



LSPc™ Washing & Curing Recommendations

Resin	Wash Regime	Post-Cure (min) <i>Flip Halfway Through Cycle</i>			Post Bake
		Wash+Cure	xCURE	xCURE Desktop	
xMODEL15	I. 4 min xCLEAN II. 2 min Isopropanol	30	30	8 @ 50%	-
PRO9499-White		60	30	TBC	-
xABS3843		60	60	20 @ 50%	2hr @ 120°C
xMODEL35		60	60	TBC	-
xPP405-Black		60	60	20 @ 50%	-
xPRO410		60	60	TBC	-
xPRO9400-FR		60	60	20 @ 100%	3hr @ 150°C
xCE-Black		60	60	TBC	-
xMODEL17-Clear	4 min Isopropanol	20	30	TBC	-
xDENT201-Gray		30	30	10 @ 50%	-
xDENT341-Beige		30	30	10 @ 50%	-
xFLEX475-White	I. 2 min Isopropanol II. Spray or dip with Mold Release Agent III. Rest 5 minutes	60 in water	30 in water	TBC	-
xFLEX475-Black		90 in water	60 in water	TBC	-
xFLEX402	I. 2 min xCLEAN II. 2 min Isopropanol	60	60	TBC	-
xPEEK147		60	60	20 @ 100%	3hr @ 170°C
xESD	I. 8 min xCLEAN II. 8 min Isopropanol	40	45	TBC	-
xCERAMIC3280	4 min brushing in Isopropanol <i>~do not use Ultrasonic~</i>	60	60	20 @ 100%	2hr @ 150°C
xMOLD		30	60	10 @ 50%	-

NOTES

1. Remove supports before washing and curing for best results.
2. Multiple baths are recommended, but the final rinse should be in clean solvent.
3. Avoid washing white or clear materials in the same bath at dark materials.
4. Wash submerged in agitated bath such as stirred or ultrasonic unless noted.
5. Blind holes and small passages require manual flushing before washing.
6. Dry immediately after rinsing with forced air and verify not tacky before curing.
7. Place items in the center of cure chamber and flip half way through curing cycle if not on clear elevated shelf.
8. Post-bake is required to achieve advertised mechanical properties. Ramp up and down slowly, 1.5°C/min.
9. Find additional information on TDS and application notes at nexa3d.com