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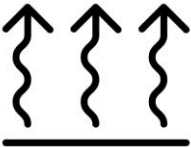









PART 4: CURE OBJECT





STEP BY STEP INSTRUCTIONS: CURING OBJECT




Cure Object

Typical Total Time to Cure Object: 45 minutes

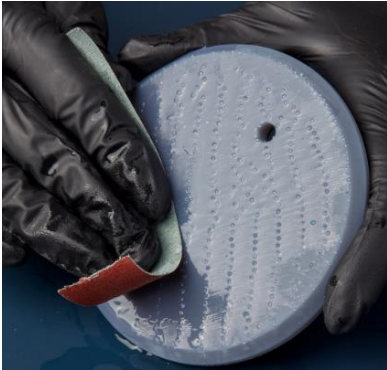


1	<p>Objects must be fully washed and dried before curing.</p>	<p>Post-curing parts with additional UV light and heat strengthens the polymer structure, improving strength, stiffness, and temperature resistance.</p>	
2	<p>Open Form Cure hood.</p>	<p>Open carefully.</p>  <p>The hood is heavy enough it will tip the unit if left to fall to a rest when opening.</p>	
3	<p>Place objects into Form Cure.</p> <p>Space parts evenly to allow light and heat to reach all areas of the objects.</p>		

4	Gently close hood.	<p>Use caution when closing hood.</p>  <p>The hood is heavy enough to tip unit.</p>	
5	<p>Set time and temperature for curing.</p> <ol style="list-style-type: none"> 1. <i>Turn</i> dial to highlight time/temperature. 2. <i>Push</i> dial to select time/temperature. 	<p>Black v4 Resin: 30 minutes 60 degrees Celsius</p> <p>White v4 Resin: 30 minutes 60 degrees Celsius</p> <p>Clear v4 Resin: 15 minutes 60 degrees Celsius</p>	
6	<p>Start Curing</p> <ul style="list-style-type: none"> • <i>Turn</i> dial to highlight Start • <i>Push</i> dial to select Start 	<p>The unit will begin to warm up. When it reaches temperature, the curing cycle will begin.</p>	

7	Lights and heater automatically turn off at end of curing cycle.	When the curing cycle has concluded, the lights will turn off and the unit will appear dark.	
8	Open hood of Form Cure.	Use caution when closing hood.  The hood is heavy enough to tip unit.	
9	Remove objects from Form Cure.	The objects are ready to be removed from the Form Cure unit. In the next steps you can remove supports.	

10	<p>Optional:</p> <p>Remove supports and clean up object at home.</p>	<p>At this point you are welcome to take your object home to perform the necessary post processing with your own tools.</p>	
11	<p>Before removing supports, put on safety equipment:</p> <ul style="list-style-type: none"> • Eye protection • Gloves • Dust mask (during sanding) 	 <p>Some methods of support removal may cause small pieces of supports to break away.</p> <p>Beware of flying debris.</p> <p>Wear safety glasses and gloves.</p>	

<p>12</p>	<p>Remove Supports.</p> <p>Use the flush cutters to carefully cut the supports attached to the object.</p> <p>You may also find a hobby knife, tweezers, and bent pliers helpful to remove supports at home.</p> <p>The library has a few tools for removing supports at the library including:</p> <ul style="list-style-type: none"> • Snips • Tweezers 	<p>Some methods of support removal may cause small pieces of supports to break away unexpectedly.</p> <p>Beware of flying debris. Wear safety glasses and gloves to protect the skin and eyes.</p> <p>Tools for in-library use located in labeled drawer.</p>	
<p>13</p>	<p>Dry Sanding as Needed at Home</p> <p>After removing supports, remove support marks by dry sanding or wet sanding.</p> <p>Depending on the object's application and desired finish, further post-processing steps may include priming and painting prints.</p> <p>The library does not provide sanding supplies.</p>	<p>Begin with the lowest or roughest grit sandpaper and sand surfaces as desired. Consider using a sequence of 150, 220, 400, 800, 1000, and 2000 grit sandpapers.</p>	

14	<p>Wet Sanding as Needed at Home</p> <p>Wet sanding reduces dust and creates a finer surface finish.</p> <p>The library does not provide wet sanding supplies.</p>	<p>Use mineral oil or water to wet sand printed parts. Wear gloves to keep dust and sanding liquid off your hands.</p>	
15	<p>Additional Post-Process Tips at Home:</p> <p>https://support.formlabs.com/s/article/Removing-Support-Marks</p>	<p>This article reviews some tips for additional methods to clean up the appearance of your object</p>	
16	<p>Clean Up</p> <ul style="list-style-type: none"> • Clean tools • Return tools to labeled storage • Return resin cartridge bottle to labeled cabinet • Return resin tank to labeled cabinet • Wipe down work areas • Tidy workspace 	<p>Additional cleaning supplies are located in lower cabinet near sink.</p>	
17	<p>See staff to return access key.</p> <p>Staff will:</p> <ul style="list-style-type: none"> • Check all tools are present and stored correctly • Check workspace is clean and tidy • Check-in access key 	<p>Failing to return keys can result in additional fees on your library card account.</p>	