

Form Wash and Form Wash L time settings

Wash printed parts before post-curing to remove liquid resin from part surfaces. These settings indicate the recommended time to wash parts printed in Formlabs resins using the Form Wash or Form Wash L and isopropyl alcohol (IPA), tripropylene glycol monomethyl ether (TPM), or Formlabs Resin Washing Solution.

For a wash bucket with highly resin-concentrated solvent, add an additional 5 minutes to the wash time. The lifetime of the solvent bath can be prolonged with a revised workflow. Consider rinsing parts with a small volume of solvent before inserting printed parts in the Form Wash or Form Wash L. Preliminary rinsing removes most liquid resin and keeps the solvent in the wash bucket cleaner.

RESIN	WASH TIME	NOTES
Alumina 4N Resin	2 min	<ul style="list-style-type: none">• Only wash Alumina 4N Resin in the Ceramic Wash Solution. Do not allow Alumina 4N Resin parts to come into contact with water or IPA, as this will cause cracking.• Use a separate wash bucket to prevent loose ceramic particles from adhering to non-Ceramic parts.• Formlabs does not recommend using Resin Washing Solution to wash parts printed in this resin.
BEGO™ VarseoSmile® TriniQ® Resin		To ensure that finished parts are biocompatible, follow all part washing notes in the Instructions for Use . Enter the item number (REF) from the resin cartridge label to access the IFU. Maintain separate wash buckets for resins for biocompatible applications.
BioMed Amber Resin		To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide . Maintain separate wash buckets for resins for biocompatible applications.
BioMed Black Resin		To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide . Maintain separate wash buckets for resins for biocompatible applications.
BioMed Clear Resin		To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide . Maintain separate wash buckets for resins for biocompatible applications.
BioMed Durable Resin V1 BioMed Durable Resin V1.1		To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide . Maintain separate wash buckets for resins for biocompatible applications.
BioMed Flex 50A Resin (formerly BioMed Elastic 50A Resin)		To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide . Maintain separate wash buckets for resins for biocompatible applications.
BioMed Flex 80A Resin		To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide . Maintain separate wash buckets for resins for biocompatible applications.
BioMed White Resin		To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide . Maintain separate wash buckets for resins for biocompatible applications.

RESIN	WASH TIME	NOTES
Black Resin V4/V4.1 Clear Resin V4/V4.1 Color Kit Grey Resin V4/V4.1 White Resin V4/V4.1	10 min	<ul style="list-style-type: none"> 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.
Black Resin V5 Clear Resin V5 Grey Resin V5 White Resin V5 Color Resin V5	5 min	
Castable Resin	10 min	<ul style="list-style-type: none"> Maintain separate wash buckets to avoid color transfer. Wash Castable Resin for the shortest time necessary. 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.
Castable Wax Resin	5 min	<ul style="list-style-type: none"> Maintain separate wash buckets to avoid color transfer. Wash for 5 minutes, then remove parts and rinse in fresh IPA. Wash Castable Wax Resin for the shortest time necessary. 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. Formlabs does not recommend using Resin Washing Solution to wash parts printed in this resin.
Castable Wax 40 Resin	5 min	<ul style="list-style-type: none"> Maintain separate wash buckets to avoid color transfer. Wash for 5 minutes, then remove parts and rinse in fresh IPA. Wash Castable Wax Resin for the shortest time necessary.
Ceramic Resin	5 min	<ul style="list-style-type: none"> Maintain separate wash buckets to prevent ceramic particles adhering to parts printed with other resins.
Clear Cast Resin	10 min	<ul style="list-style-type: none"> 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.
Custom Tray Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide . Maintain separate wash buckets for resins for biocompatible applications.	
Dental LT Clear Resin V1	20 min	<ul style="list-style-type: none"> Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations. Maintain separate wash buckets for biocompatible materials. 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.

RESIN	WASH TIME	NOTES
Dental LT Clear Resin V2		To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide . Maintain separate wash buckets for resins for biocompatible applications.
Dental LT Comfort Resin V1 Dental LT Comfort Resin V1.1		To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide . Maintain separate wash buckets for resins for biocompatible applications.
Denture Base Resin		To ensure that finished parts are biocompatible, follow all part washing notes in the Instructions for Use . Maintain separate wash buckets for resins for biocompatible applications.
Denture Teeth Resin		To ensure that finished parts are biocompatible, follow all part washing notes in the Instructions for Use . Maintain separate wash buckets for resins for biocompatible applications.
Draft Resin	10 min	<ul style="list-style-type: none"> Tackiness has been observed on part surfaces when washed in alcohol with more than 5% resin concentration. Avoid washing Draft Resin for longer than the recommended time.
Durable Resin V2 Durable Resin V2.1	20 min	<ul style="list-style-type: none"> When washed in IPA with a resin concentration of more than 10%, tackiness has been observed on part surfaces. Do not leave Durable Resin in solvent for longer than 20 minutes total, as excessive solvent exposure affects the quality of the final part.
Elastic 50A Resin V1	10 min + 10 min	<ul style="list-style-type: none"> Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes. 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. Formlabs does not recommend using Resin Washing Solution to wash parts printed in this resin.
Flexible 50A Resin (formerly Elastic 50A Resin V2)	20 min	<ul style="list-style-type: none"> Wash parts for 20 minutes or until clean. Formlabs does not recommend using Resin Washing Solution to wash parts printed in this resin.
ESD Resin	20 min	<ul style="list-style-type: none"> Use a separate wash bucket to prevent ESD Resin from transferring to other parts.
Fast Model Resin	5 min	
Flame Retardant Resin	10 min (IPA) 15 min (TPM)	<ul style="list-style-type: none"> Small negative features may be difficult to fully clean due to the resin's high viscosity. Make sure to clean your parts thoroughly before post-curing. Consider using pressurized air for better cleaning. Formlabs does not recommend using Resin Washing Solution to wash parts printed in this resin.
Flexible 80A Resin V1	10 min + 10 min	<ul style="list-style-type: none"> Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes.

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Flexible 80A Resin V1.1 Flexible Resin V2 Soft Tissue Resin		<ul style="list-style-type: none"> 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. Formlabs does not recommend using Resin Washing Solution to wash parts printed in this resin.
Flexible 80A Resin V2	5 min + 5 min	<ul style="list-style-type: none"> Wash for 5 minutes, then remove parts and soak in fresh solvent for 5 minutes. Formlabs does not recommend using Resin Washing Solution to wash parts printed in this resin.
Grey Pro Resin	15 min	<ul style="list-style-type: none"> When washed in TPM, Grey Pro Resin comes out of the wash clean and free of waxiness.
High Temp Resin	5 min	<ul style="list-style-type: none"> 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.
IBT Flex Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide . Maintain separate wash buckets for resins for biocompatible applications.	
IBT Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide . Maintain separate wash buckets for resins for biocompatible applications.	
Model Resin	10 min	<ul style="list-style-type: none"> When washed in IPA with a resin concentration of more than 10%, tackiness has been observed on part surfaces. 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 3–12 hours.
Permanent Crown Resin	<ul style="list-style-type: none"> To ensure that finished parts are biocompatible, follow all part washing notes in the Instructions for Use [EN] [EU]. Maintain separate wash buckets for resins for biocompatible applications. 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. 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. 	
Precision Model Resin	5 min	
Premium Teeth Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide . Maintain separate wash buckets for resins for biocompatible applications.	
PU Rigid 650 Resin PU Rigid 1000 Resin	2 min	<ul style="list-style-type: none"> Wash parts printed with polyurethane resins in Propylene glycol diacetate (PGDA). Polyurethane resins should not be washed with isopropyl alcohol (IPA), which can react with the printed parts and cause degradation in material properties.

RESIN	WASH TIME	NOTES
		<ul style="list-style-type: none"> Parts can be dipped in an n-Butyl acetate bath for no more than 15 seconds to speed up the evaporation of PGDA. Formlabs does not recommend using Resin Washing Solution to wash parts printed in this resin.
Rigid 4000 Resin	15 min	<ul style="list-style-type: none"> Maintain separate wash buckets to prevent glass particles adhering to parts printed with other resins. When washed in TPM, Rigid Resin comes out of the wash clean and free of waxiness.
Rigid 10K Resin V1 Rigid 10K Resin V1.1	10 min + 10 min	<ul style="list-style-type: none"> Maintain separate wash buckets to prevent glass particles adhering to parts printed with other resins. When washed in TPM, Rigid 10K Resin comes out of the wash clean and free of waxiness.
Silicone 40A Resin	20 min	<ul style="list-style-type: none"> Follow the instructions in the Silicone 40A Resin IPA sonication wash guide for best results with washing parts printed in Silicone 40A Resin. Alternatively, wash parts printed with Silicone 40A Resin in an 80/20 mixture of isopropyl alcohol (IPA) and n-butyl acetate. Do not wash with IPA alone unless following the instructions in the Silicone 40A Resin IPA sonication wash guide. Only use Formlabs-approved solvents with the Form Wash. Only use n-Butyl Acetate/IPA mixture in an unused Form Wash bucket that has not been exposed to other solvents. Once a Form Wash bucket has been used with n-Butyl Acetate, do not switch to pure IPA. Doing so risks compromising the integrity of the bucket plastic. If you notice cracking or crazing on your Form Wash bucket, discontinue use immediately, empty of solvent, and contact Formlabs. Formlabs does not recommend using Resin Washing Solution to wash parts printed in this resin.
Surgical Guide Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide . Maintain separate wash buckets for resins for biocompatible applications.	
Temporary CB Resin	<ul style="list-style-type: none"> To ensure that finished parts are biocompatible, follow all part washing notes in the Instructions for Use. Maintain separate wash buckets for resins for biocompatible applications. Do not leave Temporary CB Resin in IPA for longer than 3 minutes, as excessive solvent exposure affects the quality of the final part. 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. 	
Tough 1000 Resin	10 min + 10 min	<ul style="list-style-type: none"> Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes.

RESIN	WASH TIME	NOTES
		<ul style="list-style-type: none"> For best surface finish, Formlabs recommends allowing parts printed in Tough 1000 Resin to air dry for at least 30 minutes prior to handling or post-curing. You can also use compressed air to speed up the drying process. Formlabs does not recommend using Resin Washing Solution to wash parts printed in this resin.
Tough 1500 Resin V1 Tough 1500 Resin V1.1	10 min + 10 min	<ul style="list-style-type: none"> When washed in IPA with a resin concentration of more than 5%, tackiness has been observed on part surfaces. 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. Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes. If parts printed with Tough 1500 Resin will be used for skin contact use, wash parts in ≥99% IPA in a Form Wash for 20 minutes to comply with biocompatibility requirements.
Tough 1500 Resin V2	10 min	<ul style="list-style-type: none"> Formlabs does not recommend using Resin Washing Solution to wash parts printed in this resin.
Tough 2000 Resin V1 Tough 2000 Resin V1.1 Tough Resin V5	10 min + 10 min	<ul style="list-style-type: none"> When washed in IPA with a resin concentration of more than 5%, tackiness has been observed on part surfaces. When washed in TPM, Tough 2000 Resin and Tough Resin V5 come out of the wash clean and free of waxiness. Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes.
Tough 2000 Resin V2	15 min	<ul style="list-style-type: none"> For best surface finish, Formlabs recommends allowing parts printed in Tough 2000 Resin V2 to air dry for at least 10 minutes prior to handling or post-curing. You can also use compressed air to speed up the drying process. Formlabs does not recommend using Resin Washing Solution to wash parts printed in this resin.
True Cast Resin V1	5 min	<ul style="list-style-type: none"> Wash with IPA or ≥91% ethyl alcohol, then spray with fresh solvent after the wash cycle. Dry with compressed air.