

## Origin One Printer Settings

**Resin: LOCTITE 3D IND403 HDT80 High Modulus (Black)**

### PRINT SETTINGS

Build layer	100µm
Irradiance	5 mW/cm2
Printer Temperature	25°C
Model Exposure	7 sec
Projector DPI	1920 × 1080
Buildstyle reference	<a href="#">See here</a>

### PART CLEANING

Make & Model	Purple Violet
Model	JPS 100 A
Agitation	Sonic

### Wash Cycle

Cleaner	Isopropanol
Cleaning time & temperature	2 min at 25°C
Dry time	30 min
Forced air	25 psi

**Note** - Wiped with blue rag with IPA to confirm residue material was off.

### POST CURE

Make & Model	Heraeus LH6 - D-Bulb
Wavelength	405nm × 385nm

**Note:** Used Aluminum tray - (possible heat source) Lamp power 100% / 20ft/min. 16 per side flipping every 8 passes.