

BJM 3DP C&B DLP 385nm PRINTER WORKFLOW

PRINT SETTINGS

Layer thickness (μm)	Irradiance (mW/cm^2)	Exposure Time (s)
50	6.0	0.55
100	6.0	0.70
Printing Temp ($^{\circ}\text{C}$)	Wait after each layer(s)	XY Scale
30	7.0	1.008

	WASH CYCLE 1	WASH CYCLE 2
Agitation Method	Ultrasonic bath	Socked micro brush
Cleaner	IPA	IPA
Cleaning time (min)	3	-



WAIT BEFORE POST CURING

Waiting Time (min) 30

Temperature ($^{\circ}\text{C}$) 37

POST CURING

Model	Otoflash G171
Settings	N/A
Atmosphere	Ambient
Flashes	2000
Flip & Repeat	Yes

TERMAL TREATMENT

Ramp up ($^{\circ}\text{C} / \text{min}$)	N/A
Holding Temp. ($^{\circ}\text{C}$)	N/A
Holding Time (h)	N/A
Ramp down ($^{\circ}\text{C}/\text{min}$)	N/A