Form Wash and Form Wash L time settings

Wash printed parts before post-curing to remove liquid resin from part surfaces. These settings indicate the recommended time to wash parts printed in Formlabs resins using the Form Wash or Form Wash L and isopropyl alcohol (IPA) or tripropylene glycol monomethyl ether (TPM).

For a wash bucket with highly resin-concentrated solvent, add an additional 5 minutes to the wash time. The lifetime of the solvent bath can be prolonged with a revised workflow. Consider rinsing parts with a small volume of solvent before inserting printed parts in the Form Wash or Form Wash L. Preliminary rinsing removes most liquid resin and keeps the solvent in the wash bucket cleaner.

RESIN	WASH TIME	NOTES
Alumina 4N Resin	2 min	• Only wash Alumina 4N Resin in the Ceramic Wash Solution. Do not allow Alumina 4N Resin parts to come into contact with water or IPA, as this will cause cracking. • Use a separate wash bucket to prevent loose ceramic particles from adhering to non-Aeramic parts.
BioMed Amber Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide. Maintain separate wash buckets for resins for biocompatible applications.	
BioMed Black Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide. Maintain separate wash buckets for resins for biocompatible applications.	
BioMed Clear Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide. Maintain separate wash buckets for resins for biocompatible applications.	
BioMed Durable Resin V1 BioMed Durable Resin V1.1	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide. Maintain separate wash buckets for resins for biocompatible applications.	
BioMed Elastic 50A Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide. Maintain separate wash buckets for resins for biocompatible applications.	
BioMed Flex 80A Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide. Maintain separate wash buckets for resins for biocompatible applications.	
BioMed White Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide. Maintain separate wash buckets for resins for biocompatible applications.	
Black Resin V4 Clear Resin V4 Color Resin Grey Resin V4 White Resin V4	10 min	• When washed in TPM, standard resins remain waxy when printed with a layer thickness of 50 microns or 100 microns. Post-curing removes waxiness. Without post-curing, waxiness goes away after about a week.
Black Resin V5	5 min	

RESIN	WASH TIME	NOTES
Clear Resin V5 Grey Resin V5 White Resin V5		
Castable Resin	10 min	• Maintain separate wash buckets to avoid color transfer. • Wash Castable Resin for the shortest time necessary. • When washed in TPM, Castable Resin remains waxy when printed with a layer thickness of 50 microns or 100 microns, but the waxiness goes away after 3–12 hours.
Castable Wax Resin	5 min	• Maintain separate wash buckets to avoid color transfer. • Wash for 5 minutes, then remove parts and rinse in fresh IPA. • Wash Castable Wax Resin for the shortest time necessary. • When washed in TPM, Castable Wax Resin comes out of the wash clean and free of waxiness, requiring no post-curing. If parts are sticky after washing in TPM, Formlabs recommends post-curing for optimal casting results.
Castable Wax 40 Resin	5 min	• Maintain separate wash buckets to avoid color transfer. • Wash for 5 minutes, then remove parts and rinse in fresh IPA. • Wash Castable Wax Resin for the shortest time necessary.
Ceramic Resin	5 min	• Maintain separate wash buckets to prevent ceramic particles adhering to parts printed with other resins.
Custom Tray Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide. Maintain separate wash buckets for resins for biocompatible applications.	
Dental LT Clear Resin V1	20 min	• Wash in IPA with a concentration of 99% or higher to comply with biocompatibility regulations. • Maintain separate wash buckets for biocompatible materials. • Do not leave Dental LT Clear Resin V1 in IPA for longer than 20 minutes total, as excessive solvent exposure affects the quality of the final part.
Dental LT Clear Resin V2	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide. Maintain separate wash buckets for resins for biocompatible applications.	
Dental LT Comfort Resin V1 Dental LT Comfort Resin V1.1	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide. Maintain separate wash buckets for resins for biocompatible applications.	
Denture Base Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Instructions for Use. Maintain separate wash buckets for resins for biocompatible applications.	

RESIN	WASH TIME	NOTES
Denture Teeth Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Instructions for Use. Maintain separate wash buckets for resins for biocompatible applications.	
Draft Resin	10 min	• Tackiness has been observed on part surfaces when washed in alcohol with more than 5% resin concentration. • Avoid washing Draft Resin for longer than the recommended time.
Durable Resin V2 Durable Resin V2.1	20 min	• When washed in IPA with a resin concentration of more than 10%, tackiness has been observed on part surfaces. • Do not leave Durable Resin in solvent for longer than 20 minutes total, as excessive solvent exposure affects the quality of the final part.
Elastic 50A Resin V1	10 min + 10 min	• Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes. • Do not leave Elastic 50A Resin in solvent for longer than 20 minutes total, as excessive solvent exposure affects the quality of the final part.
Elastic 50A Resin V2	20 min + 10 min	• Separate parts from the build platform and wash for 20 minutes. • Remove parts, let dry for 10 minutes, then remove supports. • Wash parts again for 10 minutes.
ESD Resin	20 min	• Use a separate wash bucket to prevent ESD Resin from transferring to other parts.
Fast Model Resin	5 min	
Flame Retardant Resin	10 min (IPA) 15 min (TPM)	• Small negative features may be difficult to fully clean due to the resin's high viscosity. Make sure to clean your parts thoroughly before post-curing. Consider using pressurized air for better cleaning.
Flexible 80A Resin V1 Flexible 80A Resin V1.1 Flexible Resin V2 Soft Tissue Resin	10 min + 10 min	• Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes. • When washed in TPM, Flexible 80A Resin and Flexible Resin V2 remains waxy when printed at any layer thickness. and requires post-cure. Post-curing removes waxiness.
Grey Pro Resin	15 min	• When washed in TPM, Grey Pro Resin comes out of the wash clean and free of waxiness.
High Temp Resin	5 min	• Do not leave High Temp Resin in solvent for longer than 6 minutes total, as excessive solvent exposure affects the quality of the final part.

RESIN	WASH TIME	NOTES
IBT Flex Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide. Maintain separate wash buckets for resins for biocompatible applications.	
IBT Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide. Maintain separate wash buckets for resins for biocompatible applications.	
Model Resin	10 min	• When washed in IPA with a resin concentration of more than 10%, tackiness has been observed on part surfaces. • When washed in TPM, Model Resin remains waxy when printed with a layer thickness of 50 microns or 100 microns, but the waxiness goes away after 3–12 hours.
Permanent Crown Resin	• To ensure that finished parts are biocompatible, follow all part washing notes in the Instructions for Use [EN] [EU]. Maintain separate wash buckets for resins for biocompatible applications. • Do not leave Permanent Crown Resin in IPA for longer than 3 minutes total, as excessive solvent exposure affects the quality of the final part. • Use an IPA-filled squeeze bottle to remove any remaining resin on the printed parts and in between supports and rafts. An IPA-soaked brush may help with resin removal.	
Precision Model Resin	5 min	
Premium Teeth Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide. Maintain separate wash buckets for resins for biocompatible applications.	
Rigid 4000 Resin	15 min	• Maintain separate wash buckets to prevent glass particles adhering to parts printed with other resins. • When washed in TPM, Rigid Resin comes out of the wash clean and free of waxiness.
Rigid 10K Resin V1 Rigid 10K Resin V1.1	10 min + 10 min	• Maintain separate wash buckets to prevent glass particles adhering to parts printed with other resins. • When washed in TPM, Rigid 10K Resin comes out of the wash clean and free of waxiness.
Silicone 40A Resin	20 min	• Wash parts printed with Silicone 40A Resin in an 80/20 mixture of isopropyl alcohol (IPA) and n-butyl acetate. Do not wash with IPA or n-butyl acetate alone.
Surgical Guide Resin	To ensure that finished parts are biocompatible, follow all part washing notes in the Manufacturing Guide. Maintain separate wash buckets for resins for biocompatible applications.	
Temporary CB Resin	• To ensure that finished parts are biocompatible, follow all part washing notes in the Instructions for Use. Maintain separate wash buckets for resins for biocompatible applications. • Do not leave Temporary CB Resin in IPA for longer than 3 minutes, as excessive solvent exposure affects the quality of the final part.	

RESIN	WASH TIME	NOTES
		• Use an IPA-filled squeeze bottle to remove any remaining resin on the printed parts and in between supports and rafts. An IPA-soaked brush may help with uncured resin removal.
Tough 2000 Resin Tough Resin V5	10 min + 10 min	• When washed in IPA with a resin concentration of more than 5%, tackiness has been observed on part surfaces. • When washed in TPM, Tough 2000 Resin and Tough Resin V5 come out of the wash clean and free of waxiness. • Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes.
Tough 1500 Resin V1 Tough 1500 Resin V1.1	10 min + 10 min	• When washed in IPA with a resin concentration of more than 5%, tackiness has been observed on part surfaces. • When washed in TPM, Tough 1500 Resin remains waxy when printed with a layer thickness of 50 microns or 100 microns, but the waxiness goes away after 3–12 hours. • Wash for 10 minutes, then remove parts and soak in fresh solvent for 10 minutes. • If parts printed with Tough 1500 Resin will be used for skin contact use, wash parts in ≥99% IPA in a Form Wash for 20 minutes to comply with biocompatibility requirements.