

# Form Cure time and temperature settings

Post-cure printed parts after washing to achieve optimal material properties. Refer to [formlabs.com/cure-support](https://formlabs.com/cure-support) for the most updated information about post-curing printed parts with the Form Cure.

RESIN	POST-CURE SETTING	POST-CURE TIME	POST-CURE TEMPERATURE
Black Resin Color Resin Grey Resin White Resin	Recommended <sup>1</sup>	30 min	60 °C
	Full post-cure	60 min	60 °C
BioMed Amber Resin	Full post-cure <sup>2</sup>	30 min	Form 2: 60 °C Form 3B: 70 °C
BioMed Clear Resin	Full post-cure <sup>2</sup>	60 min	60 °C
Castable Resin	Full post-cure <sup>3</sup>	240 min	60 °C
Castable Wax Resin Castable Wax 40 Resin	N/A <sup>4</sup>	N/A	N/A
Ceramic Resin	N/A <sup>4</sup>	N/A	N/A
Clear Resin	Recommended <sup>1</sup>	15 min	60 °C
	Full post-cure	30 min	60 °C
Custom Tray Resin	Full post-cure <sup>2</sup>	30 min	60 °C
Dental LT Clear Resin V1	Full post-cure <sup>2</sup>	20 min	80 °C
Dental LT Clear Resin V2	Full post-cure <sup>2</sup>	60 min	60 °C
Dental SG Resin	Full post-cure <sup>2</sup>	30 min	60 °C
Denture Teeth Resin Denture Base Resin	Full post-cure <sup>5</sup>	30 min + 30 min	80 °C
Draft Resin	Better elongation	5 min	No heat
	Better UTS	5 min	60 °C

<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 materials for functional applications.

<sup>2</sup> This post-cure setting ensures that parts achieve both biocompatibility and optimum mechanical properties. Read the Instructions for Use for a full description of the workflow.

<sup>3</sup> Cure for 4 hours to increase the part strength. Increasing cure time may improve casting results, particularly for thicker parts, though casting success depends more on part geometry and casting process.

<sup>4</sup> Does not require post-curing. After washing, allow parts to fully dry before firing/casting.

<sup>5</sup> Fill a glass container with glycerin. Preheat the glycerin to 80 °C in the Form Cure. Use heat resistant silicone tongs to fully submerge the assembled denture in the glycerin inside the Form Cure. Cure for 30 minutes. After the first 30 minute post-cure, flip the denture to the opposite side. Post-cure again for 30 minutes.

Durable Resin	Full post-cure <sup>6</sup>	60 min	60 °C
Elastic 50A Resin	Full post-cure	20 min	60 °C
Flexible Resin	Recommended <sup>1</sup>	15 min	60 °C
	Full post-cure	60 min	60 °C
Flexible 80A Resin Soft Tissue Resin	Full post-cure	10 min	60 °C
Grey Pro Resin	Full post-cure <sup>7</sup>	15 min	80 °C
High Temp Resin V1	Recommended <sup>1</sup>	30 min	60 °C
	Full post-cure	60 min	60 °C
High Temp Resin V2	Recommended <sup>8</sup>	120 min	80 °C
IBT Resin	Full post-cure <sup>2</sup>	60 min	60 °C
Model Resin	Recommended <sup>1</sup>	30 min	60 °C
	Full post-cure	60 min	60 °C
Permanent Crown Resin	Full post-cure <sup>9</sup>	20 min + 20 min	60 °C
Rigid 4000 Resin	Full post-cure <sup>7</sup>	15 min	80 °C
Rigid 10K Resin	Recommended <sup>3</sup>	60 min	70 °C
	Thermal post-cure	90 min	125 °C
Surgical Guide Resin	Full post-cure <sup>2</sup>	30 min	Form 2: 60 °C Form 3B: 70 °C
Temporary CB Resin	Full post-cure <sup>9</sup>	20 min + 20 min	60 °C
Tough 2000 Resin	Recommended <sup>1</sup>	60 min	70 °C
Tough Resin V5	Recommended <sup>1</sup>	60 min	60 °C
	Full post-cure	120 min	60 °C
Tough 1500 Resin <sup>10</sup>	Full post-cure	60 min	70 °C

<sup>6</sup> For parts printed with Durable Resin, the tensile modulus increases throughout the first hour of post-curing.

<sup>7</sup> There is no significant gain in properties after 15 minutes. There is only one recommended post-curing time.

<sup>8</sup> There are several post-curing options for High Temp Resin V2 and Rigid 10K Resin. Refer to the technical data sheet to understand how different options affect mechanical properties, and choose the post-cure option that is best suited to the intended application.

<sup>9</sup> This cure setting ensures that parts achieve both biocompatibility and optimum mechanical properties. Remove supports and sandblast between post-curing cycles.

<sup>10</sup> If parts printed with Tough 1500 Resin will be used for skin contact use, parts must be post-cured in a Form Cure at 70°C for 60 minutes.

