

XiP Workspace Setup Checklist

-  **Environment** Nexa3D printers are intended for indoor use only. Make sure the workspace is dry, well ventilated, and dust free. Choose a work surface for the printer that is stable and level. Locate your workspace away from food, drinks, and other consumable products. Floors should be washable and watertight in case of spills or drips.
-  **Lighting** Avoid direct sunlight. Minimize UV light to prevent unintended curing of resin. Fluorescent or LED lighting is preferred. Windows should be treated with UV blocking film.
-  **Climate Control** Maintain ambient temperatures ranging 70-80°F / 20-27°C and relative humidity ranging 10% - 70%. Working outside those limits may result in low quality performance.
-  **Power** You will need a conventional 100-240Vac, 50/60Hz grounded power outlet. A surge protector is recommended.
-  **Finishing Activities** Any dust-generating activities should be physically separated (sanding supports, etc.)
-  **Personal Protective Equipment (PPE)** Have on hand nitrile gloves, protective glasses rated for 99.9% UVA protection, a non-porous lab coat to protect skin from resins, solvents, and UVA radiation, and vapor respirator if recommended by the safety data sheet (SDS) of the resin or solvent.
-  **Cleaning Supplies** Keep a ready supply of paper towels or microfiber washcloths for spills and cleanup. Spray with isopropyl alcohol to remove resin residue from tools or surfaces.
-  **Resin Storage Resin** polymerizes when exposed to UV light sources, including sunlight. Store resin in original containers and in a cool, dark location away from sunlight.
-  **Resin Waste** Have dedicated waste storage for resin-contaminated wipes & gloves. This may not be a hazardous waste in your jurisdiction. Nexa3D recommends treating it as chemical waste
-  **Solvent Storage** Most cleaning solvents are flammable. Don't use near open flame and ensure adequate ventilation and spill containment measures are in place.
-  **Solvent Waste** Storage Most jurisdictions consider typical solvents used a hazardous waste. Storing in labeled UN or DOT-certified containers is recommended.