

Step	Action	Duration	Notes
POST-PRINT PROCESS (IN ORDER) 4 items			
1. Remove	Lever part from build plate	Immediate	Remove directly into wash solution to limit resin contact.
2. Wash	Agitate in IPA 99% or dedicated solution	2–4 minutes	Do not over-wash — IPA can cause swelling in some resins.
3. Air dry	Place on absorbent surface	10–15 minutes	Part must be completely dry before UV curing.
4. UV cure	Rotate in 405nm UV station	See table below	Curing without washing traps resin and causes tacky surface.
UV CURE TIME BY PART SIZE (405nm, ~36W station) 4 items			
Small (<50mm)	2–3 min per side	All resins	Rotate part for even exposure on all faces.
Medium (50–150mm)	4–6 min per side	All resins	Multiple rotations recommended.
Large (>150mm)	7–8 min per side	All resins	Under-cure leads to weak, brittle finished parts.
Tough / Engineering	Exceeding above std	Engineering resins	Full cure critical — mechanical properties depend on it.