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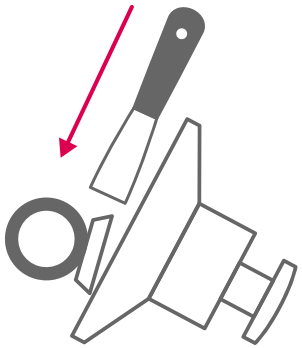
Cleaning your 3D print(s)

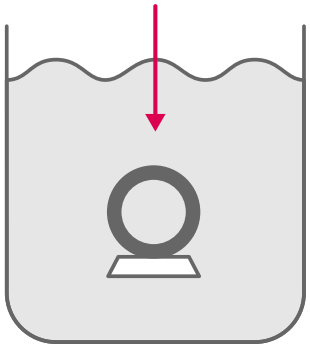
Please wear gloves for safety purposes

STEP 1



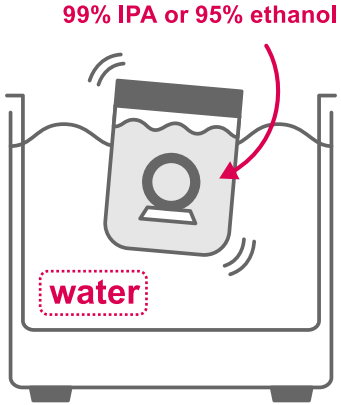
Remove your print(s) from the build plate.

STEP 2



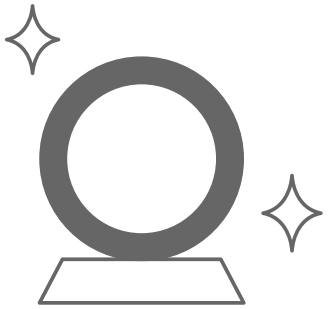
Using a glass container, submerge the print(s) in 99% IPA or 95% ethanol.

STEP 3



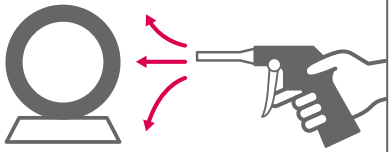
Tightly lock the glass container. Put it into the Phrozen Ultrasonic Cleaner and wash it in water for 1 min. Or you can choose to directly put your print(s) in an alcohol solution and shake vigorously for 30-40 secs. Remove and check your print(s) for residual resin.

STEP 4



If your 3D print(s) still contains residual resin, repeat STEP 3 until all residual resin has been cleaned.

STEP 5



Use a compressed air gun to blow dry your print(s). Check to see if there are any shiny patches. Repeat STEP 3 to 5 if shiny patches are found. YOUR ENTIRE PRINT(S) SHOULD HAVE A MATTE FINISH at the end.

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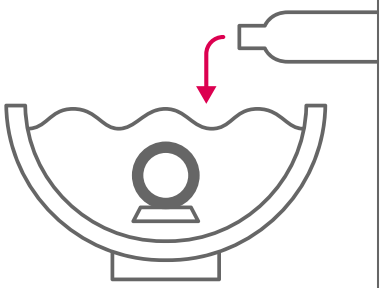
Curing your 3D print(s)

Please wear gloves for safety purposes

STEP 1

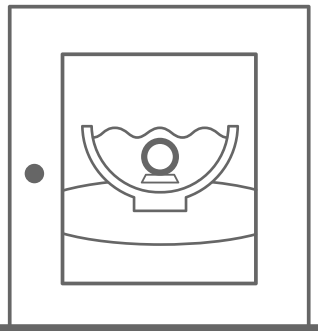
Place your 3D print(s) into a glass bowl.

STEP 2



Fill the glass bowl with lycerin until it covers the print(s).

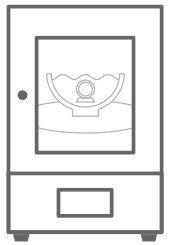
STEP 3



Then place the glass bowl into Phrozen Cure.

※You can also place the glass bowl in an environment with 60-watt, 390-405 UV curing light.

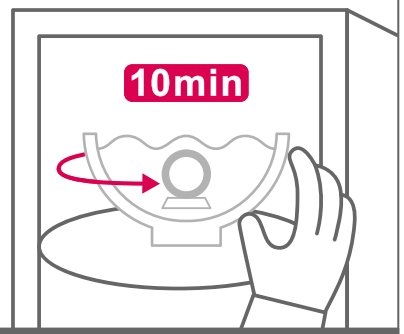
STEP 4



Turn the device on for approximately 30 to 40 min.

※Please note that cure times may vary based on the type of curing chamber used and differences in print(s).

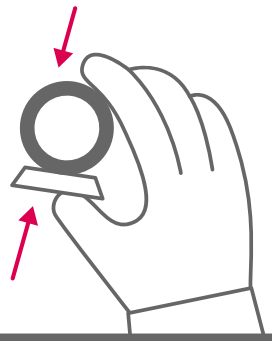
STEP 5



Rotate print(s) once every 10 min so that every part of your 3D prints gets evenly exposed to UV light.

※Phrozen Cure comes equipped with an automatic turntable.

STEP 6

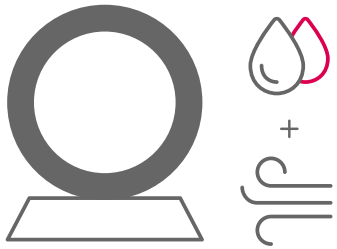


After curing, press your print(s) from different directions to check to see if your print(s) are completely cured.

STEP 7

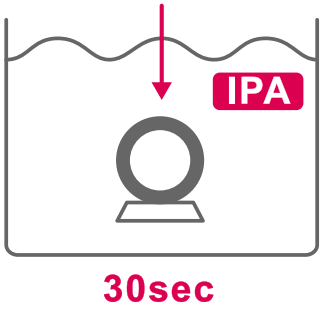
Repeat STEP 6 until your print achieves the desired stiffness.

STEP 8



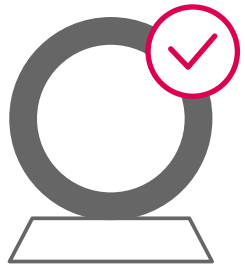
Wash part(s) in HOT WATER and then COLD WATER and then use a compressed air gun to completely dry off your print(s).

STEP 9



Submerge your print(s) in CLEAN IPA for 30 sec.

STEP 10



Once your print(s) are completely dry, it is ready.

※Print(s) should not be brittle, it should be extremely rigid. If any part of your print(s) seems soft, place it into Phrozen cure for an additional 10 min.

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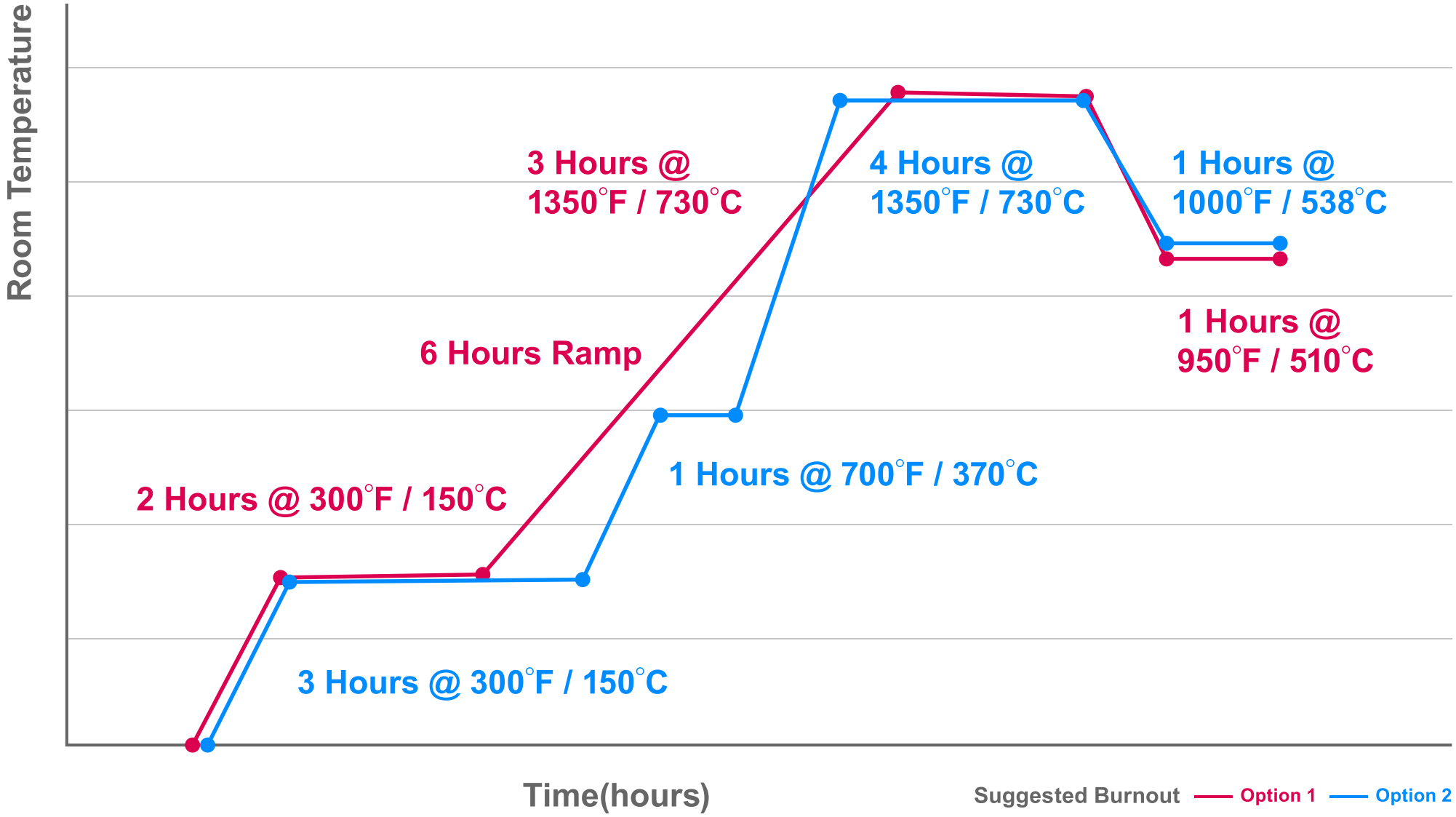
Two Recommended Burnout Schedules



*All ramp rates set at 28°F / 2°C per minute

*Exact schedule may vary slightly based on casting equipment used.