



Customer Information Bulletin

CIB #: 00194

Date: 05/11/2020

Status: Non-confidential

CIB

Subject: Accura® Fidelity™ Tips & Information

- Software version:** It is best to use the most current software version, to ensure compatibility with newly-created build styles. For customers who utilize more than one z correction value within a single geometry, 3DSprint 2.13 or newer versions is required.
- 3D Print™ software entries:** The 3D Print software includes Dp and Ec values for each material used in the SLA printer. See the 3D Print Users' Guide for details. The values for Dp and Ec are shown below.

3. Recommended Starting Parameters

	ProX™ 800, iPro 8000 and iPro 9000SV SLA System	
Layer Thickness	0.15mm (0.006")	0.10mm (0.004")
Dp (mils)	5.28	5.28
Ec (mj/cm2)	12.8	12.8
Baseline Scale Factors (x, y, z)	1.000/1.000/1.000	1.000/1.000/1.000
Baseline Linewidth Compensation Value	0.0750mm (0.003")	0.0750mm (0.003")
Recommended vat temperature.	28°C	28°C

- QuickCast™ Borders:** To achieve a balance of part quality, strength, and drainage, the QuickCast build style uses 4 additional borders. If the QuickCast skin cracks or breaks during post processing, you can increase the number of additional borders. This will increase the build time and may negatively affect drainage dependent on geometry.
- QuickCast™ Hatch and Fill** Hatch overcure and Fill cure depth are optimized to maximize part quality and build speed. It is highly recommended that the Fill cure



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depth and hatch overcure values not be reduced from default. However, you can increase hatch overcure to increase the thickness of the hatch lines which will increase the build speed. Increasing the fill cure depth may cause surface distortion, tacky down-facing surfaces, or delamination.

6. **Supports for Large Flat area:** For most SLA printer models, two default support generation parameters are provided. One style is to be used when generating supports on parts which contain flat surfaced larger than 50 mm [2 in.] across, the other is to be used with all other parts. Certain parts with large flat areas (larger than 50 mm [2 in.] across) may have wavy down facing surfaces using the general support style. When printing geometries with large flats, using the supplied Large support style when generating supports in the 3DSprint is recommended.
7. **Removing Excess Resin from QuickCast Parts:**
 - 7.1. **QuickCast Vent & Drains:** In general, when using QuickCast™ 2.0 style, Drains should be located at low points in any region that can trap resin. For large flat areas, use multiple drains, spaced at approximately 50mm [2 in.] intervals throughout the lowest trapped resin region. Locate vents as high as practical. Only 1 or 2 vents are needed on most parts. Default vent 1.27mm [0.05 in.] and drain 5.08mm [0.2 in.] sizes are recommended.
 - 7.2. **Draining, Cleaning and Post-Curing.** Refer to the [QuickCast Post-Processing Procedure](#).
8. **Support removal:** Removal of supports prior to UV post cure is recommended to avoid damage to QuickCast parts.



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9. *Instructions for entering Linewidth Compensation values in 3D Sprint.*

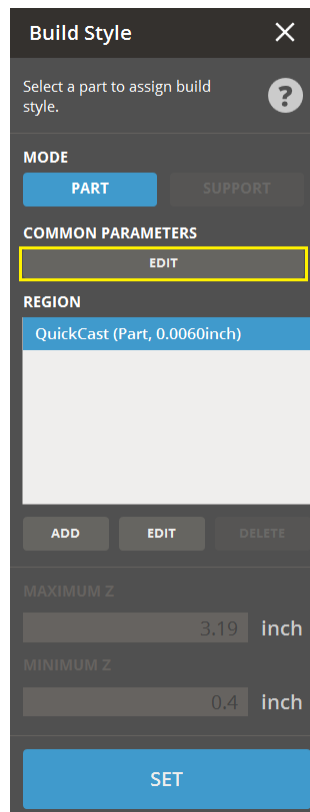
In 3D Sprint, you will perform two steps. The first one saves new values to a style, and the second one builds a platform configuration with the new style (allows you to set the new value as the default).

9.1. To adjust compensation for a Single Part in 3D Sprint:

9.2. With a part selected, click on Build Style.



9.3. Under Common Parameters, click Edit.





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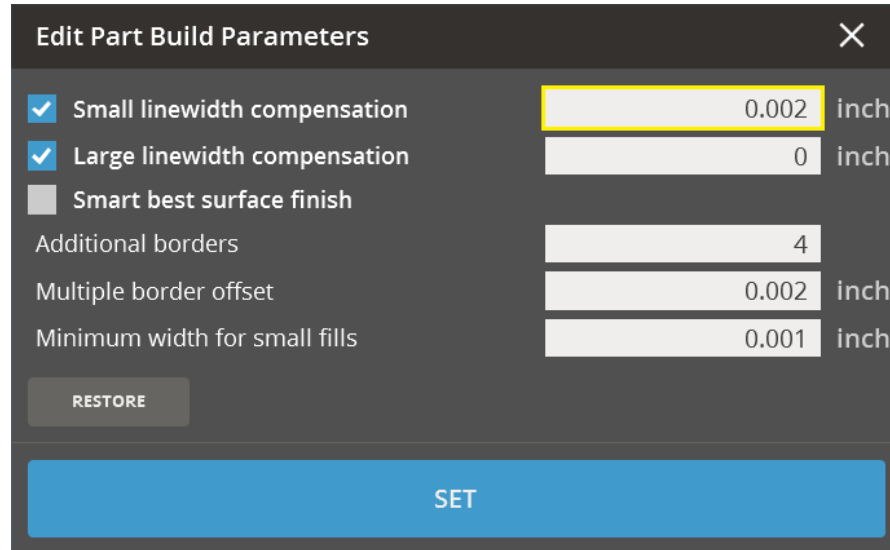
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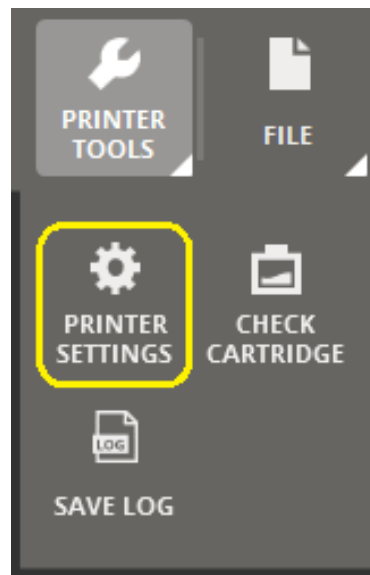
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9.4. Enter value in the Small linewidth compensation field.



9.5. To adjust compensation and save within a Style in 3D Sprint:

9.6. Select Printer Tools, then Printer Settings





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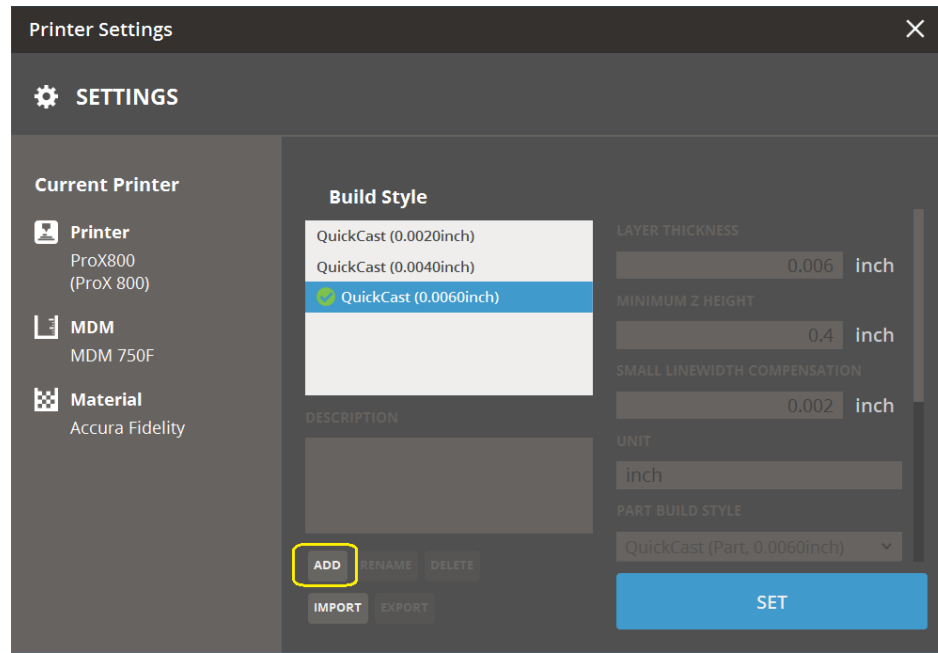
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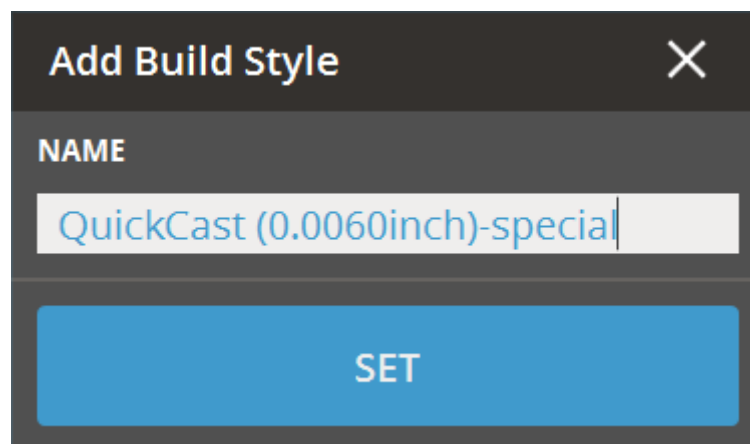
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9.7. Select Add.



9.8. Choose a name for your saved style configuration





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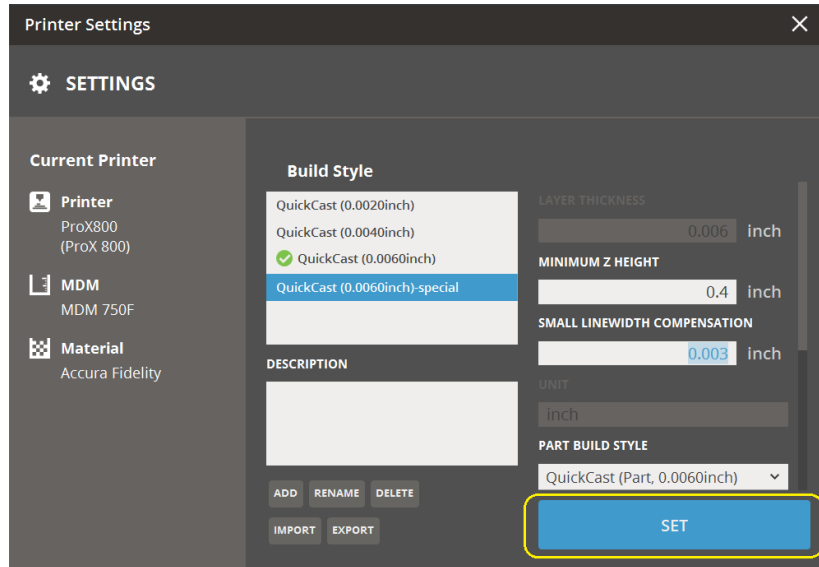
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9.9. Enter value for Small linewidth compensation and click Set.



9.10. Your new style is now saved and available on the Build Style tab of the Printer interface.

