

Origin One Printer Settings

Resin: Loctite 3D 3843 HDT60 HTO BK

PRINT SETTINGS

Build layer (µm)	100
Irradiance (mW/cm ²)	3
Printer Temperature (°C)	25
Model Exposure (s)	9.5

PART CLEANING

Make & Model	Post Process Tech - Demi 800
Agitation	Sonic
Wait time before Post Cure (min)	60

WASH CYCLE

Wash Cycle 1		Wash Cycle 2	
Cleaner	PLM-403-SUB	Cleaner	IPA
Cleaning time & temperature	4 min at 25°C	Cleaning time & temperature	2 min at 30°C
Dry Time (s)	60	Dry Time (s)	15
Forced Air (psi)	N/A	Forced Air (psi)	10 - 30

POST CURE

Make & Model	Dymax - 5000 EC Flood
Wavelength (nm)	Metal Halide
Irradiance (mW/cm ²)	150mW/cm ²
Placement	Shelf K
Time (min/side)	5