

Form Wash and Form Wash L time settings

Wash printed parts before post-curing to remove liquid resin from part surfaces. These settings indicate the recommended time to wash parts printed in Formlabs resins using the Form Wash or Form Wash L and isopropyl alcohol (IPA) or tripropylene glycol monomethyl ether (TPM).

For a wash bucket with highly resin-concentrated solvent, add an additional 5 minutes to the wash time. The lifetime of the solvent bath can be prolonged with a revised workflow. Consider rinsing parts with a small volume of solvent before inserting printed parts in the Form Wash or Form Wash L. Preliminary rinsing removes most liquid resin and keeps the solvent in the wash bucket cleaner.

RESIN	WASH TIME	NOTES
BioMed Amber Resin	Form Wash: 20 min Form Wash L: 5 min or until clean	- Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations. - Maintain separate wash buckets for biocompatible materials.
BioMed Clear Resin	15 min + 5 min	- Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations. - Maintain separate wash buckets for biocompatible materials. - Wash for 15 minutes then remove parts and soak in fresh IPA for 5 minutes.
Black Resin Clear Resin Color Resin Grey Resin White Resin	10 min	When washed in TPM, standard resins remain waxy when printed with a layer thickness of 50 microns or 100 microns. Post-curing removes waxiness. Without post-curing, waxiness goes away after about a week.
Castable Resin	10 min	- Maintain separate wash buckets to avoid color transfer. - Wash Castable Resin for the shortest time necessary. - When washed in TPM, Castable Resin remains waxy when printed with a layer thickness of 50 microns or 100 microns, but the waxiness goes away after 3–12 hours.
Castable Wax Resin	5 min	- Maintain separate wash buckets to avoid color transfer. - Wash for 5 minutes, then remove parts and rinse in fresh IPA. - Wash Castable Wax Resin for the shortest time necessary. - When washed in TPM, Castable Wax Resin comes out of the wash clean and free of waxiness, requiring no post-curing. If parts are sticky after washing in TPM, Formlabs recommends post-curing for optimal casting results.
Castable Wax 40 Resin	5 min	- Maintain separate wash buckets to avoid color transfer. - Wash for 5 minutes, then remove parts and rinse in fresh IPA. - Wash Castable Wax Resin for the shortest time necessary.
Ceramic Resin	5 min	Maintain separate wash buckets to prevent ceramic particles adhering to parts printed with other resins.
Custom Tray Resin	10 min	Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations.

		● Maintain separate wash buckets for biocompatible materials.
Dental LT Clear Resin V1	20 min	● Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations. ● Maintain separate wash buckets for biocompatible materials. ● Do not leave Dental LT Clear Resin V1 in IPA for longer than 20 minutes total, as excessive solvent exposure affects the quality of the final part.
Dental LT Clear Resin V2	15 min + 5 min	● Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations. ● Maintain separate wash buckets for biocompatible materials. ● Wash for 15 minutes, then remove parts and soak in fresh IPA for 5 minutes. ● Do not leave Dental LT Clear Resin V2 in IPA for longer than 20 minutes total, as excessive solvent exposure affects the quality of the final part.
Denture Base Resin Denture Teeth Resin	10-20 min	● Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations. ● Maintain separate wash buckets for biocompatible materials.
Draft Resin	10 min	● Tackiness has been observed on part surfaces when washed in alcohol with more than 5% resin concentration. ● Avoid washing Draft Resin for longer than the recommended time.
Durable Resin	20 min	● When washed in IPA with a resin concentration of more than 10%, tackiness has been observed on part surfaces. ● Do not leave Durable Resin in solvent for longer than 20 minutes total, as excessive solvent exposure affects the quality of the final part.
Elastic 50A Resin	10 min + 10 min	● Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes. ● Do not leave Elastic 50A Resin in solvent for longer than 20 minutes total, as excessive solvent exposure affects the quality of the final part.
Flexible 80A Resin Flexible Resin V2 Soft Tissue Resin	10 min + 10 min	● Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes. ● When washed in TPM, Flexible 80A Resin and Flexible Resin V2 remains waxy when printed at any layer thickness. and requires post-cure. Post-curing removes waxiness.
Grey Pro Resin	15 min	● When washed in TPM, Grey Pro Resin comes out of the wash clean and free of waxiness.
High Temp Resin	6 min	● Do not leave High Temp Resin in solvent for longer than 6 minutes total, as excessive solvent exposure affects the quality of the final part.
IBT Resin	20 min	● Exceeding wash duration may affect dimensional accuracy and performance of printed parts over time.

Model Resin	10 min	- When washed in IPA with a resin concentration of more than 10%, tackiness has been observed on part surfaces. - When washed in TPM, Model Resin remains waxy when printed with a layer thickness of 50 microns or 100 microns, but the waxiness goes away after 3–12 hours.
Permanent Crown Resin	3 min	- Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations. - Maintain separate wash buckets for biocompatible materials. - Do not leave Permanent Crown Resin in IPA for longer than 3 minutes total, as excessive solvent exposure affects the quality of the final part. - Use an IPA-filled squeeze bottle to remove any remaining resin on the printed parts and in between supports and rafts. An IPA-soaked brush may help with resin removal.
Rigid 4000 Resin	15 min	- Maintain separate wash buckets to prevent glass particles adhering to parts printed with other resins. - When washed in TPM, Rigid Resin comes out of the wash clean and free of waxiness.
Rigid 10K Resin	10 min + 10 min	- Maintain separate wash buckets to prevent glass particles adhering to parts printed with other resins. - When washed in TPM, Rigid 10K Resin comes out of the wash clean and free of waxiness.
Surgical Guide Resin	Form Wash: 20 min Form Wash L: 5 min or until clean	- Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations. - Maintain separate wash buckets for biocompatible materials.
Temporary CB Resin	3 min	- Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations. - Maintain separate wash buckets for biocompatible materials. - Do not leave Temporary CB Resin in IPA for longer than 3 minutes, as excessive solvent exposure affects the quality of the final part. - Use an IPA-filled squeeze bottle to remove any remaining resin on the printed parts and in between supports and rafts. An IPA-soaked brush may help with uncured resin removal.
Tough 2000 Resin Tough Resin V5	10 min + 10 min	- When washed in IPA with a resin concentration of more than 5%, tackiness has been observed on part surfaces. - When washed in TPM, Tough 2000 Resin and Tough Resin V5 come out of the wash clean and free of waxiness. - Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes.
Tough 1500 Resin	10 min + 10 min	- When washed in IPA with a resin concentration of more than 5%, tackiness has been observed on part surfaces. - When washed in TPM, Tough 1500 Resin remains waxy when printed with a layer thickness of 50 microns or 100 microns, but the waxiness goes away after 3–12 hours.

		• Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes. • If parts printed with Tough 1500 Resin will be used for skin contact use, wash parts in $\geq 99\%$ IPA in a Form Wash for 20 minutes to comply with biocompatibility requirements.
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