

# 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](https://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 <sup>1</sup>	N/A	N/A
BEGO™ VarseoSmile® TriniQ® Resin	Full post-cure <sup>2</sup>	Refer to the <a href="#">Compatibility Overview</a> for washing and post-curing instructions for this resin. View the PDF at the attached link.	
BioMed Amber	Full post-cure <sup>2</sup>	Refer to the <a href="#">Manufacturing Guide</a> for washing and post-curing instructions for this resin.	
BioMed Black Resin	Full post-cure <sup>2</sup>	Refer to the <a href="#">Manufacturing Guide</a> for washing and post-curing instructions for this resin.	
BioMed Clear Resin	Full post-cure <sup>2</sup>	Refer to the <a href="#">Manufacturing Guide</a> for washing and post-curing instructions for this resin.	
BioMed Durable Resin V1 BioMed Durable Resin V1.1	Full post-cure <sup>2</sup>	Refer to the <a href="#">Manufacturing Guide</a> for washing and post-curing instructions for this resin.	
BioMed Elastic 50A Resin <sup>11</sup>	Full post-cure <sup>2</sup>	Refer to the <a href="#">Manufacturing Guide</a> for washing and post-curing instructions for this resin.	
BioMed Flex 80A Resin <sup>11</sup>	Full post-cure <sup>2</sup>	Refer to the <a href="#">Manufacturing Guide</a> for washing and post-curing instructions for this resin.	
BioMed White Resin	Full post-cure <sup>2</sup>	Refer to the <a href="#">Manufacturing Guide</a> 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 <sup>3</sup>	N/A	N/A
Ceramic Resin	N/A <sup>1</sup>	N/A	N/A
Clear Resin V4	Default	5 min	60 °C

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

<sup>2</sup> 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.

<sup>3</sup> 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 <sup>2</sup>	Refer to the <a href="#">Manufacturing Guide</a> for washing and post-curing instructions for this resin.	
Dental LT Clear Resin V2	Full post-cure <sup>2</sup>	Refer to the <a href="#">Manufacturing Guide</a> for washing and post-curing instructions for this resin.	
Dental LT Comfort Resin V1 Dental LT Comfort Resin V1.1	Full post-cure <sup>2</sup>	Refer to the <a href="#">Manufacturing Guide</a> for washing and post-curing instructions for this resin.	
Denture Base Resin	Full post-cure <sup>2</sup>	Refer to the <a href="#">Instructions for Use</a> for washing and post-curing instructions for this resin.	
Denture Teeth Resin	Full post-cure <sup>2</sup>	Refer to the <a href="#">Instructions for Use</a> 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 <sup>4</sup>	12 min	60 °C
Elastic 50A Resin V2	Full post-cure <sup>5</sup>	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 <sup>2</sup>	Refer to the <a href="#">Manufacturing Guide</a> for washing and post-curing instructions for this resin.	

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

<sup>5</sup> 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 <sup>2</sup>	Refer to the <a href="#">Manufacturing Guide</a> 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 <sup>2</sup>	Refer to the Instructions for Use <a href="#">[EN]</a> <a href="#">[EU]</a> for washing and post-curing instructions for this resin.	
Precision Model Resin	Default	1 min	No heat
Premium Teeth Resin	Full post-cure <sup>2</sup>	Refer to the <a href="#">Manufacturing Guide</a> for washing and post-curing instructions for this resin.	
PU Rigid 650 Resin	N/A	Refer to the support article <a href="#">Using PU Rigid 650 Resin</a> .	
PU Rigid 1000 Resin	N/A	Refer to the support article <a href="#">Using PU Rigid 1000 Resin</a> .	
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 <sup>2</sup>	Refer to the <a href="#">Manufacturing Guide</a> for washing and post-curing instructions for this resin.	
Temporary CB Resin	Full post-cure <sup>2</sup>	Refer to the <a href="#">Instructions for Use</a> for washing and post-curing instructions for this resin.	
Tough 1500 Resin V1 Tough 1500 Resin V1.1 Tough 1500 Resin V2	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