

## FORM 2 & 3 PRINTER Laser Modeling – Black V2 (MD-R002BK)

### Check:

- UV optical pathways are clean
- Vat is free of defect
- Resin is well shakened

### Open Mode (Form2):

Printer at idle

1. Tap touchscreen “Gear” icon, open “Settings” menu
2. Select Open Mode
3. Select On

### Cartridge (Form2 & 3):

Refill corresponding cartridge e.g. FormLabs Black version 4 cartridge. Open air vent, turn cartridge upside down, drip dry through air vent for 10 mins to avoid cross contamination, refill, shake well for 2 mins, insert & print (may work up to 2 refills before locked by FL software).

**Warning:** Cross contamination of resins could cause size inaccuracy or wavy line.

Other online solution: [Universal Cartridge](#)

### PreForm:

Select Printer: Form 2 or Form 3

Material: **Black V4 (FLGPBK04)**

Layer Thickness Select: 100~25

The screenshot shows the PreForm software interface. At the top, under 'Printer', 'VIRTUAL PRINTER Form 3' is selected. Below, under 'Material', 'Resin' is set to 'Black', 'Version' is 'V4 (FLGPBK04)', and 'Print Setting' is 'Default'. The 'Layer Thickness' section shows a slider between 'Fixed' and 'Adaptive' modes, with a scale from 100 to 25 microns. The 'Fastest Print' to 'Highest Resolution' scale is also visible. At the bottom, there are 'Cancel' and 'Apply' buttons.

### Washing

IPA 95%, maximum for up to 5 minutes, gently shake-off / blow-off excess IPA quickly, set print in a shaded airy place to dry completely before curing.

Extended time in IPA causes deformation. Dried print might be a little tacky to touch.

### Post-curing

For optimal material performance, the condition of FormCure is **60°C / 45 mins**.

### Storage:

- Keep resin away from heat & light.
- NOT accessible to children.
- Filter used resins before storage.

### Note:

- Keep print environment well ventilated.
- Avoid direct contact to skin or eyes. Rinse cautiously with water / soap and water for several minutes if contact to eyes / skin.
- Wear chemically-resistant gloves like nitrile or neoprene (not latex) when handling.
- DO NOT pour uncured resin down the drain. Abandoned resin can be cured by sunlight before discarding.

### **WARNING:**

Contact with uncured resin may cause eye or skin irritation and allergic reaction.