

CHEATSHEET

MONOCURE 3D RAPID RESIN WANHAO DUPLICATOR 7



Introduction

Congratulations on your purchase! I know you will be happy with this great 3D printer, especially when using our Monocure 3D Rapid Resin. It was formulated with over 30 years of UV polymer experience and is manufactured in our own factory located in Sydney, Australia.

This Cheat Sheet will help you get the best out of your Duplicator 7 when using our advanced Rapid Resin system. Our different Rapid colours will print more or less the same, with only occasional minor setting adjustments needed.

Whether you are using Creation Workshop or Nano DLP, the information below should be enough to get you printing like a professional in no time. You can buy our resin from our [website](#) or our friendly [resellers](#).



What printer settings should I start with?

Resin Type: Monocure RAPID (all colours)*

Layer Height: 50 microns

Base layers: 4 x 60 Seconds

Normal Layers: 7 Seconds

Lift Distance: 4mm

Wait after Print: 1 Second

* These settings are a guide only as your environment & printer can change the way the resin reacts when cured.

How should I handle the resin?

- * Shake the bottle well before every use.
- * Store the resin in a dark cool place.
- * Clean parts and spills with [RESINAWAY](#) or IPA
- * Filter Resin back into the bottle when not printing.
- * Post-cure using a 405nm light to avoid yellowing.

Should I Sand the Build Plate?

The Duplicator 7 has had a few different build plate finishes. The early models came with a brushed aluminium surface, then they brought out a painted black one, and the latest version has a highly polished aluminium surface.

If you have either of the last two mentioned, for the best adhesion, especially with any darker pigmented colours. To help with this, you may choose to sand the build plate to restore it to the brushed aluminium surface. This is best done by using masking tape to stick a piece of 240 grit sandpaper to a completely flat surface (Glass is perfect), then rub your build plate back and forth until all the paint is removed. Using an electric sander is not recommended as it could make the build plate surface uneven and potentially not completely flat.

Remember to re-home the printer when done as the build plate will be a bit thinner!



Important Things to Remember!

- ★ Sand your build plate (See left)
- ★ Home printer correctly
- ★ Avoid using rafts or bases
- ★ Angled Model Position
- ★ Use lots of thick supports
- ★ KISS (Keep it Simple)

Having Problems? Have you downloaded our [Calibration Models](#) yet? Please contact us on our website for [technical support](#).