

Form Cure 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.

RESIN	POST-CURE SETTING	POST-CURE TIME	POST-CURE TEMPERATURE
Alumina 4N Resin	N/A ⁴	N/A	N/A
Black Resin V4 Color Resin	Recommended ¹	30 min	60 °C
Grey Resin V4 White Resin V4	Full post-cure	60 min	60 °C
Black Resin V5 Clear Resin V5	Default ¹	5 min	No heat
Grey Resin V5 White Resin V5	Enhanced mechanical properties	15 min	60 °C
BioMed Amber Resin	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.	
Castable Resin	Full post-cure ³	240 min	60 °C
Castable Wax Resin Castable Wax 40 Resin	N/A ⁴	N/A	N/A

¹ Recommended post-cure settings achieve close-to-optimal mechanical performance and minimize post-cure time. Full post-cure settings achieve optimal mechanical properties. Use full post-cure settings when using materials for functional applications.

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 Cure for 4 hours to increase the part strength. Increasing cure time may improve casting results, particularly for thicker parts, though casting success depends more on part geometry and casting process.

⁴ Does not require post-curing. After washing, allow parts to fully dry before firing/casting.

Ceramic Resin	N/A ⁴	N/A	N/A
Clear Resin	Recommended ¹	15 min	60 °C
	Full post-cure	30 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 V1	Full post-cure ²	20 min	80 °C
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 ⁵	Refer to the Instructions for Use for washing and post-curing instructions for this resin.	
Denture Teeth Resin	Full post-cure ⁶	Refer to the Instructions for Use for washing and post-curing instructions for this resin.	
Draft Resin	Better elongation	5 min	No heat
	Better UTS	5 min	60 °C
Durable Resin V2 Durable Resin V2.1	Full post-cure ⁷	60 min	60 °C
Elastic 50A Resin V1	Full post-cure	20 min	60 °C
Elastic 50A Resin V2	Full post-cure ¹¹	10 min preheat 30 min post-cure	70 °C 70 °C
ESD Resin	Full post-cure	60 min	70 °C
Fast Model Resin	Default ¹	5 min	No heat
	Enhanced mechanical properties	15 min	60 °C
Flame Retardant Resin	Better toughness	60 min	70 °C
	Better HDT	120 min	80 °C
Flexible Resin	Recommended ¹	15 min	60 °C
	Full post-cure	60 min	60 °C

⁵ This post-cure setting ensures that parts achieve both biocompatibility and optimum mechanical properties. Read the Instructions for Use for a full description of the workflow.

⁶ This post-cure setting ensures that parts achieve both biocompatibility and optimum mechanical properties. Read the Instructions for Use for a full description of the workflow.

⁷ For parts printed with Durable Resin, the tensile modulus increases throughout the first hour of post-curing.

Flexible 80A Resin V1 Flexible 80A Resin V1.1 Soft Tissue Resin	Full post-cure	10 min	60 °C
Grey Pro Resin	Full post-cure ⁸	15 min	80 °C
High Temp Resin V1	Recommended ¹	30 min	60 °C
	Full post-cure	60 min	60 °C
High Temp Resin V2	Recommended ⁹	120 min	80 °C
	Thermal post-cure	180 min	160 °C
IBT Flex Resin ¹¹	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
IBT Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
Model Resin V2	Recommended ¹	30 min	60 °C
	Full post-cure	60 min	60 °C
Model Resin V3	Full post-cure	5 min	60 °C
Permanent Crown Resin	Full post-cure ⁹	Refer to the Instructions for Use [EN] [EU] for washing and post-curing instructions for this resin.	
Precision Model Resin	Full post-cure	5 min	35 °C
Premium Teeth Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	
Rigid 4000 Resin	Full post-cure ⁷	15 min	80 °C
Rigid 10K Resin V1 Rigid 10K Resin V1.1	Recommended ⁸	60 min	70 °C
	Thermal post-cure	125 min	90 °C
Silicone 40A Resin ¹¹	Full post-cure	45 min	60 °C
Surgical Guide Resin	Full post-cure ²	Refer to the Manufacturing Guide for washing and post-curing instructions for this resin.	

⁸ There is no significant gain in properties after 15 minutes. There is only one recommended post-curing time.

⁹ There are several post-curing options for High Temp Resin V2 and Rigid 10K Resin. Refer to the technical data sheet to understand how different options affect mechanical properties, and choose the post-cure option that is best suited to the intended application.

Temporary CB Resin	Full post-cure ¹⁰	Refer to the Instructions for Use for washing and post-curing instructions for this resin.	
Tough 2000 Resin	Recommended ¹	60 min	70 °C
Tough Resin V5	Recommended ¹	60 min	60 °C
	Full post-cure	120 min	60 °C
Tough 1500 Resin V1 ¹⁰ Tough 1500 Resin V1.1 ¹⁰	Full post-cure	60 min	70 °C

¹⁰ This cure setting ensures that parts achieve both biocompatibility and optimum mechanical properties. Remove supports and sandblast between post-curing cycles. Read the Manufacturing Guide for a full description of the workflow.

¹⁰ If parts printed with Tough 1500 Resin will be used for skin contact use, parts must be post-cured in a Form Cure at 70°C for 60 minutes.

¹¹ This cure setting ensures that parts achieve both biocompatibility and optimum mechanical properties. Read the Manufacturing Guide for a full description of the workflow.