



STEP 1



3D Print the .stl file

Select the 3D Model .stl file
Set up suitable setting printer parameters
Add proper support structure keeping keeping intaglio free of supports
3D print the part

STEP 2



Clean the print (Short cycle)

C&B - C &B can be cleaned with IPA IPA spray and wipe .Excessive IPA cleaning in acyclone can cause a powdery surface due to resin removal from top layer. if cyclone is used , please use a short cycle (Approx 5 seconds)
Fpr Bio Compatible resins maintain a separate cleaning system with IPA to prevent cross contamination with TEC resins

STEP 3

**POST
PROCESSING**
cutting supports



Cut the support & check the fitment of pattern on Model

Cut the support by using a flash cutter .

Check the fitment of the 3D printed part on a corresponding model

STEP 4



Post Cure

Put the printed part in a glass beaker / Glass pot filled with glycerol (50%) +water (50%) and post cure in a curing chamber. This allows the oxygen inhibited layer to cure.Set curing time based on machine power
1. 30-50 watt- Cure for 20 mins
2. 60-80 watt -Cure for 10 mins
3. >100 watt- Cure for 3-5 mins

*Curing under nitrogen or vacuum will improve results



STEP 5

Check the fitting

Check the fitment of printed C&B on a corresponding model.

If it fits properly go to the next step



STEP 6

Polishing & Finishing

Polish with a rotary tool/brush applying light to moderate pressure



STEP 7

Glaze and Post Cure Glaze

Apply the D Tech Pro Glaze material evenly on the printed object using a micro brush. Cure 10-15 seconds in a curing chamber.

Dip the object in Glycerine (50%) + water (50%) mixture and cure it for another 30-40 seconds.

**Indirect Use Only*
NANO FILLED LIGHT ACTIVATED
"ONE FOR ALL" GLAZING SYSTEM



STEP 8

Second Polish

Polish again after the Glaze is fully cured. Polish again with a rotary tool/ brush applying light to moderate pressure.