# SOP for Formlabs Custom trays and Wax Rims

By:

Katherine Lala

Nesting: software is PreForm (blue butterfly)

- when the dialog box opens pick the printer of choice
  - resin is Custom Tray
  - layer thickness set to fastest print 200 microns
  - apply
- drag and drop files from the windows directory \dima Print Cast
- Orient print with the intaglio surface away from the plate (so that minimal supports get on it.)
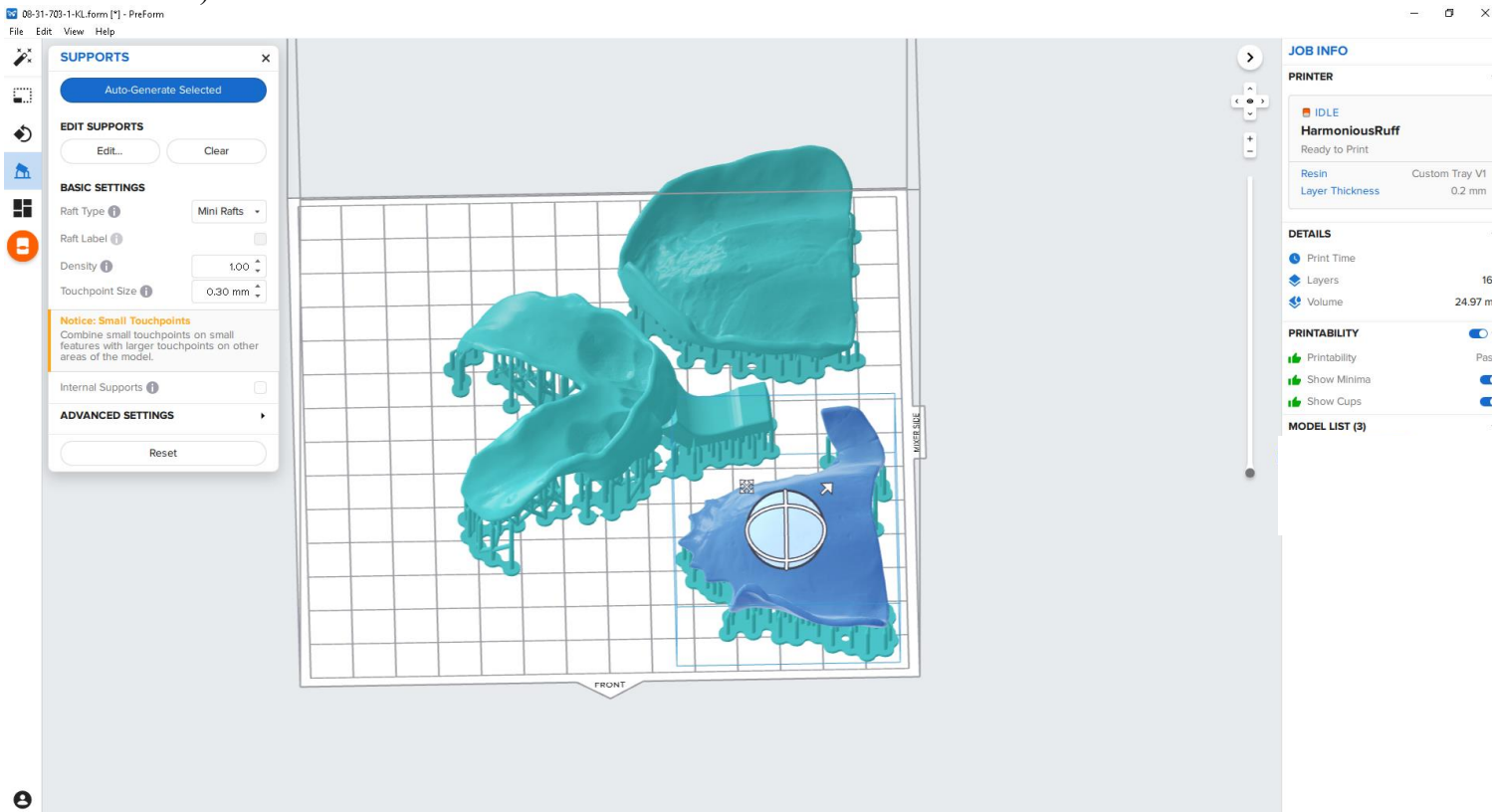
- if there are a fewer than five prints lay them flat to the plate as above
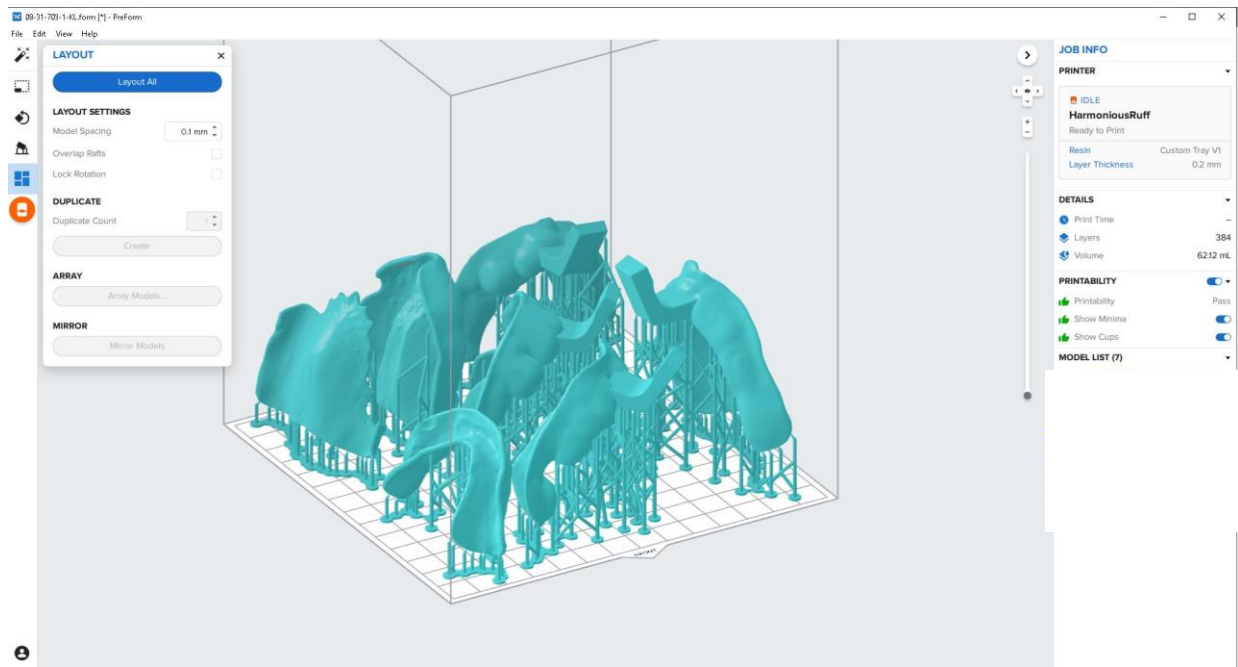
- – if there are more than that, stand them nearly vertical to the plate distal side to plate (with a slight tilt with the intaglio side away from the plate) as above
- – Supports:
  - – raft type = Mini rafts
  - – no raft labels
  - – density = 1.00
  - – touchpoint size = 0.30mm
  - – internal supports off
  - – Auto-Generate All
- – Check for and supports on the intaglio surfaces. Remove if necessary.
  - – For easier visibility select the model. It will turn blue and the supports will be green.
- – Layout All
- – Check the slices.
- – Save file as month-day-70(2/3)-#-initials
- – Check printability
- – use the Orange Printer button to send to the printer.

Printing:
- – Remove the resin tank and while holding upside down give it a left right shake. Put it back.
- – Open the vent on resin tank
- – check the plate (clean and proper position)
- – in the tiger mix the resin
- – verify that you have the correct file and hit print on the printer. Follow prompts.

Removal and Curing:
- – remove plate
- – at the processing station use the super bendy black handle scraper to remove the prints
- – place them in the dirty IPA for 280 seconds in the ultrasonic
- – blow out between supports and print

- place in clean IPA for 280 seconds
- give a light blow off and air dry for 30 minutes
- 30 minutes in the Accu-Cure
- remove supports and clean up with clippers

formlabs reference https://dental.formlabs.com/indications/custom-trays-guide/