

RESIN	WASH TIME	POST-CURE SETTING	CURE TIME	CURE TEMP	Notes
Black Resin Color Resin Grey Resin	10	Recommended <sup>1</sup>	30	60 °C	<ul style="list-style-type: none"> <li>When washed in TPM, standard resins remain waxy when printed with a layer thickness of 50 microns or 100 microns. Post-curing removes waxiness. Without post-curing, waxiness goes away after about a week.</li> </ul>
		Full post-cure	60	60 °C	
BioMed Amber Resin	20	Full post-cure <sup>2</sup>	30	Form 2: 60 °C Form 3B: 70 °C	<ul style="list-style-type: none"> <li>Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations.</li> <li>Maintain separate wash buckets for biocompatible materials.</li> </ul>
BioMed Clear Resin	15 + 5	Full post-cure <sup>2</sup>	60	60 °C	<ul style="list-style-type: none"> <li>Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations.</li> <li>Maintain separate wash buckets for biocompatible materials.</li> <li>Wash for 15 minutes then remove parts and soak in fresh IPA for 5 minutes.</li> </ul>
Castable Resin	10	Full post-cure <sup>3</sup>	240	60 °C	<ul style="list-style-type: none"> <li>Maintain separate wash buckets to avoid color transfer.</li> <li>Wash Castable Resin for the shortest time necessary.</li> <li>When washed in TPM, Castable Resin remains waxy when printed with a layer thickness of 50 microns or 100 microns, but the waxiness goes away after 3–12 hours.</li> </ul>
Castable Wax Resin Castable Wax 40 Resin	5	N/A <sup>4</sup>	N/A	N/A	<ul style="list-style-type: none"> <li>Maintain separate wash buckets to avoid color transfer.</li> <li>Wash for 5 minutes, then remove parts and rinse in fresh IPA.</li> <li>Wash Castable Wax Resin for the shortest time necessary.</li> <li>When washed in TPM, Castable Wax Resin comes out of the wash clean and free of waxiness, requiring no post-curing. If parts are sticky after washing in TPM, Formlabs recommends post-curing for optimal casting results.</li> </ul>
Ceramic Resin	5	N/A <sup>4</sup>	N/A	N/A	<ul style="list-style-type: none"> <li>Maintain separate wash buckets to prevent ceramic particles adhering to parts printed with other resins.</li> </ul>
Clear Resin	10	Recommended <sup>1</sup>	15	60 °C	<ul style="list-style-type: none"> <li>When washed in TPM, standard resins remain waxy when printed with a layer thickness of 50 microns or 100 microns. Post-curing removes waxiness. Without post-curing, waxiness goes away after about a week.</li> </ul>
		Full post-cure	30	60 °C	
Custom Tray Resin	10	Full post-cure <sup>2</sup>	30	60 °C	<ul style="list-style-type: none"> <li>Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations.</li> <li>Maintain separate wash buckets for biocompatible materials.</li> </ul>
Dental LT Clear Resin V1	20	Full post-cure <sup>2</sup>	20	80 °C	<ul style="list-style-type: none"> <li>Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations.</li> <li>Maintain separate wash buckets for biocompatible materials.</li> <li>Do not leave Dental LT Clear Resin V1 in IPA for longer than 20 minutes total, as excessive solvent exposure affects the quality of the final part.</li> </ul>
Dental LT Clear Resin V2	15 + 5	Full post-cure <sup>2</sup>	60	60 °C	<ul style="list-style-type: none"> <li>Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations.</li> <li>Maintain separate wash buckets for biocompatible materials.</li> <li>Wash for 15 minutes, then remove parts and soak in fresh IPA for 5 minutes.</li> <li>Do not leave Dental LT Clear Resin V2 in IPA for longer than 20 minutes total, as excessive solvent exposure affects the quality of the final part.</li> </ul>
Dental SG Resin	10 + 10	Full post-cure <sup>2</sup>	30	60 °C	<ul style="list-style-type: none"> <li>Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations.</li> <li>Maintain separate wash buckets for biocompatible materials.</li> <li>Wash for 10 minutes, then remove parts and soak in fresh IPA for 10 minutes.</li> <li>Do not leave Dental SG Resin in IPA for longer than 20 minutes total, as excessive solvent exposure affects the quality of the final part.</li> </ul>
Denture Teeth Resin Denture Base Resin	20	Full post-cure <sup>5</sup>	30 + 30	80 °C	<ul style="list-style-type: none"> <li>Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations.</li> <li>Maintain separate wash buckets for biocompatible materials.</li> </ul>
Draft Resin	10	Better elongation	5	No heat	<ul style="list-style-type: none"> <li>Tackiness has been observed on part surfaces when washed in alcohol with more than 5% resin concentration.</li> <li>Avoid washing Draft Resin for longer than the recommended time.</li> </ul>
		Better UTS	5	60 °C	

Durable Resin	20	Full post-cure <sup>6</sup>	60	60 °C	<ul style="list-style-type: none"> <li>When washed in IPA with a resin concentration of more than 10%, tackiness has been observed on part surfaces.</li> <li>Do not leave Durable Resin in solvent for longer than 20 minutes total, as excessive solvent exposure affects the quality of the final part.</li> </ul>
Elastic 50A Resin	10 + 10	Full post-cure	20	60 °C	<ul style="list-style-type: none"> <li>Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes.</li> <li>Do not leave Elastic 50A Resin in solvent for longer than 20 minutes total, as excessive solvent exposure affects the quality of the final part.</li> </ul>
Flexible Resin	10 + 10	Recommended <sup>1</sup>	15	60 °C	<ul style="list-style-type: none"> <li>Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes.</li> <li>When washed in TPM, Flexible 80A Resin and Flexible Resin V2 remains waxy when printed at any layer thickness. and requires post-cure. Post-curing removes waxiness.</li> </ul>
		Full post-cure	60	60 °C	
Flexible 80A Resin		Full post-cure	10	60 °C	
Soft Tissue Resin Grey Pro Resin	15	Full post-cure <sup>7</sup>	15	80 °C	<ul style="list-style-type: none"> <li>When washed in TPM, Grey Pro Resin comes out of the wash clean and free of waxiness.</li> </ul>
High Temp Resin V1	6	Recommended <sup>1</sup>	30	60 °C	<ul style="list-style-type: none"> <li>Do not leave High Temp Resin in solvent for longer than 6 minutes total, as excessive solvent exposure affects the quality of the final part.</li> </ul>
		Full post-cure	60	60 °C	
High Temp Resin V2		Recommended <sup>8</sup>	120	80 °C	
IBT Resin	20	Full post-cure <sup>2</sup>	60	60 °C	<ul style="list-style-type: none"> <li>Exceeding wash duration may affect dimensional accuracy and performance of printed parts over time.</li> </ul>
Model Resin	10	Recommended <sup>1</sup>	30	60 °C	<ul style="list-style-type: none"> <li>When washed in IPA with a resin concentration of more than 10%, tackiness has been observed on part surfaces.</li> <li>When washed in TPM, Model Resin remains waxy when printed with a layer thickness of 50 microns or 100 microns, but the waxiness goes away after 2-12 hours.</li> </ul>
		Full post-cure	60	60 °C	
Permanent Crown Resin	3	Full post-cure <sup>9</sup>	20 + 20	60 °C	<ul style="list-style-type: none"> <li>Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations.</li> <li>Maintain separate wash buckets for biocompatible materials.</li> <li>Do not leave Permanent Crown Resin in IPA for longer than 3 minutes total, as excessive solvent exposure affects the quality of the final part.</li> <li>Use an IPA-filled squeeze bottle to remove any remaining resin on the printed parts and in between supports and rafts. An IPA-soaked brush may help with resin removal.</li> </ul>
Rigid 4000 Resin	15	Full post-cure <sup>7</sup>	15	80 °C	<ul style="list-style-type: none"> <li>Maintain separate wash buckets to prevent glass particles adhering to parts printed with other resins.</li> <li>When washed in TPM, Rigid Resin comes out of the wash clean and free of waxiness.</li> </ul>
Rigid 10K Resin	10 + 10	Recommended <sup>3</sup>	60	70 °C	<ul style="list-style-type: none"> <li>Maintain separate wash buckets to prevent glass particles adhering to parts printed with other resins.</li> <li>When washed in TPM, Rigid 10K Resin comes out of the wash clean and free of waxiness.</li> </ul>
		Thermal post-cure	90	125 °C	
Surgical Guide Resin	20	Full post-cure <sup>2</sup>	30	Form 2: 60 °C Form 3B: 70 °C	<ul style="list-style-type: none"> <li>Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations.</li> <li>Maintain separate wash buckets for biocompatible materials.</li> </ul>
Temporary CB Resin	3	Full post-cure <sup>9</sup>	20 + 20	60 °C	<ul style="list-style-type: none"> <li>Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations.</li> <li>Maintain separate wash buckets for biocompatible materials.</li> <li>Do not leave Temporary CB Resin in IPA for longer than 3 minutes, as excessive solvent exposure affects the quality of the final part.</li> <li>Use an IPA-filled squeeze bottle to remove any remaining resin on the printed parts and in between supports and rafts. An IPA-soaked brush may help with uncured resin removal.</li> </ul>
Tough 2000 Resin	10 + 10	Recommended <sup>1</sup>	60	70 °C	<ul style="list-style-type: none"> <li>When washed in IPA with a resin concentration of more than 5%, tackiness has been observed on part surfaces.</li> <li>When washed in TPM, Tough 2000 Resin and Tough Resin V5 comes out of the wash clean and free of waxiness.</li> </ul>
Tough Resin V5		Recommended <sup>1</sup>	60	60 °C	

		Full post-cure	<b>120</b>	<b>60 °C</b>	and free of waxiness.
<b>Tough 1500 Resin</b>	<b>10 + 10</b>	Full post-cure	<b>60</b>	<b>70 °C</b>	<ul style="list-style-type: none"> <li>• Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes.</li> <li>• When washed in IPA with a resin concentration of more than 5%, tackiness has been observed on part surfaces.</li> <li>• When washed in TPM, Tough 1500 Resin remains waxy when printed with a layer thickness of 50 microns or 100 microns, but the waxiness goes away after 3–12 hours.</li> <li>• Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes.</li> </ul>

<sup>1</sup> Recommended post-cure settings achieve close-to-optimal mechanical performance and minimize post-cure time. Full post-cure settings achieve optimal mechanical properties. Use full post-cure settings when using