

## Stratasys - Origin One Printer Settings

Resin: Loctite 3D 3955 HDT280 FST Black

### PRINT SETTINGS

Build layer (µm)	100
Irradiance (mW/cm <sup>2</sup> )	5
Printer Temperature (°C)	60
Model Exposure (s)	5

### PART CLEANING

Make & Model	Purple Violet
Agitation	Sonic
Wait time before Post Cure (min)	No Wait Time

### WASH CYCLE

Wash Cycle 1		Wash Cycle 2	
Cleaner	TPM	Cleaner	TPM
Cleaning time & temperature	1 min at 80°C	Cleaning time & temperature	0.5 min at 80°C
Dry Time (s)	20	Dry Time (s)	20
Forced Air (psi)	30	Forced Air (psi)	30

### POST CURE

See Details on Data Sheet