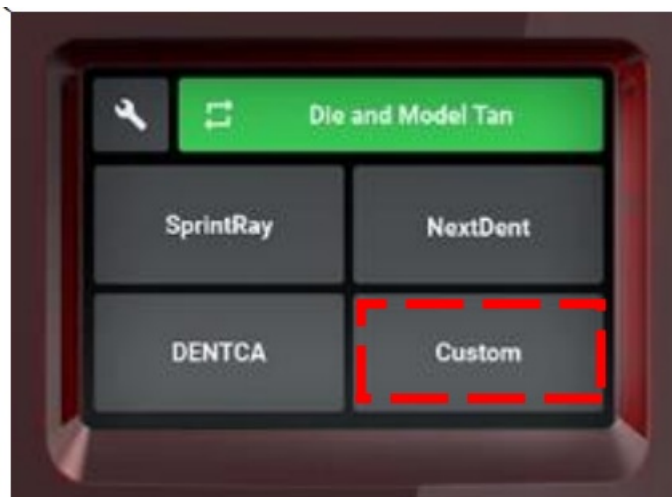
Washing:

IPA 95%, maximum for up to 5 minutes, gently shake off / blow off excess IPA quickly, and set print in a shaded airy place to dry completely before curing.

Extended time in IPA causes deformation. The dried print might be a little tacky to the touch.

Post-curing:

Pro-Cure: (firmware version 1.51 and later)



Select Custom, and then select the condition as30°C for 10 min.

Form Cure:

Select Custom Profile, and then select the condition as 60°C for 15 min.

Other:


Heat prints to 60°C, depending on the size, adjust time accordingly (15~40 mins). Move the warm print to the UV-curing chamber for 40 seconds. A yellow tint may appear after UV curing but will subside in a few days

Storage:

DO NOT keep the resin in the tank for more than 3 days. Filter out all debris in the case of failed print jobs

Design Concept Series

Documents / Resources

	<p>ApplyLabWork S100 DLP Modeling [pdf] Instructions S100 DLP Modeling, S100, DLP Modeling, Modeling</p>
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