

Graphy

We like creating specialized materials.

"Smart Materials"

Post Process Manual for S-100M

(Model Resin)

Rev.01(2021-06-30)

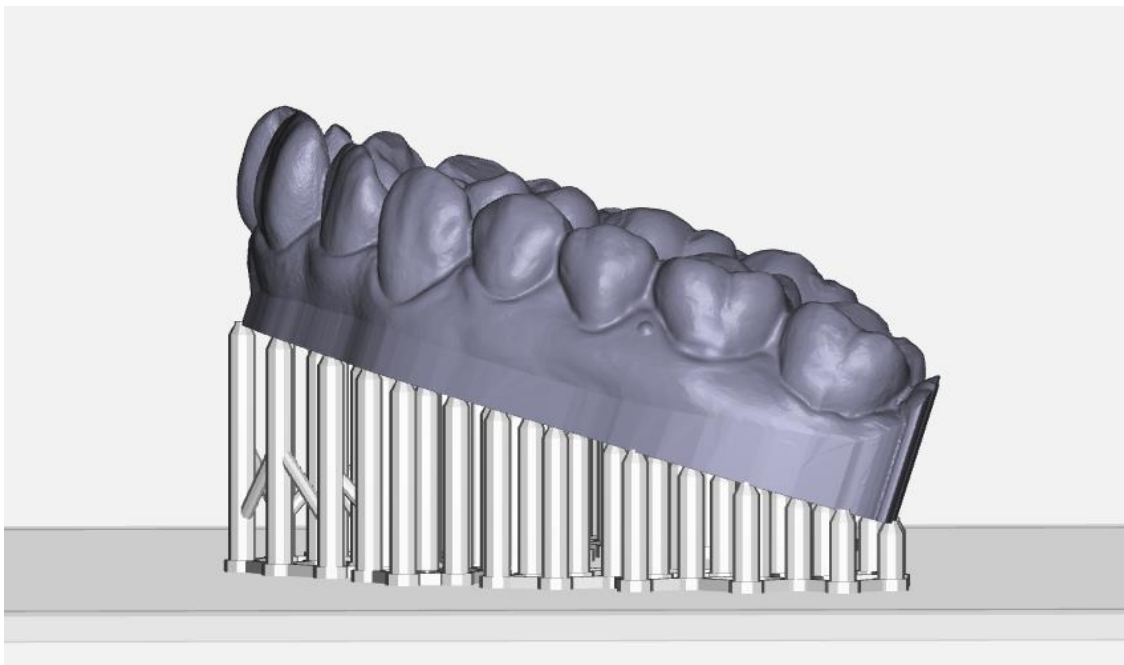


Contents

1. Precautions for setting support
2. Printing
3. Washing and support removal
4. Post-Curing

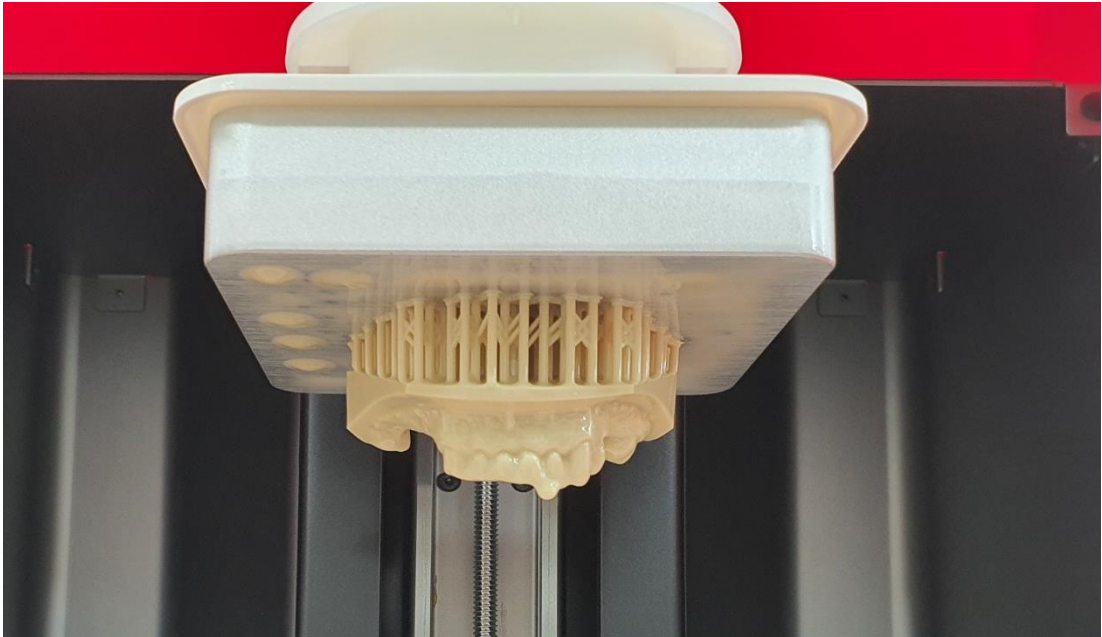


1. Precautions for setting support



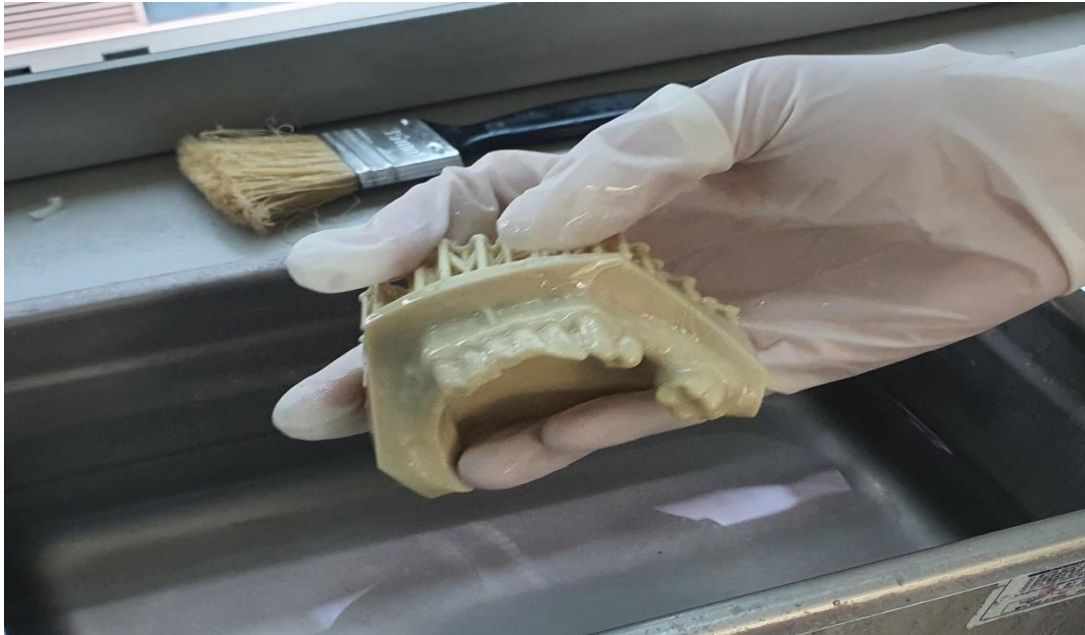
: For models with a large base like orthodontic study model, Printing success rate can be improved by lifting the labial and generate support to reduce the area of each layer.

2. Printing



: Detach the printed Model from the build plate of the 3D Printer with tool like the picture above.

3. Washing and support removal



: Wash off the residual resin on the surface of the Model using IPA(alcohol 99%) and ultrasonic cleaner.

: Primary washing time should be around 30 seconds.



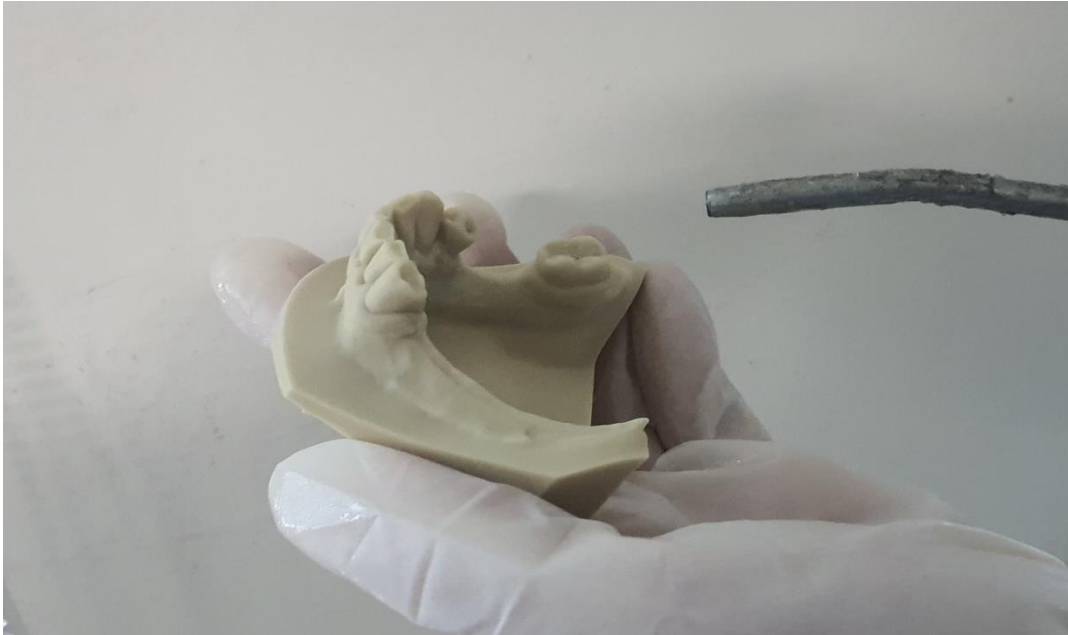
: Remove support by hand or nippers.

3. Washing and support removal



: Use soft brush to remove residual resin around undercut area and perform the second cleaning with IPA and ultrasonic cleaner. Be careful not to exceed 5 minutes in contact with the IPA and Model.

3. Washing and support removal



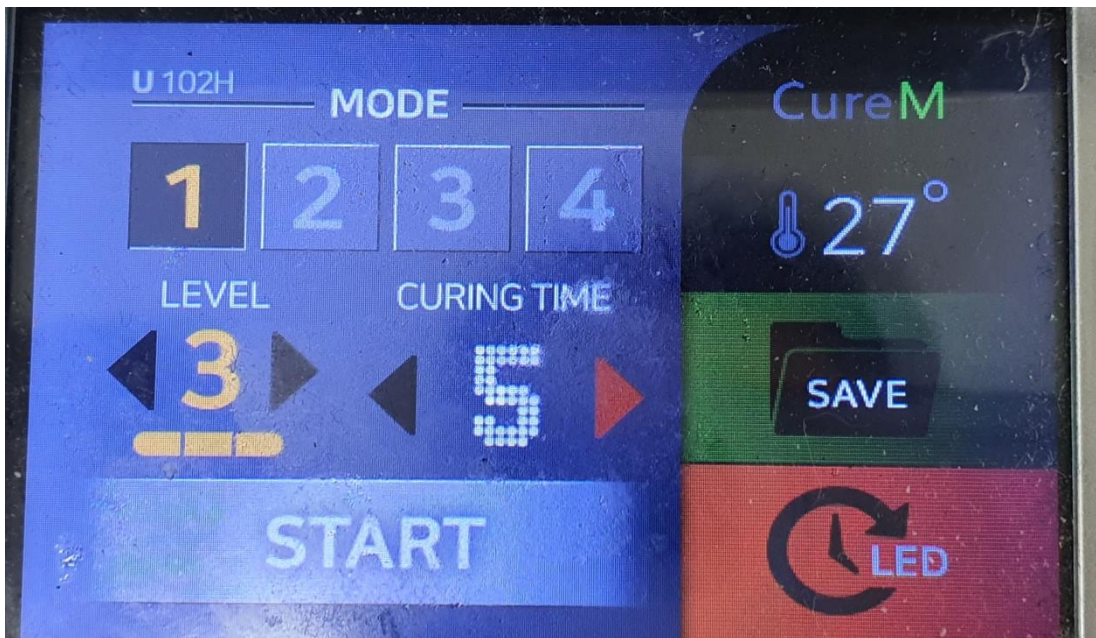
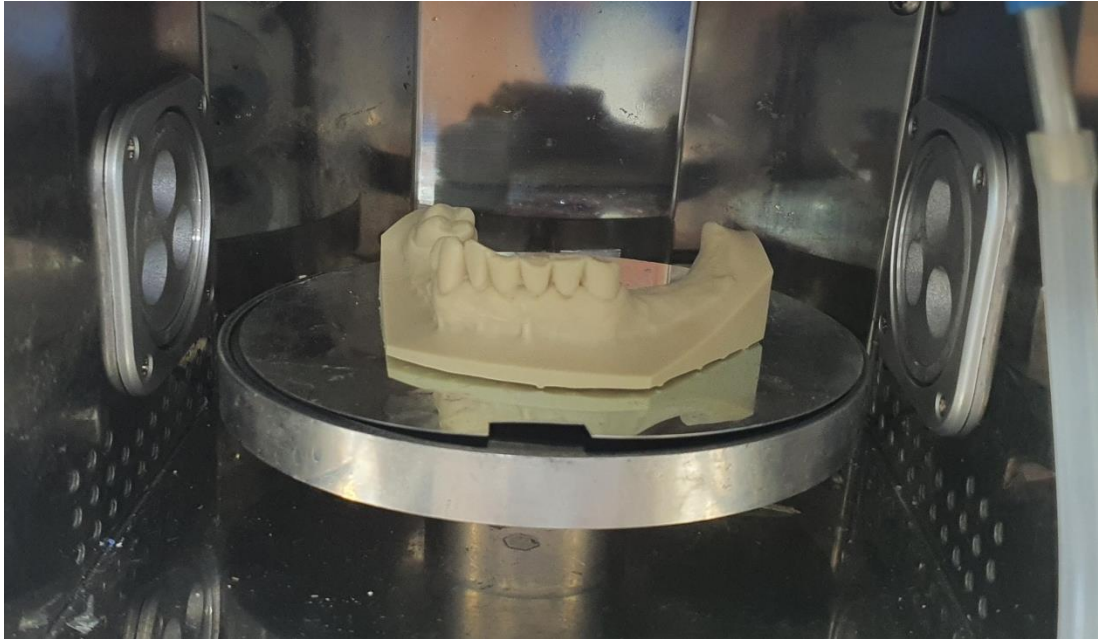
: Blow out the IPA using an air gun.



: Check the residual resin on the model surface.

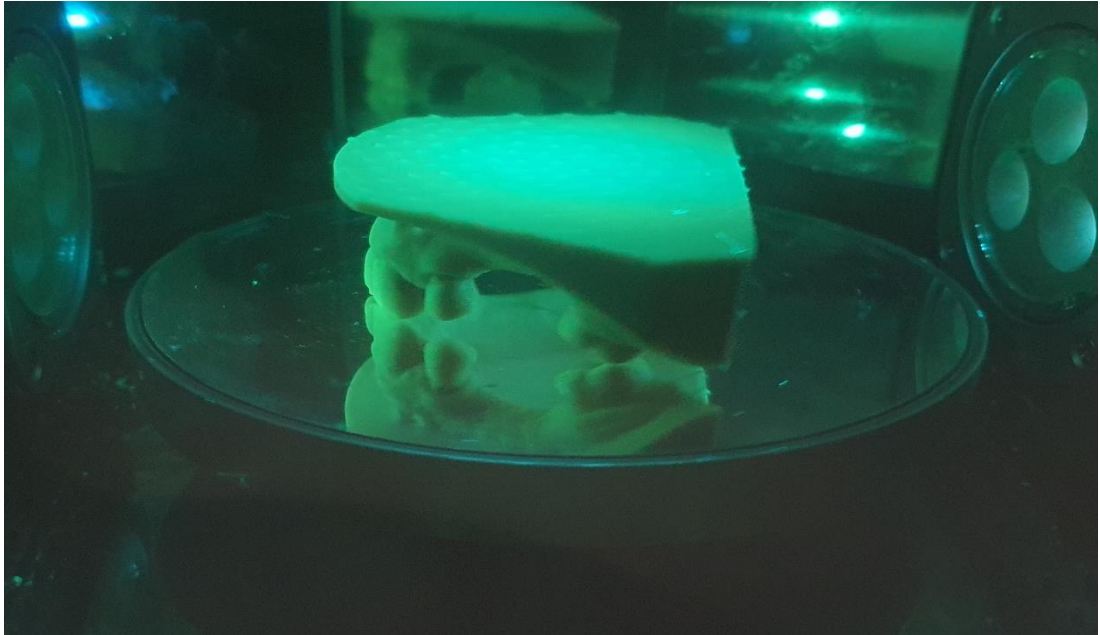
4. Post-Curing

: Post-curing consists of two steps.



- : Put the Model into the CureM.
- : cure for 5 minutes at Level 3 strength.

4. Post-Curing



: Do additional cure as needed until no sticky surface and disproportionate color are found.

