

Post-processing Instructions

RODIN Sculpture (Ceramic Nanohybrid Resin)

NOTE: RODIN Sculpture contains abrasive fillers. If the build platform is metallic, wipe off excess resin on the build platform with a paper towel and discard. **DO NOT squeegee excess resin from build platform into the build tank.** DISCOLORATION OF THE RESIN MAY OCCUR.

1. After completion of print, remove the build platform from the printer
2. Using a paper towel, wipe off excess resin from the printed model
3. Remove the model from the build platform. **DO NOT soak the model in an alcohol bath**
4. Using a squirt bottle, rinse the part with alcohol. Alternatively, you can swirl the part around in an alcohol bath for **a couple of seconds**
5. For best results, use compressed air to blow excess resin from cracks and crevices and for drying the model
6. Repeat steps 4 and 5 until the model is thoroughly clean
7. Post-cure RODIN Sculpture in these validated light curing devices:
 - a. **Otoflash (recommended)** - 4500 flashes**
 - b. Dreve PCU LED N2 – 15min @ 40%**
 - c. Ackuretta Curie – 20min, P9, D2
 - d. Formlabs Form Cure – 10min @ 40C

**** Post curing under vacuum or with inert gas is recommended if applying light cured stains and/or glaze.**

Castable Resin - Start at step 3 from above

All Other Resins

Standard post-processing procedures may be used with all remaining resins.

1. Wipe off excess resin from the model then soak in an alcohol bath for 15min.
2. Use compressed air to clean and dry the model
3. Post-cure in a UV chamber using these settings:
 - a. **Otoflash (recommended)** - 4500 flashes**
 - b. Dreve PCU LED N2 – 20min @ 80%**
 - c. Ackuretta Curie – 10min, P16, D10
 - d. Formlabs Form Cure – 20min @ 60C