Post-Curing with Form Cure

Post-curing helps 3D printed parts achieve optimal material properties. Follow these recommendations to configure Form Cure for Formlabs resins.

	Resin Type	Cure	Time (min)	Temperature (°C)
Standard Resins	**Clear Resin**	**Recommended** [1]	**15**	**60**
		Full Cure	**30**	**60**
	Black Resin White Resin Grey Resin	**Recommended** [1]	**30**	**60**
		Full Cure	**60**	**60**
	Color Resin	**Recommended** [1]	**30**	**60**
		Full Cure	**60**	**60**
Engineering Resins	**Tough Resin**	**Recommended** [1]	**60**	**60**
		Full Cure	**120**	**60**
	Durable Resin	**Full Cure** [2]	**60**	**60**
	Flexible Resin	**Recommended** [1]	**15**	**60**
		Full Cure	**60**	**60**
	High Temp Resin	**Recommended** [1]	**30**	**60**
		Full Cure	**60**	**60**
Dental Resins	**Dental SG Resin**	**Full Cure** [3]	**30**	**60**
	Dental LT Clear Resin	**Full Cure** [3]	**20**	**80**
	Dental Model Resin	**Recommended** [1]	**30**	**60**
		Full Cure	**60**	**60**
Jewelry Resins	**Castable Resin**	**Full Cure** [4]	**240**	**60**

1 The recommended post-cure settings achieve close-to-maximum mechanical performance and minimize the post-cure time. The full post-cure settings achieve the maximum mechanical properties and require significantly more time. Use full post-cure settings when using materials for functional applications.

2 For parts printed with Durable Resin, the tensile modulus continues to increase steadily throughout the first hour of post-curing. There is only one proposed post-curing setting.

3 This cure setting ensures that parts achieve both biocompatibility and optimum mechanical properties.

4 Cure for 4 hours to increase the part strength. After curing, follow the Recommended Burnout Guide. Increasing the cure time may improve casting results, particularly for thicker parts, though casting success depends more on the part geometry and casting process. Testing results show no disadvantages for increasing cure time.

These settings will be updated periodically. Always refer to formlabs.com/cure-support for the most updated information about post-curing printed parts with Form Cure.

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