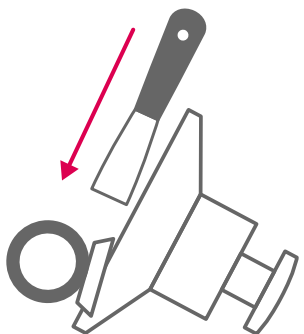


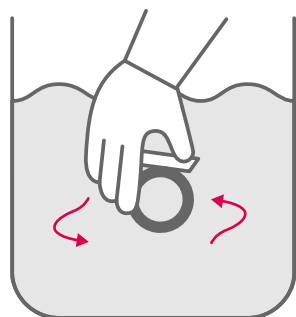


## STEP 1



Remove your prints from the building plate.

## STEP 2

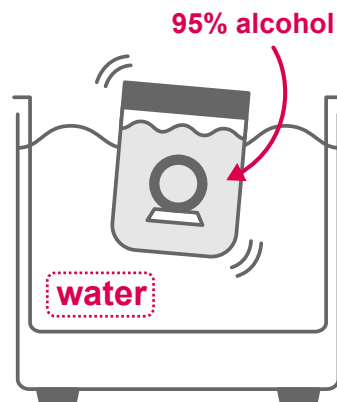


95% alcohol

Rinse your prints in a container of 95% alcohol.

optional

## STEP 3



30 sec

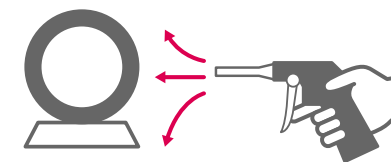
Submerge your prints in a glass jar of 95% alcohol, then put the jar on the Phrozen Ultrasonic Cleaner for 30s. DO NOT submerge prints in alcohol for more than 30s.

## STEP 4



Repeat step 2-3 for better cleaning, if needed.

## STEP 5



Dry your prints with a compressed air gun. Be careful with the fine features. Your print should have a matte finish at the end. Repeat step 2-5 if needed.

\*This step is optional. Please skip it if you want to speed up the process.

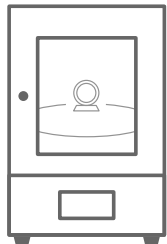
# Post-Curing your 3D print



Please wear gloves for safety purposes

optional

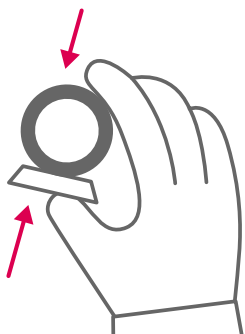
## STEP 1



30 min

Post-cure your prints with a Phrozen Post-Curing device for at least 30 minutes.

## STEP 2



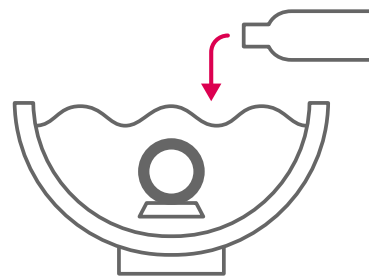
After curing, gently press your prints from various directions to check if they are fully cured. Extend the post-curing time if needed.

## STEP 1



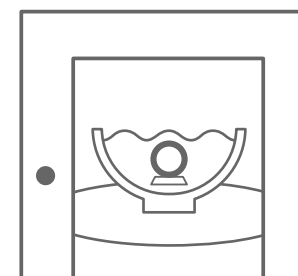
Place your prints in a glass bowl.

## STEP 2



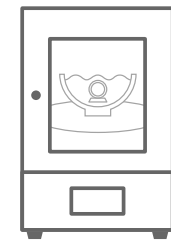
Fill the glass bowl with glycerin until your prints are fully submerged.

## STEP 3



Place the glass bowl in a Phrozen Post-Curing device.

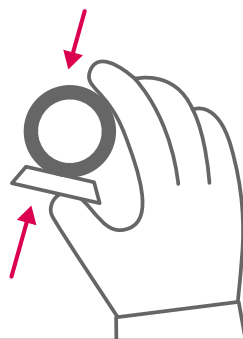
## STEP 4



30 min

Cure your prints for at least 30 minutes.

## STEP 5



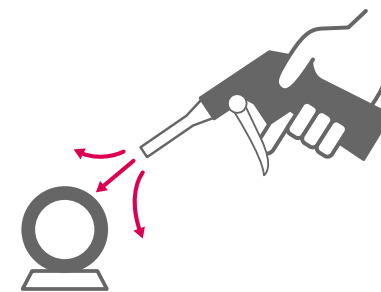
After curing, gently press your prints from various directions to check if they are fully cured. Extend the post-curing time if needed.

## STEP 6



Wash your prints in water to remove the glycerin.

## STEP 7



Use a compressed air gun to dry your prints.

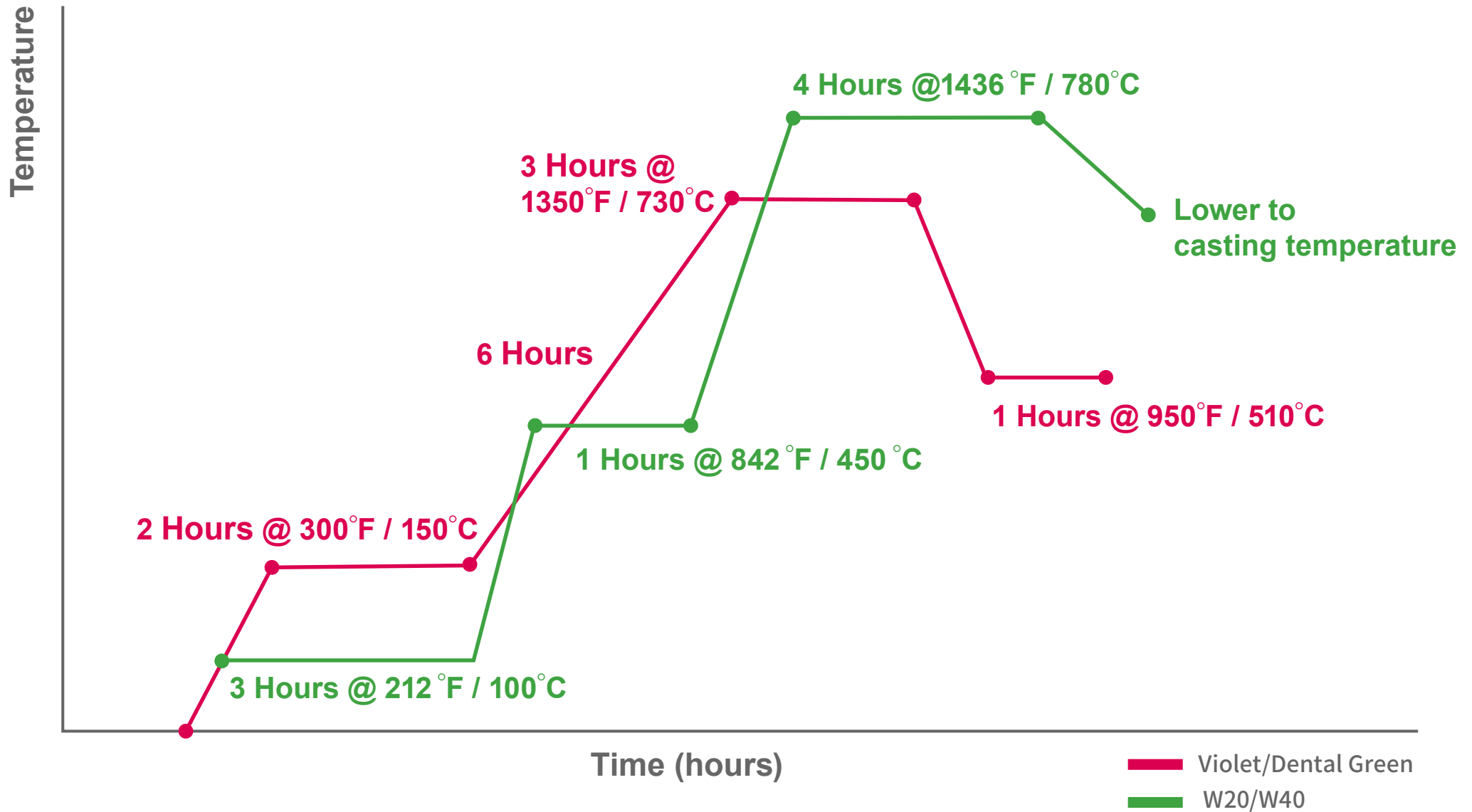
## STEP 8



Your prints should be ready for casting when they are completely dry.

※These steps are optional. Please skip it if you want to speed up the process.

# Recommended Burnout Schedules



\*All ramp rates are set at 28°F / 2°C per minute

\*Exact schedule may vary slightly based on casting equipment used.