

Form 2 & 3 series printers Laser Spring Black (PT-SP001BK)

Check:

- Resin tank and optical path are clean
- Shake resin bottle well before use

Open-Mode (Form2):

Ensure the printer is idle

1. Tap **printer icon** on home screen
2. Select “**Settings**” menu
3. Select “**Open Mode**” function
4. swipe the bar on top right side to “**On**”

* **LT tank is required in Form2 printers**

Cartridge (Form2 & Form 3 series):

Refill the resin to durable-v2 cartridge.
Open air vent, turn cartridge upside down, drip dry through air vent for at least 5 mins to minimize cross contamination, refill, shake well for 2 minutes, insert and print.

Alternative solution: [North America](#) , [Other Regions](#)

PreForm Setting:

Select Printer: Form2 or Form3 series

Select Material: **durable v2**

Layer Thickness: 100µm

Job Setup	
1 Printer Type	Form 3/3+
2 Material	Durable V2
3 Layer Thickness	0.100 mm
4 Print Settings	Default

* please avoid any large aspect-ratio geometry (e.g. thin wall or long rod) in the object to reduce failures.

Washing:

Wipe off excess resin on prints 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 airy place to dry at least 2 hours before curing.

*Dried print will be tacky to touch

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:

- Do NOT keep the resin in the tank more than one week. Pour out the resin and gently wipe the tank with paper towel and IPA.
- 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 might cause resin splash onto printer 's cover. Use paper towel and IPA to clean immediately.
- Form2 printers usually give better printing quality than Form 3 series using Spring resin.
- Spring resin is sensitive to resin tank quality. Please use a new tank to print if repetitive failure occur, even within Form 3 tank lifetime.
- Spring resin should NOT use with food, drink, or on/in the human body unless specifically indicated.