

FORM 2 & 3 PRINTER Modeling – Gray (MD-R001GY)

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 Grey 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: **Grey V4 (FLGPR04)**

Suggest Layer Thickness 100~25

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.

The screenshot shows the 'JOB SETUP' window in the PreForm software. It includes a 'Printer' dropdown set to 'VIRTUAL PRINTER Form 3'. Under 'Material', 'Resin' is set to 'Grey', 'Version' is 'V4 (FLGPR04)', and 'Print Setting' is 'Default'. The 'Layer Thickness' is shown as a slider between 'Fastest Print' (160 microns) and 'Highest Resolution' (25 microns), with the current value set at 50 microns. 'Cancel' and 'Apply' buttons are at the bottom.