

Stratasys - Origin One Printer Settings

Resin: Loctite 3D IND402 A70 High Rebound Black

PRINT SETTINGS

Build layer (µm)	100
Irradiance (mW/cm ²)	5
Printer Temperature (°C)	25
Model Exposure (s)	6.5

PART CLEANING

Make & Model	Manual
Agitation	Hand
Wait time before Post Cure (min)	60

WASH CYCLE

Wash Cycle 1		Wash Cycle 2	
Cleaner	Cleaner T	Cleaner	IPA
Cleaning time & temperature	2 min at 60°C	Cleaning time & temperature	1 min at 25°C
Dry Time (s)	30	Dry Time (s)	30
Forced air (psi)	10-30	Forced air (psi)	10-30

POST CURE

Make & Model	Dymax - 5000 EC Flood
Wavelength	Metal Halide
Time per side (min/side)	5