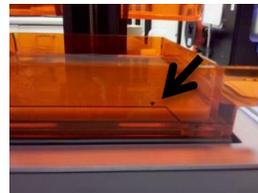
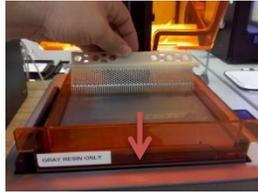


# HOW TO USE THE FORM 1+ RESIN PRINTER

## Prepare resin tank...

1. If resin tank is not already loaded, clean bottom of tank with a soft cloth, then slide tank forward into printer until it clicks into place. **Do not touch bottom of tank.**
2. Remove resin tank's black cover (**important**).
3. Inspect liquid in tank. If you see particles, use comb to sift and remove stray resin pieces.
4. If resin is stuck to tank's floor, do **not** use scraper to remove! Use gloved fingers to slightly push/flex tank floor, then slide & remove hardened resin with fingers.
5. Check tank fill level. If more resin is needed, gently shake bottle, then fill tank to fill line.
  - a. **Do not fill past fill line! It will damage the printer**
  - b. Do not mix resin colors/types
6. Close orange lid when finished; never leave it open.



## Load object in program...

1. Open PreForm program by clicking icon on desktop.
2. Load your object's STL file via "File > Open" on menu.
3. Click [Orientation] then [Orient all] to rotate object to an optimal printing angle. Diagonal orientation is normal.
4. Click [Supports] then [Generate] to create support structures to hold object in-place while printing.
5. Click [Layout] on ribbon, then [Layout all] to arrange object onto build platform.



## Start printing...

1. Ensure build platform is mounted and has a clean build surface.
2. Remove black lid from resin tank.
3. Turn on printer.



4. On computer, click orange "butterfly" icon, then choose "Print Material" to select resin color and type that you are using.
5. Click [Send to Printer].
6. When the printer displays "Build platform? Tank and resin?" press power button to start printing.



## While printing...

1. Your part will print upside down; the build platform will slowly lift from the resin tank.
2. Check printing process every 15-20 minutes. **Do not print overnight or when no one is in the room.**
3. If pieces of your object falls into the resin tank, hold-down power button for five seconds to cancel printing.



## After printing...

1. Wear safety rubber gloves.
2. Open orange cover, lift lever on build platform, then pull platform forward to remove.
3. Close lever on build platform, place upside-down on cleanup tray.
4. Replace black lid on resin tank, close orange cover.
5. **Carefully** remove object with metal scraper. Keep your other hand safely away from the scraper!
6. Place object in rinsing bin on the right, then gently agitate up and down on black rinsing rack for two minutes.
7. Move object to left-side rinsing bin, soak for 10 minutes (use timer). Remove object, tightly cover both rinsing bins.
8. Use side-snips to remove unwanted supports from your object. If sticky or rubbery, expose object to sunlight for several hours to harden.

