

3DR Settings Guidance on Asiga UV Max 385



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Asiga UV Max 385



Asiga Flash Cure



*Ackuretta Curie

Resin	Settings	50 Micron	100 Micron	Guidance
 Model Pro	INI	Denta Model (Modified)	Denta Model (Modified)	Step 1 - Select Asigamodel INI and adjust Step 2 - Input the light intensity and layer exposure so that the multiplication of their values = UV dose (e.g 11.6 x 0.91 = 10.6 and also 10.6 x 1= 10.6) Step 3 - After printing, wash with IPA and then post cure in Asiga Flash Cure for 30m
	Light Intensity mw/cm ²	11.6	11.6	
	Layer Exposure (s)	0.91	1.13	
	UV Dose (mws/cm2)	10.6	13.1	
	Base Exposure (s)	8.9	8.9	
 Model Standard	INI	Denta Model (Modified)	Denta Model (Modified)	Step 1 - Select Asigamodel INI and adjust Step 2 - Input the light intensity and layer exposure so that the multiplication of their values = UV dose (e.g 11.6 x 0.91 = 10.6 and also 10.6 x 1= 10.6) Step 3 - After printing, wash with IPA and then post cure in Asiga Flash Cure for 30m
	Light Intensity mw/cm ²	11.6	11.6	
	Layer Exposure (s)	0.91	1.13	
	UV Dose (mws/cm2)	10.6	13.1	
	Base Exposure (s)	8.9	8.9	
 Model Hard	Light Intensity mw/cm ²	12.06	12.14	Step 1 - Select Asigamodel INI and adjust Step 2 - Input the light intensity and layer exposure so that the multiplication of their values = UV dose (e.g 12.06 x 0.66 = 8 and also 8 x 1= 8) Step 3- After printing, wash with IPA and then post cure in Asiga Flash Cure for 30m
	Layer Exposure (s)	0.66	0.87	
	UV Dose (mws/cm2)	8.0	10.6	
	Base Exposure (s)	8.9	8.9	
 Dental Cast	INI	Nextdent Cast	Nextdent Cast	Step 1 - Select Nextdent Cast V2.2 ini file. Step 2 - After printing, wash with IPA and then post cure in Asiga Flash Cure for 30m
	Light Intensity mw/cm ²	5	5	
	Layer Exposure (s)	2.1	3.225	
	UV Dose (mws/cm2)	10.5	16.1	
	Base Exposure (s)	8.8	8.8	
 Surgical Guide	INI	Optiprint Guide	Optiprint Guide	Step 1 - Select Optiprint Guide 385 Guide V.1 ini file. Step 2 - After printing, wash with IPA and then post cure in Asiga Flash Cure for 30m
	Light Intensity mw/cm ²	12.06	12.06	
	Layer Exposure (s)	1.078	1.306	
	UV Dose (mws/cm2)	13.0	15.8	
	Base Exposure (s)	9.85	9.85	
 Crown & Bridge	INI	Optiprint Temp 385	Optiprint Temp 385	Step 1 - Select Optiprint Temp 385 Guide V.1 ini file. Step 2 - After printing, wash with IPA and then post cure in Asiga Flash Cure for 30m Step 3 -Instead of Asiga Flash Cure,Post curing for 10 mints in Ackuretta curie using Curo Temp Program gives better results.
	Light Intensity mw/cm ²	11.76	12.03	
	Layer Exposure (s)	0.85	1.638	
	UV Dose (mws/cm2)	10.0	19.7	
	Base Exposure (s)	9.07	9.07	