

Rayshape – Shape 1+ HD

Resin: Loctite 3D IND147 HDT230 BK

PRINT SETTINGS

Build layer	100 µm
Irradiance	6 mW/cm ²
Printer Temperature	25 °C
Model Exposure	8 s

Wash Cycle

	Cycle 1	Cycle 2	Cycle 3
Make/Model	Rayshape - ShapeWash M	Rayshape - ShapeWash M	Rayshape - ShapeWash M
Agitation Method	Sonic	Sonic	Sonic
Cleaner	IPA	IPA	IPA
Cleaning time	1 min	30 s	30 s
Cleaner Temperature	25 °C	25 °C	25 °C
Dry Time	10 s	10 s	10 s
Forced Air	10-30 psi	10-30 psi	10-30 psi

Wait Before Post Curing

Wait time before Post Cure	60 min
Cleaning to Post Cure Temperature	25 °C

POST CURE

Make & Model	Rayshape - Shape Cure +
Wavelength	405 nm LED
Settings	N/A
Irradiance	110 mW/cm ²
Temperature	N/A
Atmosphere or Immersion Media	N/A
Placement	N/A
Time	90 min
Flip and Repeat (Yes/No)	Yes