# **Form2 Printing Instructions:**

## **How the printer works:**

Resin is cured onto the build platform via a laser that travels through the mirror and the underside of the build tray.

## **General Rules:**

* Avoid touching the mirror and underside of the build tray. Clean with glass cleaner and lint free cloth if touched or if there are splotches.
* Use IPA to clean the black areas of the build platform
* Do not use IPA on the silver metal part of the build platform
* Do not allow resin to contact ANY part of the printer except inside the build tray and the build platform

## **Preparing the Part on Preform**

* **Orient** parts
* Add **supports**
* **Inspect** the build tray and move parts so they are not on the cloudy parts of the tray
* **Record** the volume of resin required

## **Loading the Part on the Printer**

* **Wear Gloves**
* **Remove the build platform** and scrape the silver metal part of the build platform using the spatula so that it is clean
* **Attach the build platform** and use IPA soaked paper towel to wipe down the black portions of the build platform – do not allow IPA to touch the metal part or drip into the build tray that has the resin
* Remove the wiper, set aside, wipe down the outer part with IPA soaked paper towel if sticky. Don’t wipe the resin-soaked part.
* **Remove Gloves**
* **Inspect build tray**, using the spatula to move through the resin to ensure that there are no small pieces of cured resin or other artefacts inside the build tray. If there are big chunks, discard them. If there are small pieces, the resin must be filtered out and new resin put in. Note: if there are small particles in the resin, the print may fail, which may cause some damage to the printer.

1. **Wipe down** ONLY the sides of the build tray with IPA soaked paper towel so they are not sticky.
2. Ensure the **resin level** is within the fill line indicated on the build tray.
3. **Insert the build tray** then wiper.
4. **Start** the print.

## **Weekly Maintenance**

* Wipe mirror with lint free cloth and glass cleaner
* Grease the screw