

APPLYLABWORK PRINTING INSTRUCTIONS

MSLA Spring Black (MPT-SP001BK)

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 4 K	0.1	10	4	60	60	8	120
Elegoo	Mars2 Pro	0.1	6	3.6	30	60	8	120
	Mars3	0.1	6	3.6	30	60	8	120
		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

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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.