**Form 3 Printing and Set-up**

**Preform**

1. Import your 3D file into the Preform program by going to *File > Open...* and insert your STL or OBJ file.
2. If the size of the model is correct, there is no need to scale the object in the ***Size*** tab. When creating an enclosure for a PCB or BreadBoard you won’t want to use the scale feature.
3. In the ***Orientation*** tab, if the object is flat, you can select the bases of the objects by clicking ***Select Base...*** and not use any supports.
4. In the ***Orientation***tab, you can also add supports and internal supports. Either use the ***Auto-Generate***or add supports manually in the ***Supports*** tab.
5. If there is more than one object in the printer, use the *Layout* feature to set up an efficient print.
6. Once the print is set up, click the orange print button to check that the materials being used, the printer, and the account are correct.

**Print Setup**

1. Make sure that the correct cartridge and tray are installed in the Form 3 printer as well as the build platform.
   1. Always wear gloves when transporting or touching resin.
   2. Never touch the bottom of the resin tray, **only carry by the sides**.
   3. If using a different resin, make sure to shake the cartridge well before installing.
   4. Make sure to be gentle when inserting the tank to forego spills and contaminating the electronics of the printer.
2. Prime the printer if not already in progress.
3. Push ***Print*** on the printer itself if there is a notification to do so.
4. In the online formlabs group, you can track the status of a print online and get a notification when it is finished.

**Wash/Cleanup**

1. Wearing gloves, open the top to the printer and remove the build platform and close the printer.
2. Use the *Finish Kit* to remove the parts from the build platform and scrap any left over residue off and wipe with a paper towel. Note: Take extra care not to get any resin directly onto the tabletop, and wipe up any spilt resin with an alcohol soaked paper towel.
3. Once the prints are off of the platform, place them in the first wash container making sure to agitate and move the part around. Move to the second washing container to get any remnants off of the piece.
4. After going through the two manual washing stations, allow the prints to dry on a paper towel on top of the *Finishing Kit* lid so as to not damage the table.
5. Once dry, put the prints in the UV Curing station at 35 C for 20 minutes. If it did not fully cure, put in the print in the curing station at a different orientation for another 10 minutes or place in the sunlight for a natural UV cure.