

Subject:**Figure 4® Modular**

Premium Mold Build Style Tips

Issue:

With the launch of the new Premium Mold Build Style for Figure 4 HI TEMP 300-AMB material, there are many tips and tricks to help with your builds.

Solution:

1. Use the HI TEMP Premium Mold support style along with the Premium Mold Build Style.
2. Orient parts on angle for best results. Be sure to support the initial part layers well in a tripod position to prevent any part shift.
3. Make mating parts angles the same for each mold part for best matching parts
4. When coring out mold halves, use a honeycomb hatch/rubbing pattern with no sharp corners.
5. For best results for the best quality vs time, use 50µm layer thickness.
6. Ensure no debris is in resin tray before printing to avoid causing part defects that could lead to cracks. [Run a resin-tray cleaning](#) if you suspect there to be debris.
7. Ensure no debris is on print platform before printing.
8. When making large inserts for molds:
 - a. Modify model to add 500µm to front and back face and mill off to ensure flatness
 - b. For larger molds, core out mold half and fill with aluminum epoxy for added cooling.
 - i. Mill off to be flat.
 - ii. When coring out, minimize ribs to maximize amount of aluminum epoxy to contact reverse side of the mold surface
 - c. Use metal sprue bushing for injection to avoid excess wear at injection point of mold when necessary for longevity of mold, or when using more-abrasive materials
9. Prints can take up to 12 hours.