

Form Cure L V1 time and temperature settings

Post-cure printed parts after washing to achieve optimal material properties. Refer to support.formlabs.com/s/article/Form-Cure-L-time-and-temperature-settings for the most updated information about post-curing printed parts with the Form Cure L V1.

RESIN	POST-CURE SETTING	POST-CURE TIME	POST-CURE TEMPERATURE
Alumina 4N Resin	N/A ⁴	N/A	N/A
Black Resin V4/V4.1 Color Kit Grey Resin V4/V4.1 White Resin V4/V4.1	Recommended ¹	30 min	60 °C
	Full post-cure	60 min	60 °C
Black Resin V5 Clear Resin V5 Grey Resin V5 White Resin V5	Default ¹	5 min	No heat
	Enhanced mechanical properties	15 min	60 °C
BEGO™ VarseoSmile® TriniQ® Resin	Full post-cure ²	Refer to the Instructions for Use for washing and post-curing instructions for this resin. Enter the item number (REF) from the resin cartridge label to access the IFU.	
BioMed Amber Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
BioMed Black Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
BioMed Clear Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
BioMed Durable Resin V1 BioMed Durable Resin V1.1	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
BioMed Flex 50A Resin (formerly BioMed Elastic 50A Resin)	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
BioMed Flex 80A Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
BioMed White Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and	

¹ 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.

² This post-cure setting ensures that parts achieve both biocompatibility and optimum mechanical properties. Read the Manufacturing Guide for a full description of the workflow.

		post-curing instructions for this resin.	
Castable Resin	Full post-cure ³	240 min	60 °C
Castable Wax Resin Castable Wax 40 Resin	N/A ⁴	N/A	N/A
Ceramic Resin	N/A ⁴	N/A	N/A
Clear Cast Resin	Recommended ¹	15 min	60 °C
	Full post-cure	30 min	60 °C
Clear Resin V4/V4.1	Recommended ¹	15 min	60 °C
	Full post-cure	30 min	60 °C
Color Resin V5	Full post-cure	5 min	N/A
Custom Tray Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
Dental LT Clear Resin V1	Full post-cure ²	20 min	80 °C
Dental LT Clear Resin V2	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
Dental LT Comfort Resin V1 Dental LT Comfort Resin V1.1	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
Denture Base Resin V1	Full post-cure ²	Refer to the Instructions for Use for washing and post-curing instructions for this resin.	
Denture Base Resin V2	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
Denture Teeth Resin	Full post-cure ²	Refer to the Instructions for Use for washing and post-curing instructions for this resin.	
Draft Resin	Better elongation	5 min	No heat
	Better UTS	5 min	60 °C
Durable Resin V2 Durable Resin V2.1	Full post-cure ⁵	60 min	60 °C
Elastic 50A Resin V1	Full post-cure	20 min	60 °C

³ 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.

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

⁵ For parts printed with Durable Resin, the tensile modulus increases throughout the first hour of post-curing.

Flexible 50A Resin (formerly Elastic 50A Resin V2)	Full post-cure ⁶	30 min	70 °C
ESD Resin	Full post-cure	60 min	70 °C
Fast Model Resin	Default ¹	5 min	No heat
	Enhanced mechanical properties	15 min	60 °C
Flame Retardant Resin	Better toughness	60 min	70 °C
	Better HDT	120 min	80 °C
Flexible Resin	Recommended ¹	15 min	60 °C
	Full post-cure	60 min	60 °C
Flexible 80A Resin V1 Flexible 80A Resin V1.1 Soft Tissue Resin	Full post-cure	10 min	60 °C
Flexible 80A Resin V2	Default	Cycle 1 ⁶ : 5 min Cycle 2: 30 min	Cycle 1 ⁶ : No heat Cycle 2: 70 °C
Grey Pro Resin	Full post-cure ⁷	15 min	80 °C
High Temp Resin V1	Recommended ¹	30 min	60 °C
	Full post-cure	60 min	60 °C
High Temp Resin V2	Recommended ⁸	120 min	80 °C
	Thermal post-cure	180 min	160 °C
IBT Flex Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
IBT Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
Model Resin V2	Recommended ¹	30 min	60 °C
	Full post-cure	60 min	60 °C
Model Resin V3	Full post-cure	5 min	60 °C

⁶ Post-cure parts completely submerged in room temperature water in a glass beaker (or other UV-transparent container).

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

⁸ 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.

Permanent Crown Resin	Full post-cure ²	Refer to the Instructions for Use [EN] [EU] for washing and post-curing instructions for this resin.	
Precision Model Resin	Full post-cure	5 min	35 °C
Premium Teeth Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
Rigid 4000 Resin	Full post-cure	15 min	80 °C
Rigid 10K Resin V1 Rigid 10K Resin V1.1	Recommended ⁷	60 min	70 °C
	Thermal post-cure	125 min	90 °C
Silicone 40A Resin	Full post-cure ⁶	15 min preheat 45 min post-cure	60 °C 60 °C
Surgical Guide Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
Temporary CB Resin	Full post-cure ²	Refer to the Instructions for Use for washing and post-curing instructions for this resin.	
Tough 1000 Resin	Recommended	60 min	70 °C
Tough 2000 Resin V1 Tough 2000 Resin V1.1 Tough 2000 Resin V2	Recommended	60 min	70 °C
Tough Resin V5	Recommended ¹	60 min	60 °C
	Full post-cure	120 min	60 °C
Tough 1500 Resin V1 Tough 1500 Resin V1.1 Tough 1500 Resin V2	Full post-cure ⁹	60 min	70 °C
True Cast Resin V1	Full post-cure	10 min	N/A

⁹ If parts printed with Tough 1500 Resin will be used for skin contact use, parts must be post-cured in a Form Cure L at 70 °C for 60 minutes.