

Stratasys – Origin One

Resin: Loctite 3D IND403 BK

Printer Settings

Build layer	100 μm
Irradiance	5 mW/cm^2
Printer Temperature	25 $^{\circ}\text{C}$
Model Exposure	6.687 s

Wash Cycle

	Cycle 1	Cycle 2
Make/Model	Branson - 8800	Branson - 8800
Agitation Method	Sonic	Sonic
Cleaner	IPA	IPA
Cleaning time	2 min	2 min
Cleaner Temperature	20 $^{\circ}\text{C}$	20 $^{\circ}\text{C}$

Wait Before Post Curing

Wait time before Post Cure	60 min
Cleaning to Post Cure Temperature	22 $^{\circ}\text{C}$

Post Cure

Make & Model	Onulis - WRAP Cure Certified
Wavelength	405 nm LED
Settings	100 %
Irradiance	80 mW/cm^2
Temperature	N/A
Atmosphere or Immersion Media	Ambient
Placement	N/A
Time	60 min
Flip and Repeat (Yes/No)	No

OVEN CURE

Temperature	80 $^{\circ}\text{C}$
Temperature 1 Hold	3 hr