

## Stratasys – Origin One

Resin: Loctite 3D IND405 CL

### Printer Settings

Build layer	100 $\mu\text{m}$
Irradiance	5 $\text{mW}/\text{cm}^2$
Printer Temperature	25 $^{\circ}\text{C}$
Model Exposure	4.704 s

### Wash Cycle

	Cycle 1	Cycle 2	Cycle 3
Make/Model	Branson - 8800	Branson - 8800	N/A
Agitation Method	Sonic	Sonic	N/A
Cleaner	IPA	IPA	N/A
Cleaning time	2 min	2 min	N/A
Cleaner Temperature	20 $^{\circ}\text{C}$	20 $^{\circ}\text{C}$	N/A
Dry Time	0 s	0 s	N/A
Forced Air	N/A	N/A	N/A

### Wait Before Post Curing

Wait time before Post Cure	N/A
Cleaning to Post Cure Temperature	N/A

### Post Cure

Make & Model	Onulis - WRAP Cure Certified
Wavelength	405 nm LED
Settings	100%
Irradiance	80 $\text{mW}/\text{cm}^2$
Temperature	N/A
Atmosphere or Immersion Media	Ambient
Placement	N/A
Time	30 min
Flip and Repeat (Yes/No)	No

Additional post cure setting options: 30 minutes

