

FORMLABS FORM2 QUICK START GUIDE

Basic Operation

Version 2.0

10/17/2019

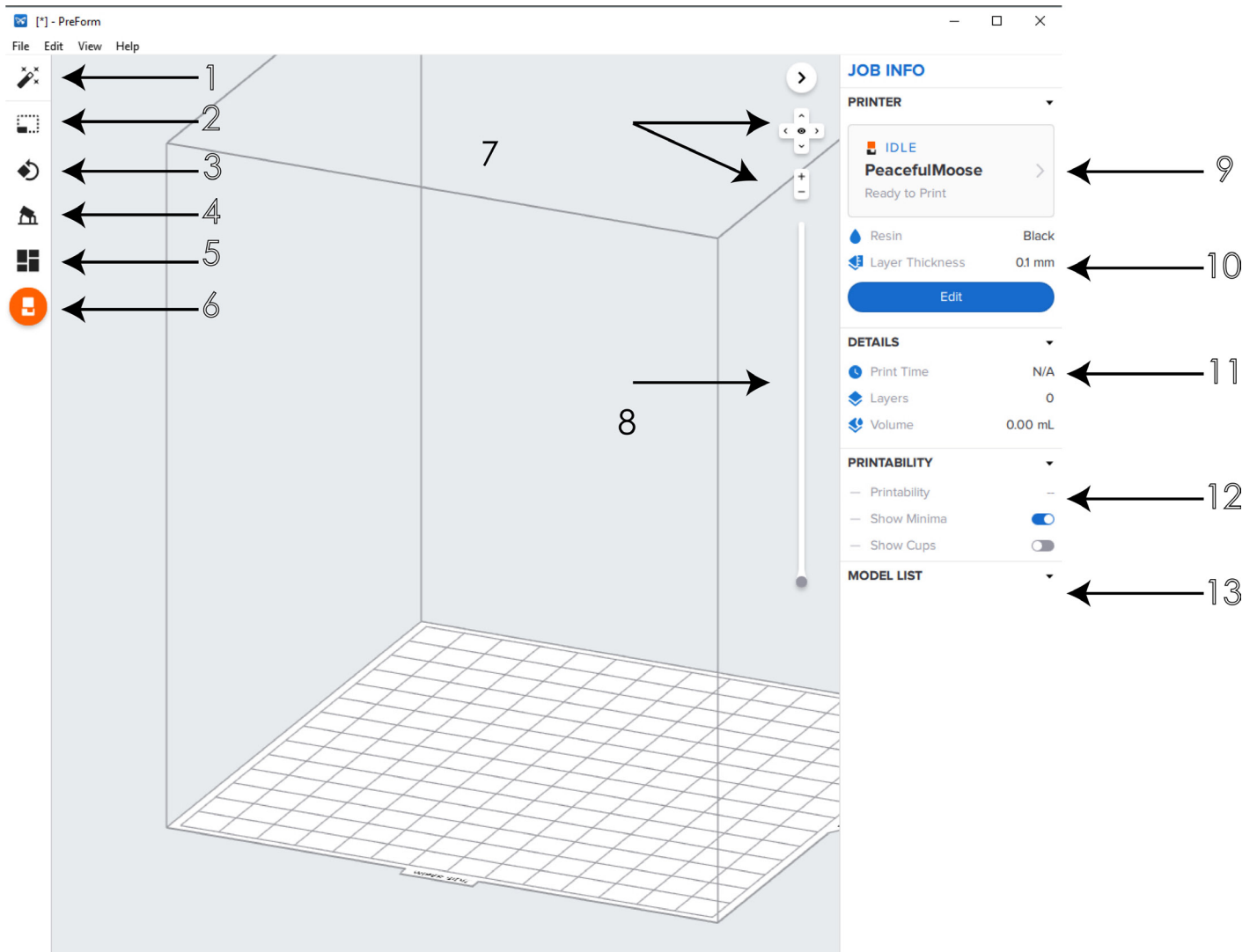
IMPORTANT INFORMATION

Whenever touching the printers, wash station, cure stations, parts, etc. **always wear gloves and safety glasses**

As a rule of thumb, to ensure a good print, orient your part at a compound angle of about 45 degrees in the X and Y axis using the rotate function

When adding your support structures, using a raft helps immensely. If possible try to use a raft if your part will allow for it

SOFTWARE

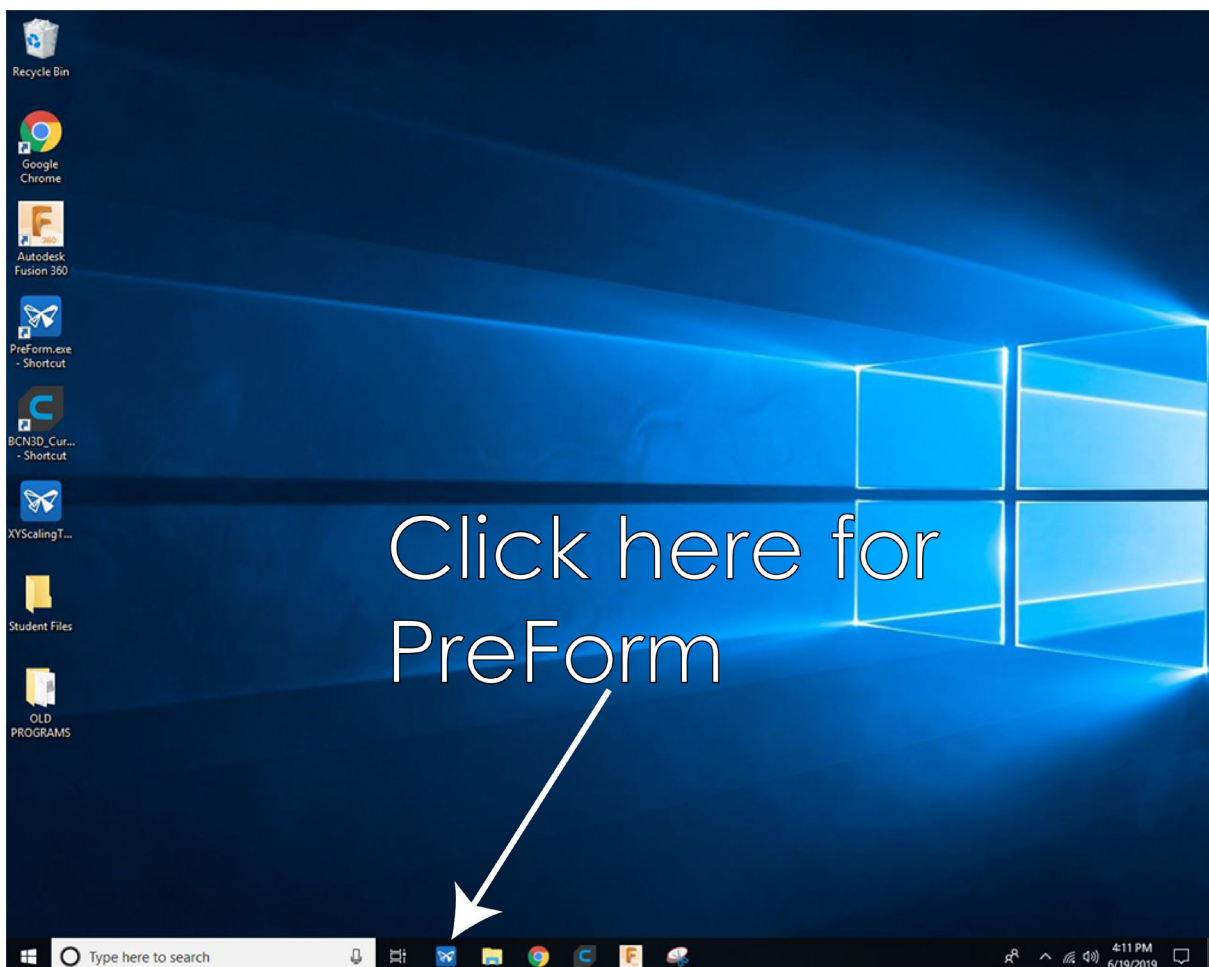


1. One-Click-Printing
2. Scale
3. Rotate
4. Support
5. Layout
6. Start A Print
7. Camera controls

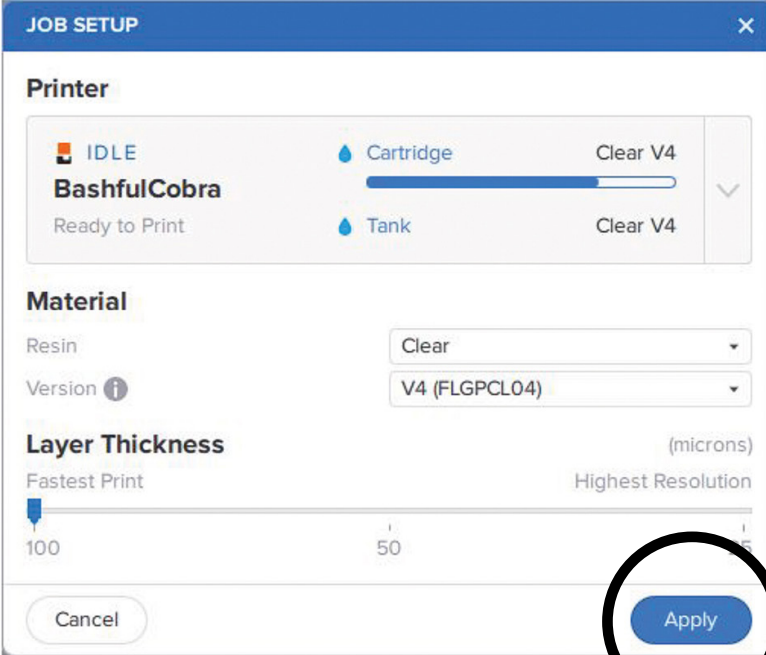
8. Slicer Tool
9. Printer Selected
10. Resin Info
11. Print Details
12. Printability Info
13. Model List

- 1. One-Click-Printing:** Automatically orients and adds support structure to your print
- 2. Scale:** Scale your model (in mm)
- 3. Rotate:** Rotate the orientation of your model
- 4. Support:** Add support structures and rafts to your model
- 5. Layout:** Create and arrange multiple versions of your print
- 6. Start a Print:** Send your model to the printer
- 7. Camera controls:** Pan, zoom, and rotate the camera
- 8. Slicer Tool:** View each slice of your print as the printer would print it in the orientation that you have set it
- 9. Printer Selected:** Shows which printer you will be sending your model to be used to print with
- 10. Resin Info:** Type of resin and layer thickness (resolution)
- 11. Print Details:** Estimated print time, number of layers, volume of print
- 12. Printability Info:** Printability check, Show Minima (lowest point of a surface), Show cups (Hollow sections and concave surfaces that risk creating a suction cup during printing)
- 13. Model List:** A list of all models currently in the software

1. Open the PreForm software by clicking on the icon in the bottom toolbar



2. In the Pop-up window, you can choose your printer, the material (resin type), and layer thickness (resolution). Make your adjustments and then click APPLY in the window.

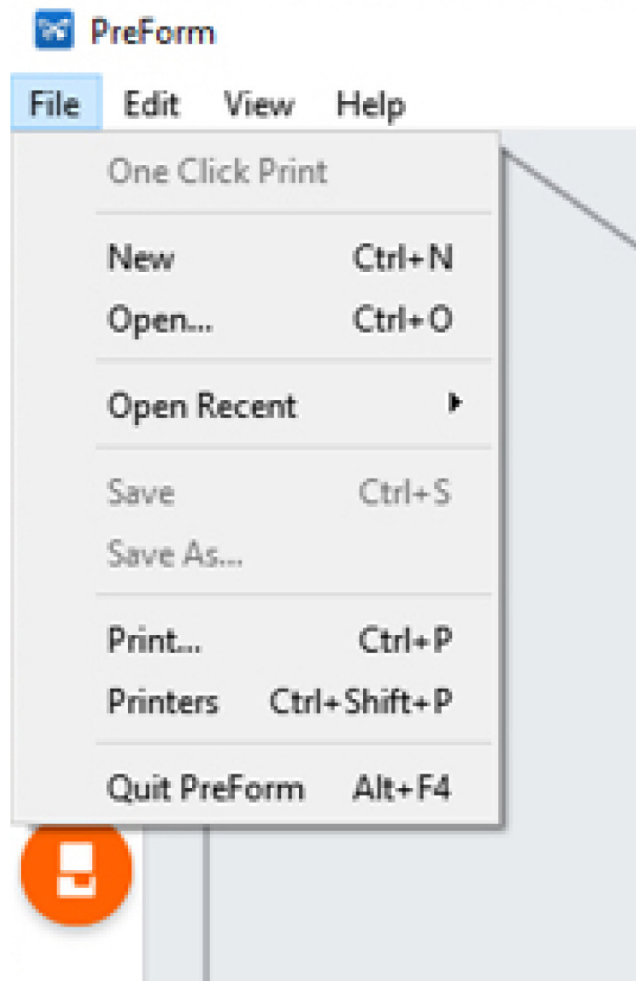


The screenshot shows a 'JOB SETUP' window with the following sections:

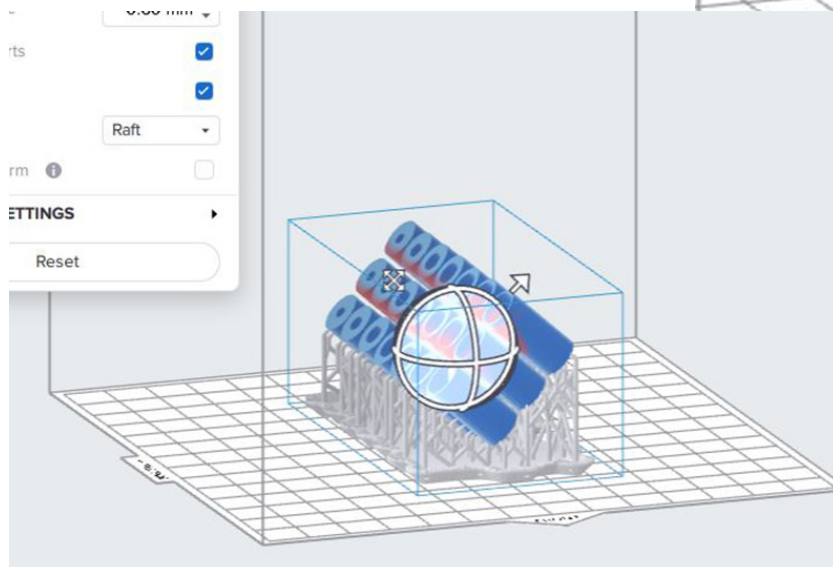
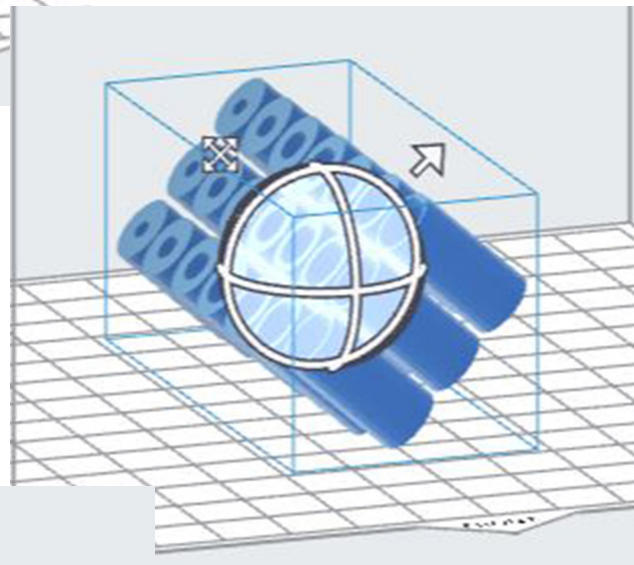
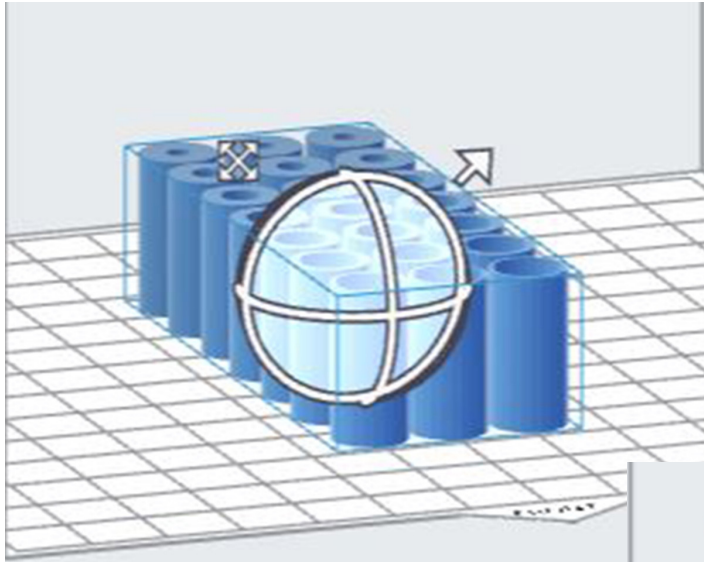
- Printer:** Shows 'BashfulCobra' as the selected printer, which is 'Ready to Print'. It also displays 'Cartridge' and 'Tank' levels with 'Clear V4' buttons and a dropdown arrow.
- Material:** Features dropdown menus for 'Resin' (set to 'Clear') and 'Version' (set to 'V4 (FLGPCL04)').
- Layer Thickness:** A slider ranging from 100 microns (Fastest Print) to 25 microns (Highest Resolution). The current setting is approximately 75 microns.

At the bottom of the window are two buttons: 'Cancel' and 'Apply'. The 'Apply' button is circled in black.

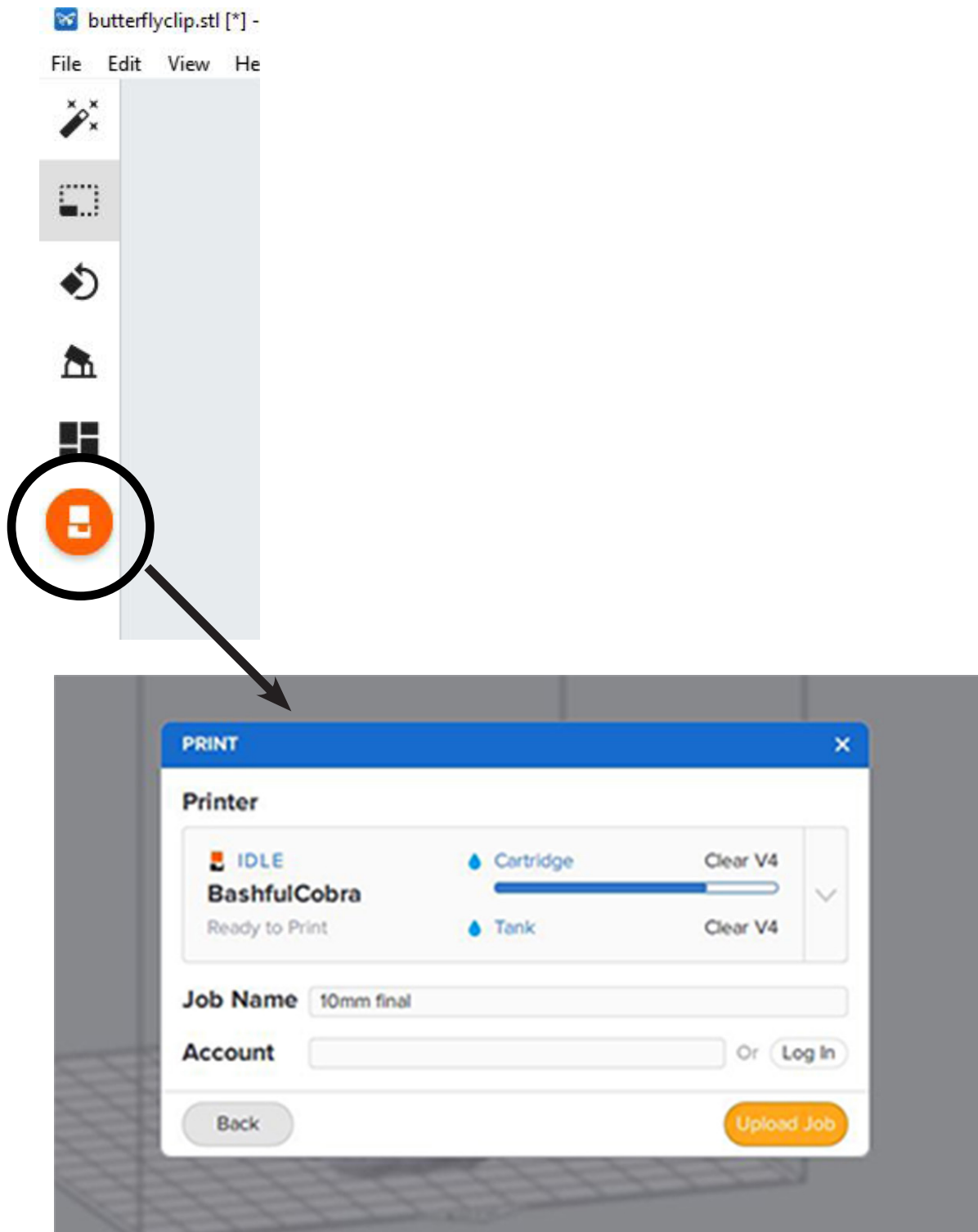
3. Upload your STL by going to FILE→OPEN



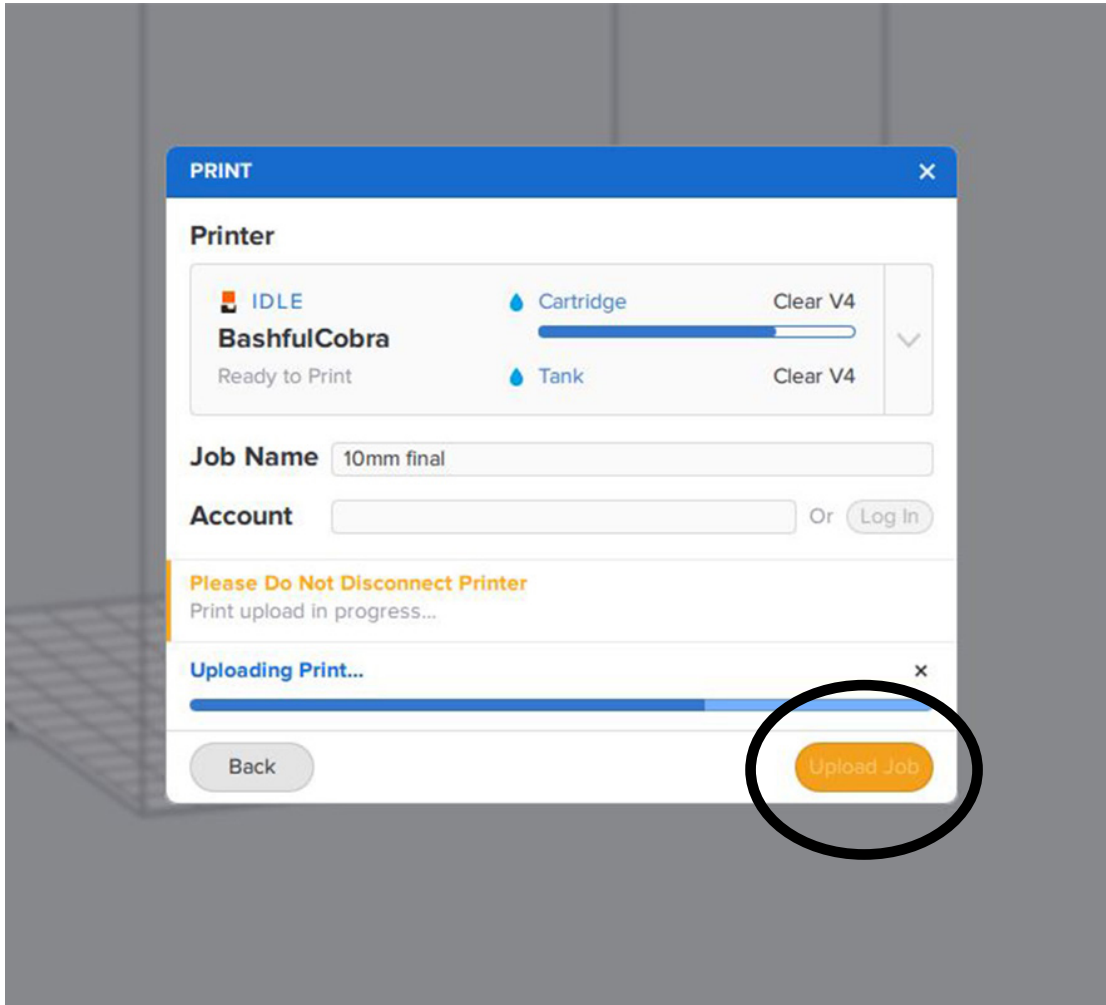
4. While in PreForm, make any adjustments to the model, such as rotate, scale, add supports, etc.



5. Click Send to Printer. (It will re-cap the settings)

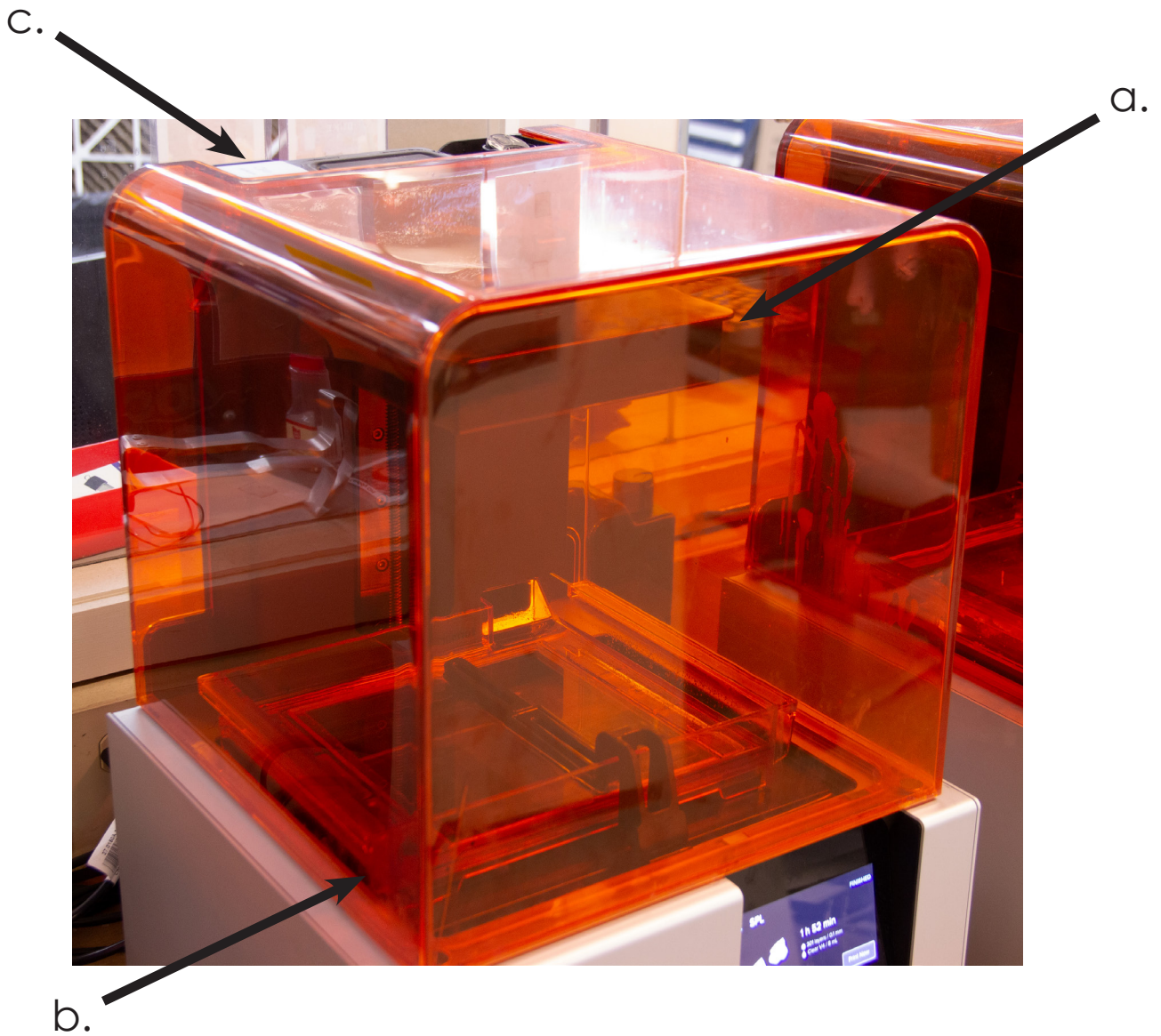


6. Upload the job

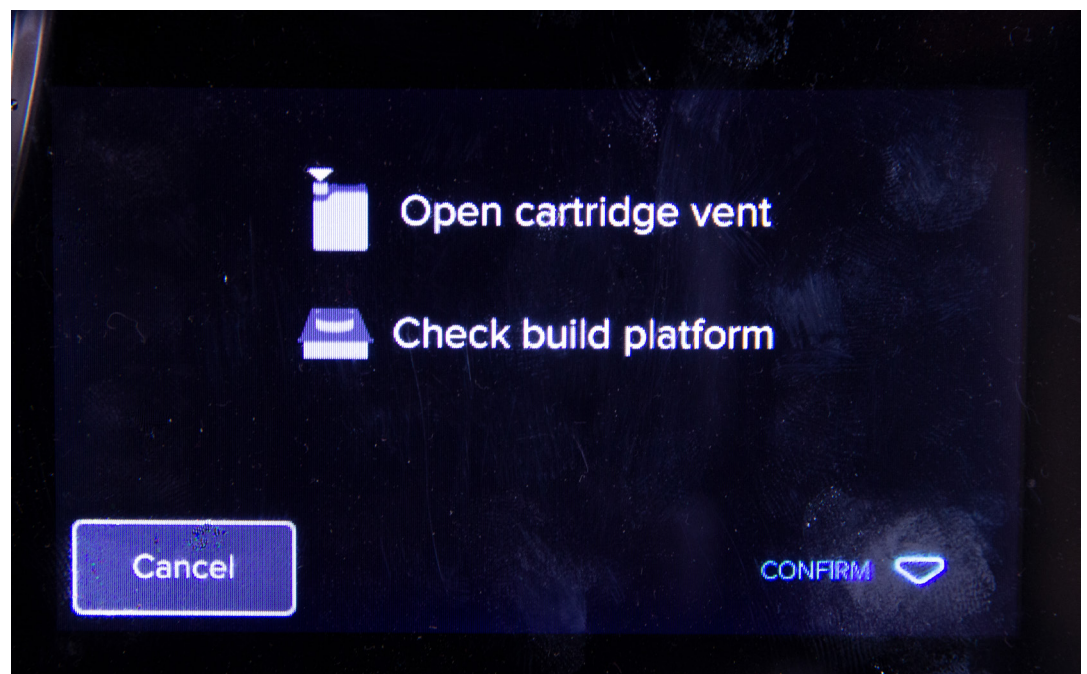
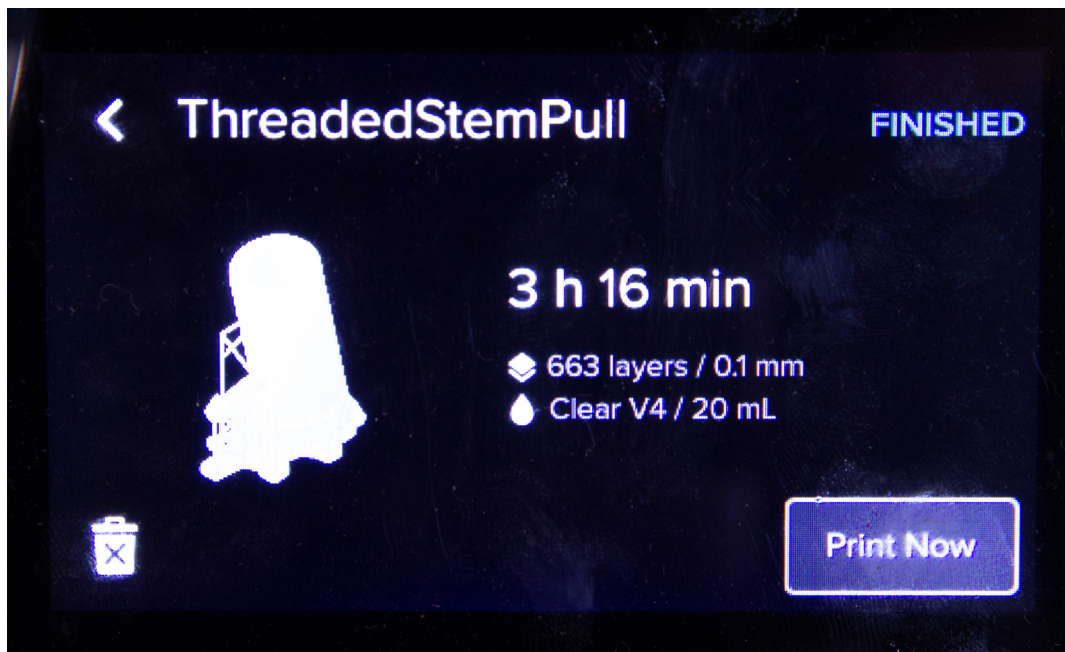


PRINTER

1. Make sure the printer has:
 - a. A clean build platform
 - b. A tank
 - c. A resin cartridge



2. Upon confirming the above, tap PRINT NOW on the printer's touch screen. (This will give you a warning to check to make sure that the cartridge vent is open and that the build platform is clean)



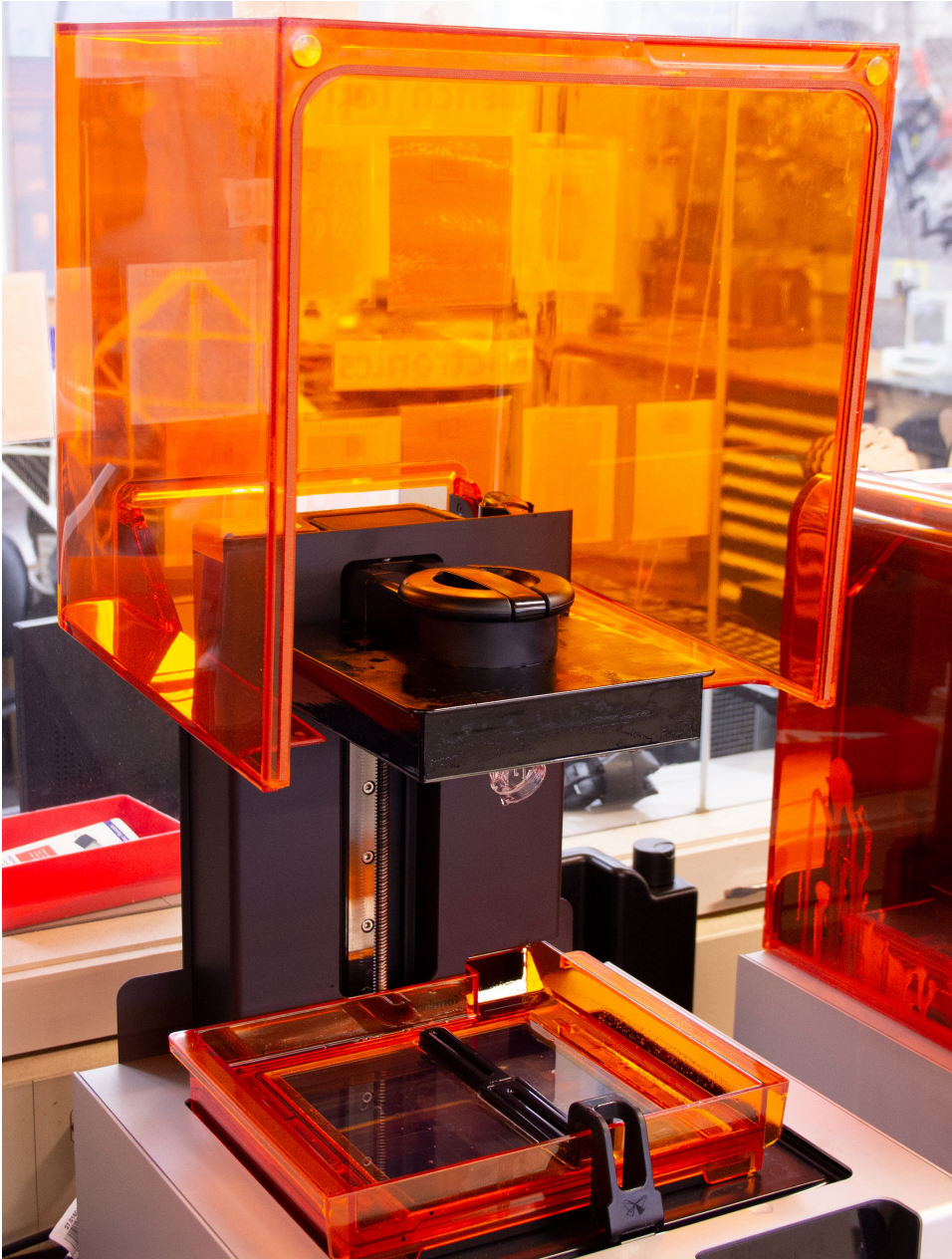
3. Press the button on the printer to confirm. (This will begin your print. It will take a few minutes for the resin tank to reach operating temperature.)



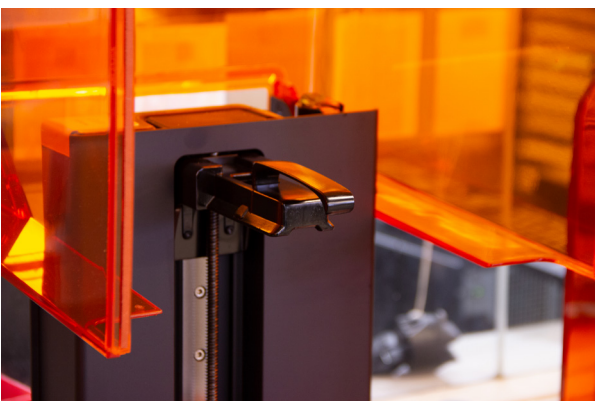
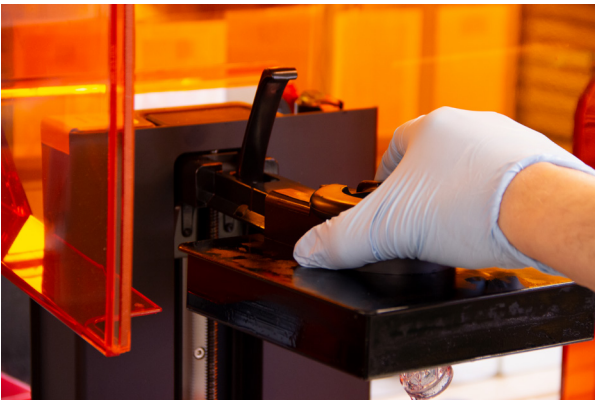
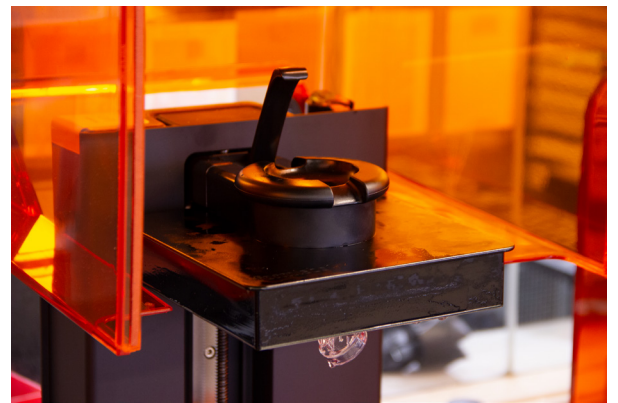
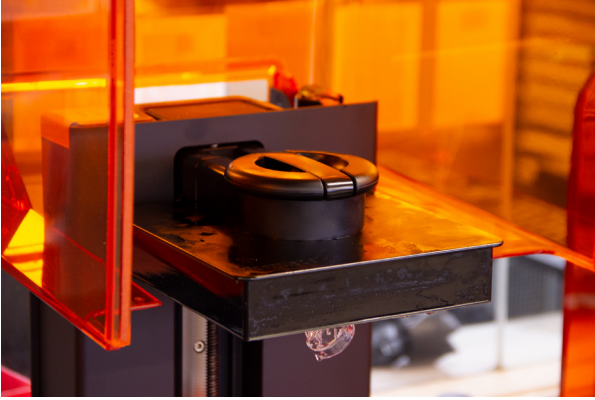
AFTER PRINTING (WASH)



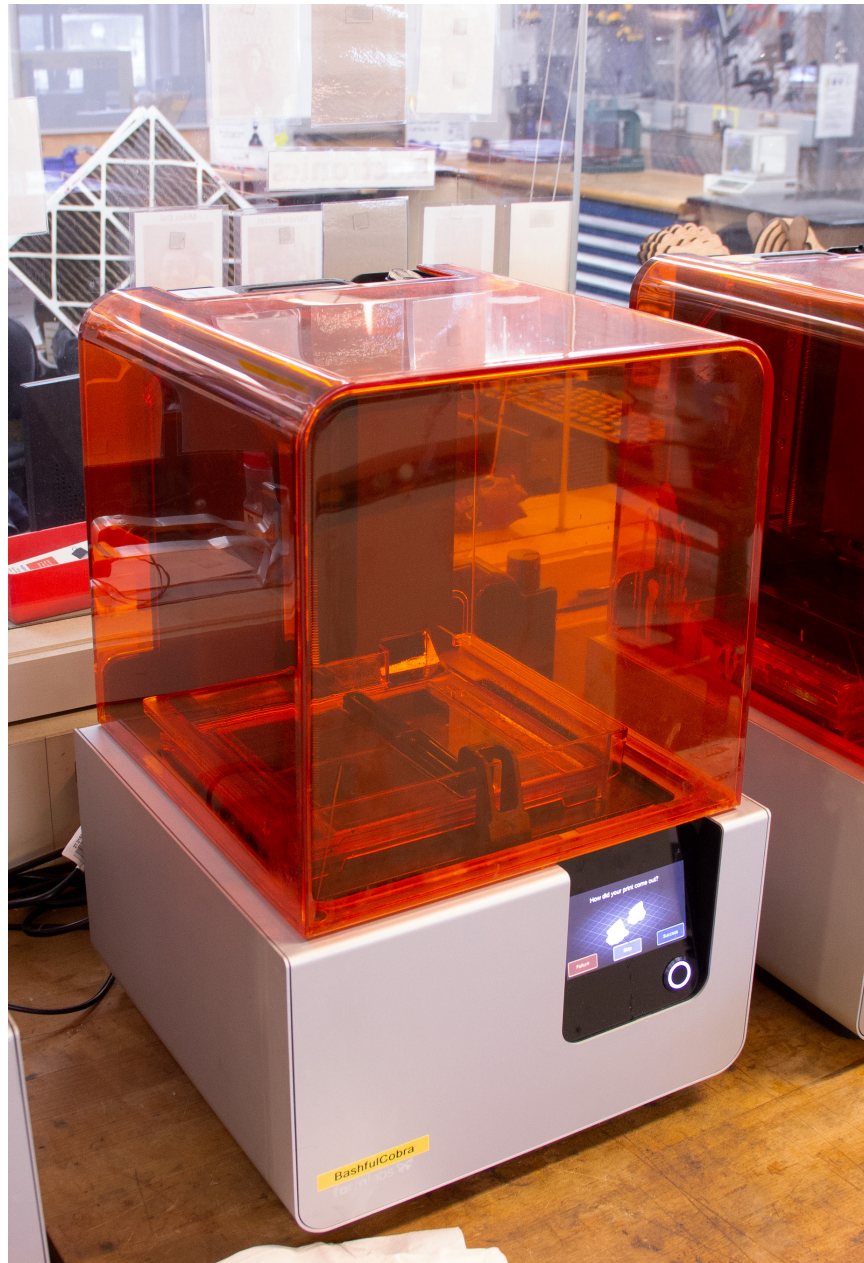
1. Open the cover



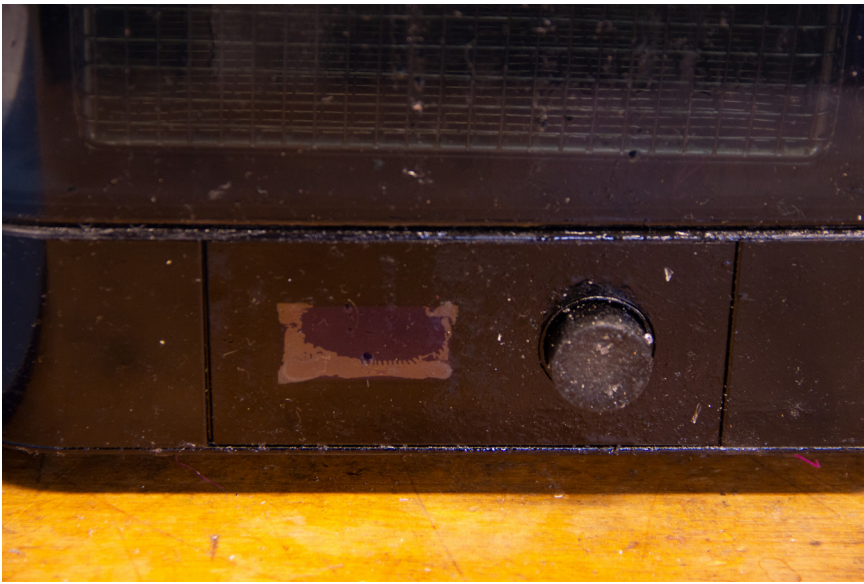
2. Remove the build platform



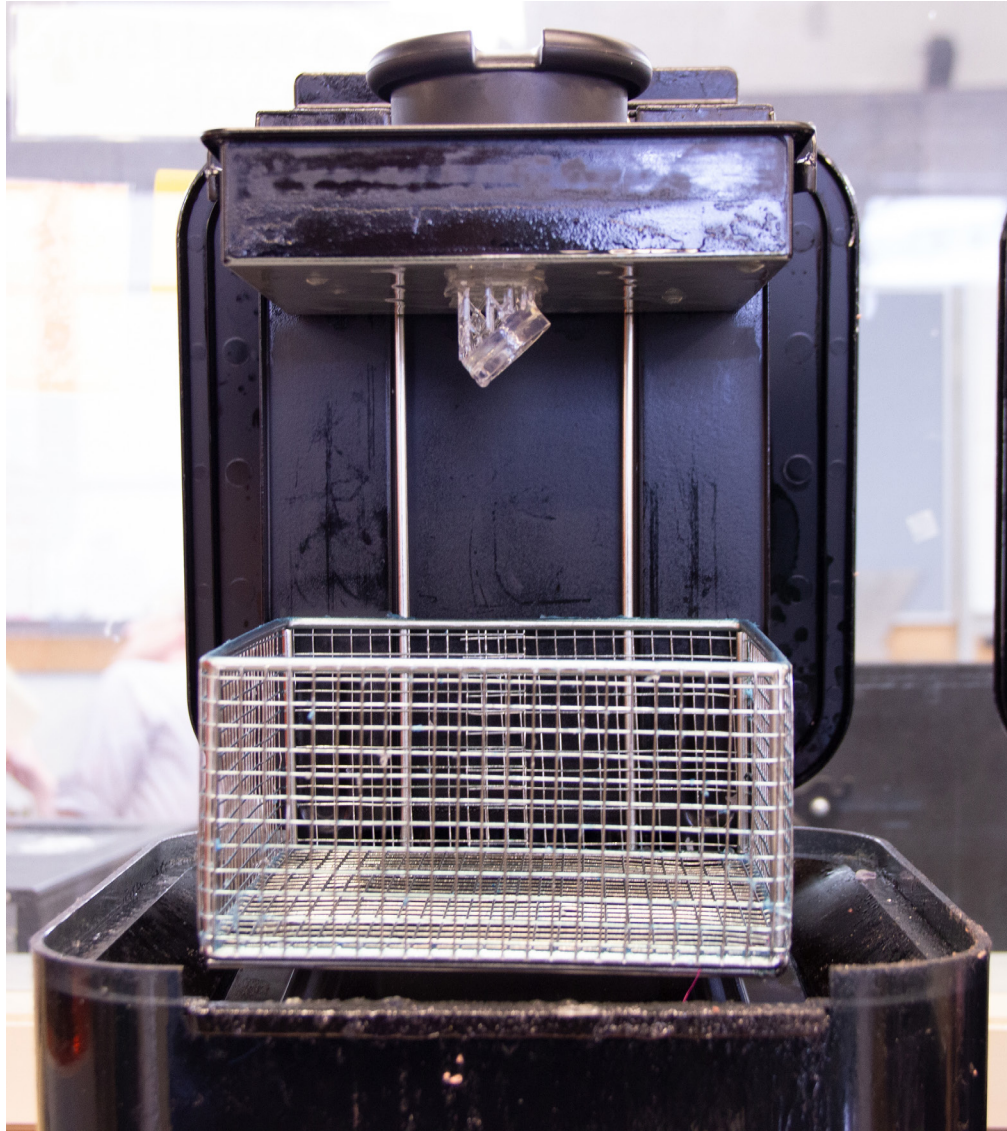
3. Close the cover



4. Wake up the wash station by pressing the selector dial. Highlight OPEN and press the selector dial.



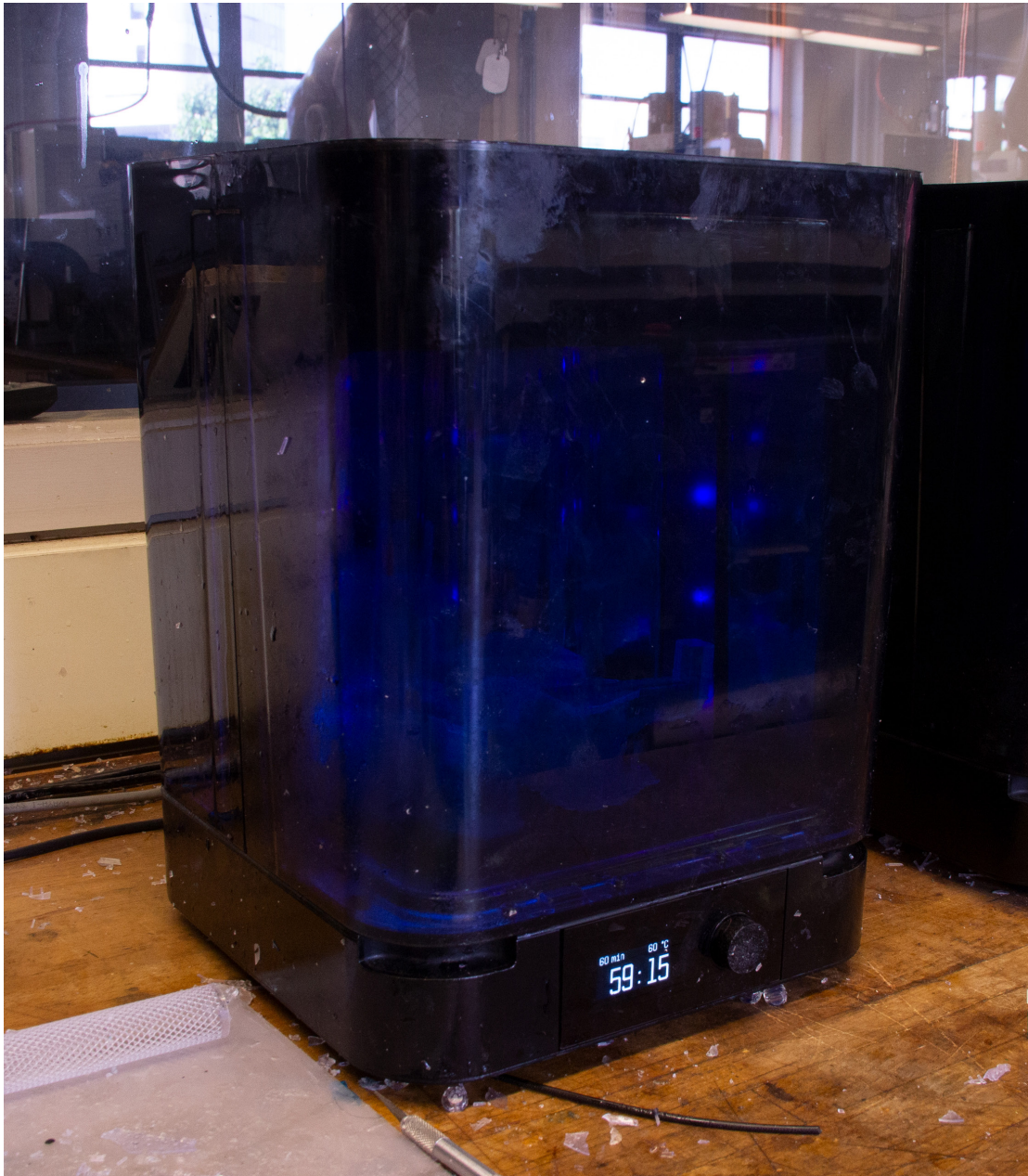
5. Load the build platform onto the fixture



6. Select START and press the selector dial



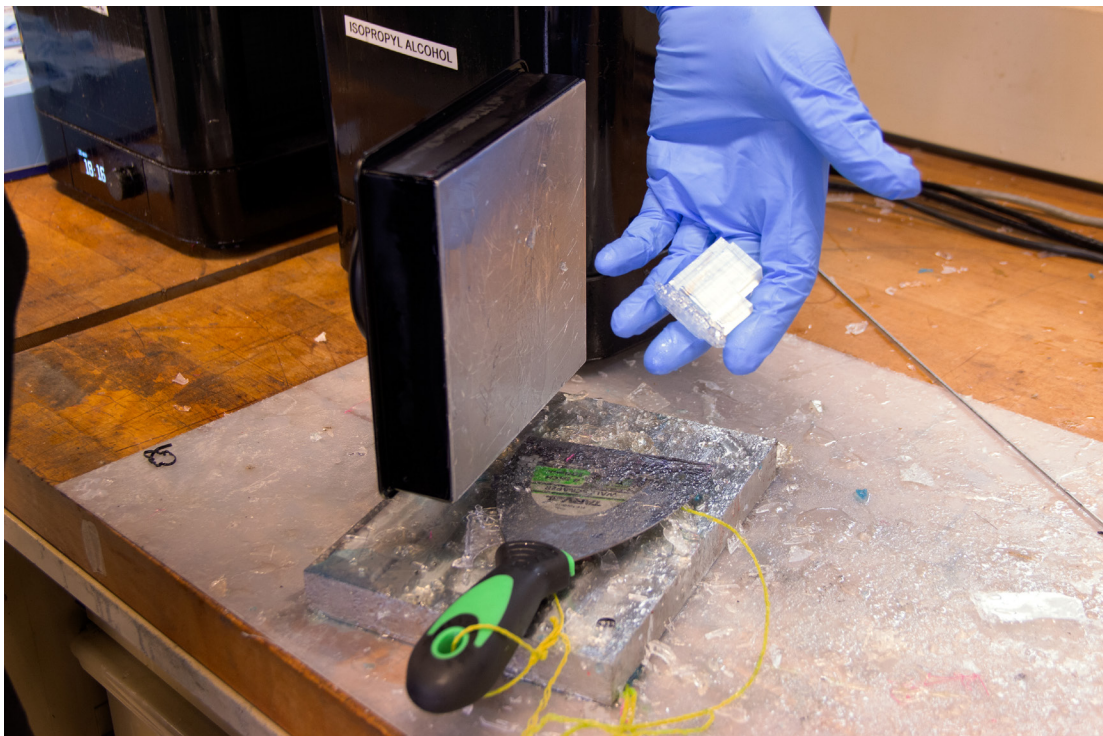
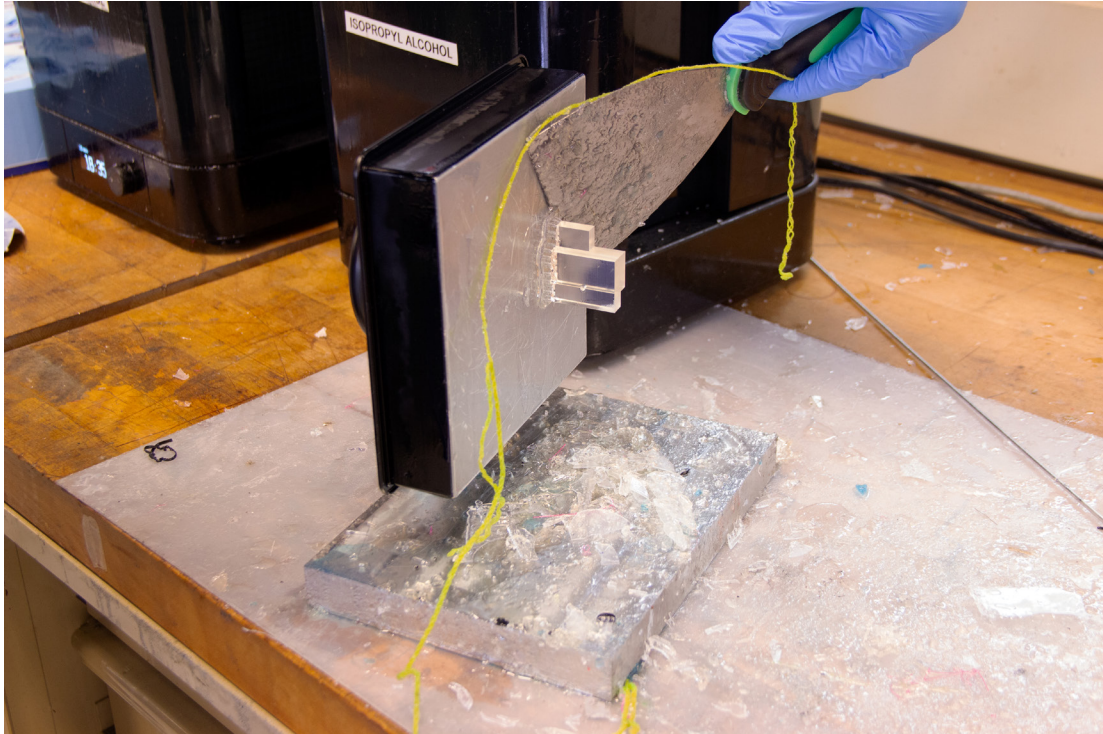
AFTER PRINTING (CURING)



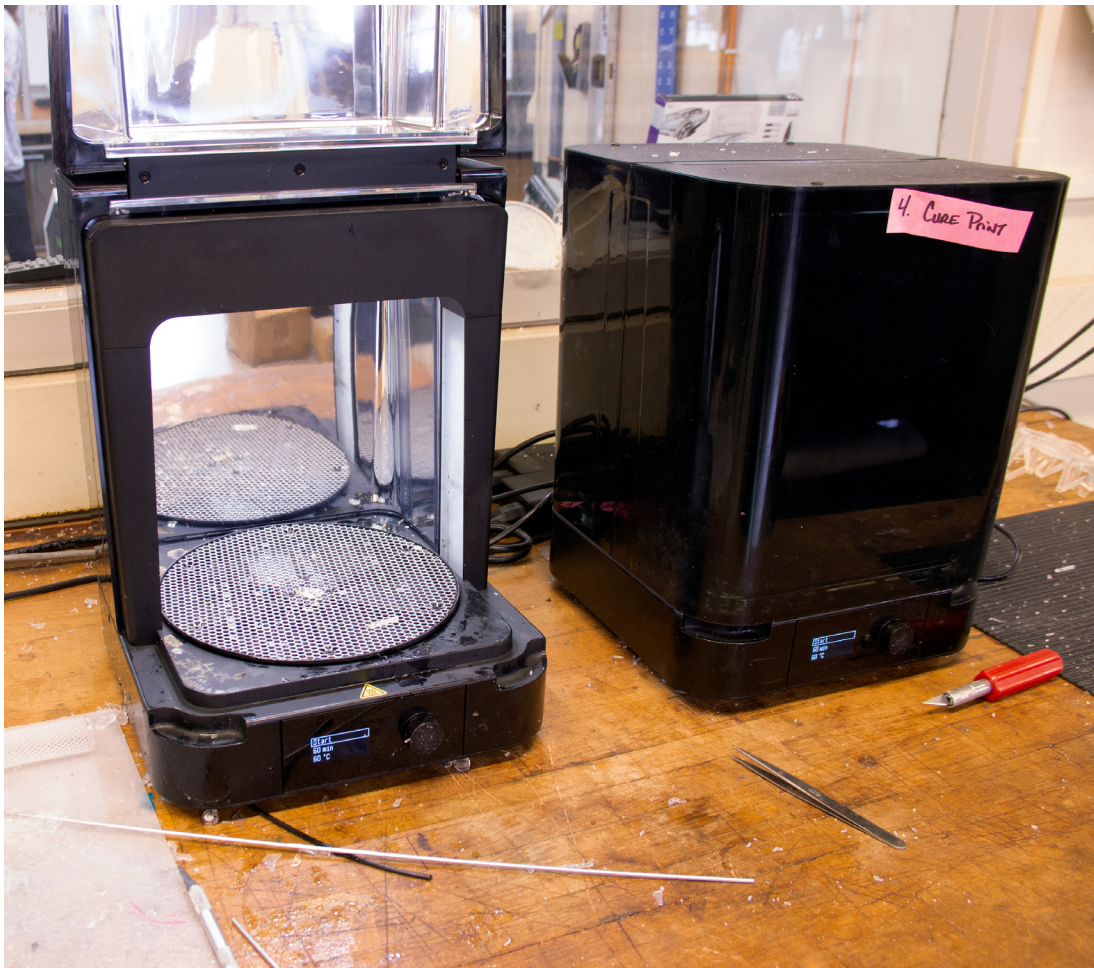
1. Secure the build platform into the jig next to the wash station



2. Remove the part from the build platform using the scrapper



3. Open the curing station and place your part on the bed



4. Close the door and use the selector dial to highlight START. Press the selector dial to begin curing

