

Form Cure (2nd Generation) time and temperature settings

Post-cure printed parts after washing to achieve optimal material properties. Refer to formlabs.com/cure-support for the most updated information about post-curing printed parts with the Form Cure (2nd Generation).

RESIN	POST-CURE SETTING	POST-CURE TIME	POST-CURE TEMPERATURE
Alumina 4N Resin	N/A ¹	N/A	N/A
BEGO™ VarseoSmile® TriniQ® Resin	Full post-cure ²	Refer to the Compatibility Overview for washing and post-curing instructions for this resin. View the PDF at the attached link.	
BioMed Amber	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 Elastic 50A Resin ¹¹	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
BioMed Flex 80A Resin ¹¹	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 post-curing instructions for this resin.	
Black Resin V4/V4.1	Default	10 min	60 °C
Black Resin V5	Default	1 min	No heat
Castable Wax Resin Castable Wax 40 Resin	N/A ³	N/A	N/A
Ceramic Resin	N/A ¹	N/A	N/A
Clear Resin V4	Default	5 min	60 °C

¹ Does not require post-curing. After washing, allow parts to fully dry before firing/casting.

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.

³ Does not require post-curing. Allow parts to fully dry before casting.

Clear Resin V4.1	Default	7 min	60 °C
Clear Resin V5	Default	1 min	No heat
Color Resin	Default	10 min	60 °C
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 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	Full post-cure ²	Refer to the Instructions for Use 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 V2	Better elongation	5 min	No heat
	Better UTS	5 min	60 °C
Durable Resin V2 Durable Resin V2.1	Full post-cure ⁴	12 min	60 °C
Elastic 50A Resin V2	Full post-cure ⁵	7 min	70 °C
ESD Resin	Default	10 min	70 °C
Fast Model Resin	Default	1 min	No heat
Flame Retardant Resin	Default	5 min preheat 10 min post-cure	100 °C
Flexible 80A Resin V1 Flexible 80A Resin V1.1	Default	3 min	60 °C
Grey Resin V4 Grey Resin V4.1	Default	10 min	60 °C
Grey Resin V5	Default	1 min	No heat
Grey Pro Resin	Default	8 min	80 °C
High Temp Resin V2	Default	15 min	80 °C
IBT Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	

⁴ For parts printed with Durable Resin, the tensile modulus increases throughout the first hour of post-curing.

⁵ Place dry parts in a glass beaker (or other UV-transparent container) and completely submerge the parts in room temperature water.

IBT Flex Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
Model Resin V2	Default	10 min	60 °C
Model Resin V3	Default	2 min	60 °C
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	Default	1 min	No heat
Premium Teeth Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
PU Rigid 650 Resin	N/A	Refer to the support article Using PU Rigid 650 Resin .	
PU Rigid 1000 Resin	N/A	Refer to the support article Using PU Rigid 1000 Resin .	
Rigid 4000 Resin	Default	6 min	80 °C
Rigid 10K Resin V1 Rigid 10K Resin V1.1	Default	3 min preheat 7 min post-cure	80 °C
Silicone 40A Resin	Default	10 min	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 1500 Resin V1 Tough 1500 Resin V1.1	Low warp	12 min	No heat
Tough 2000 Resin V1 Tough 2000 Resin V1.1	Low warp	7 min	No heat
White Resin V4 White Resin V4.1	Default	10 min	60 °C
White Resin V5	Default	1 min	No heat