



EZPRINT

User Manual for Model Resin

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1.1. Layout

1.1.1. Select Layout Software and Import Data

Double-click to open the “Aidite Dental” software, click “File – Import Model” in Figure 1, select the data to be imported. After successful import, the opened page is as shown in Figure 2.

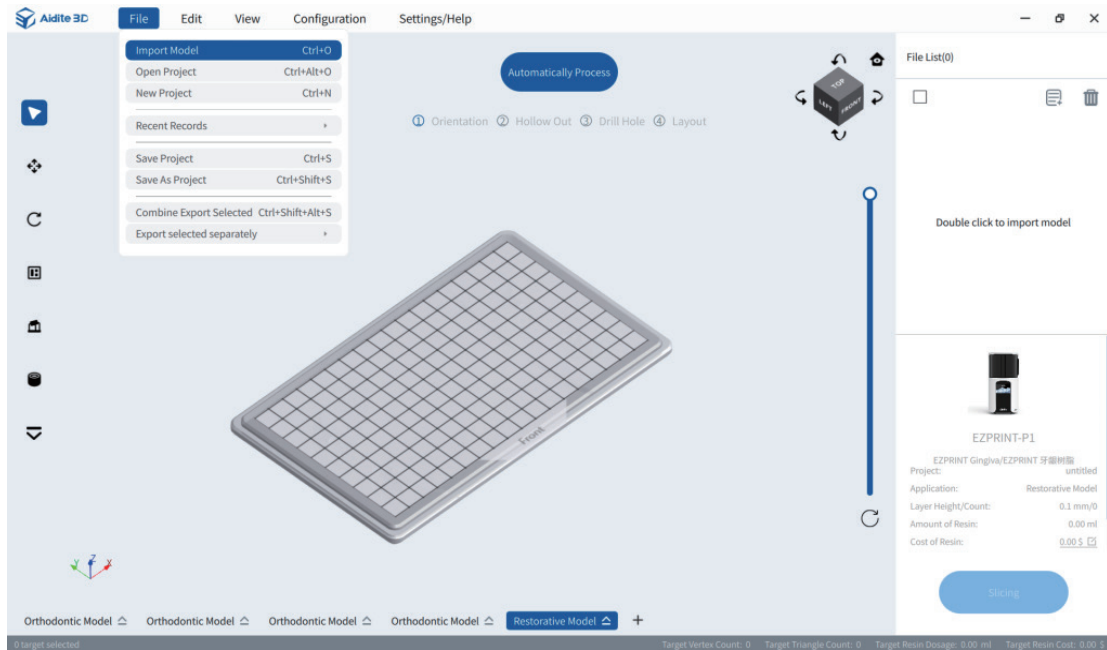


Figure 1

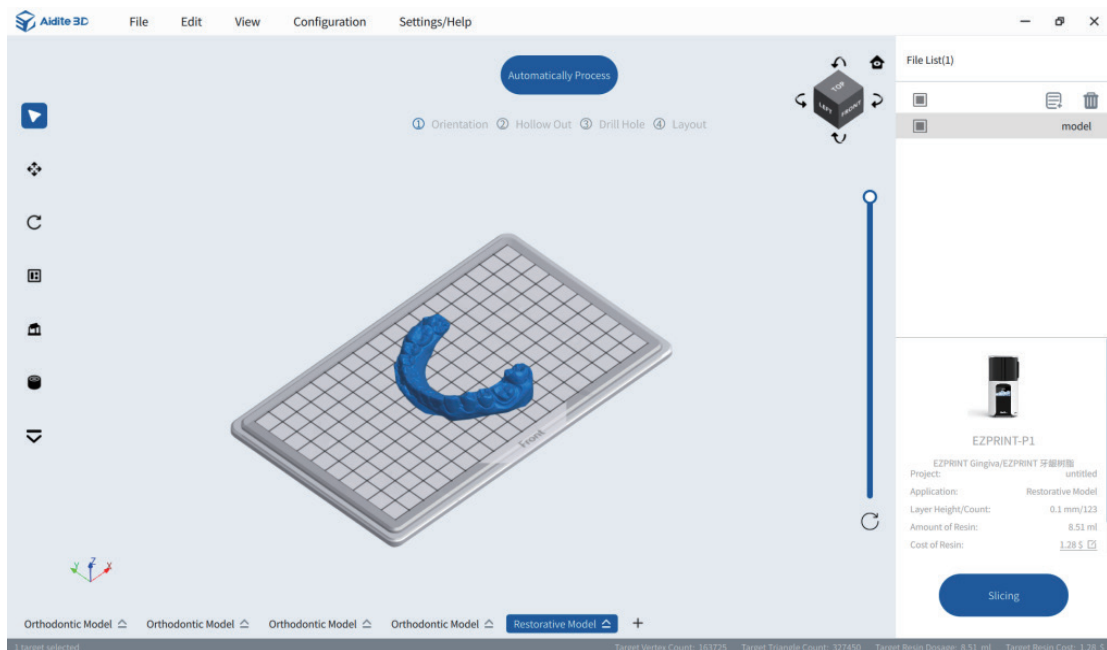


Figure 2

1.1.2. Select Layout Parameters

Click "Configuration - Edit current configuration", and a page for selecting the machine model and material will appear. Select the "EZPRINT-P1" printer, choose "Restorative Model" in the "Application" section. And then choose the right printing parameter in the "Material" section, select the application type of the model to be printed (Plug-in Type / Implant), and click "Apply". The following table shows the printing parameter names corresponding to each material:

Material	Printing Parameter Name
Almond Model Resin	EZPRINT Model (Almond) /EZPRINT 模型树脂 (杏仁色)
Yellow Model Resin	EZPRINT Model (Yellow) /EZPRINT 模型树脂 (黄色)
White Model Resin	EZPRINT Model (White) /EZPRINT 模型树脂 (白色)
Grey Model Resin	EZPRINT Model (Grey) /EZPRINT 模型树脂 (灰色)
Light Grey Model Resin	EZPRINT Model (Light-Grey) /EZPRINT 模型树脂 (浅灰色)

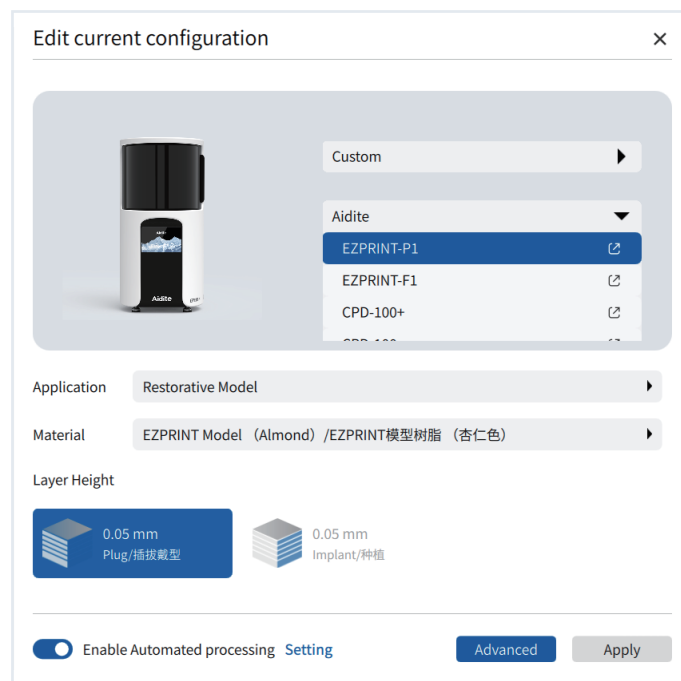


Figure 3

1.1.3. Model Placement

Adjust the view to the bottom, i.e., the perspective is "BOTTOM". After selecting the model, check whether the model is attached to the bottom. If it is blue, the model is in a suspended state. You need to click the "Rotation" button in the left toolbar and click "Flatten on Platform", then select the face where the model needs to be attached to the bottom. The bottom surface of the model after being attached to the bottom is green, as shown in Figure 6.

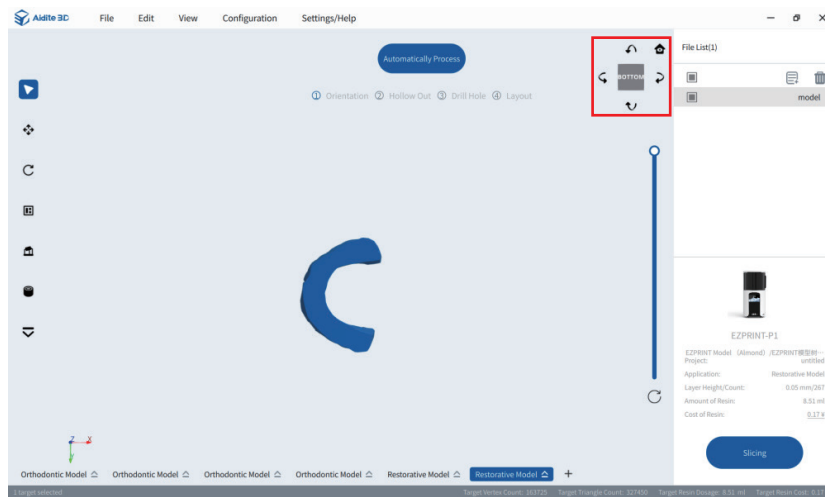


Figure 4

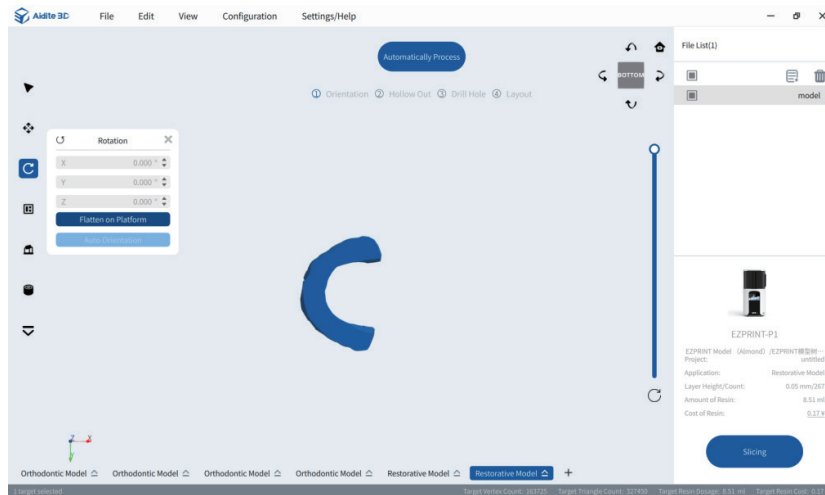


Figure 5

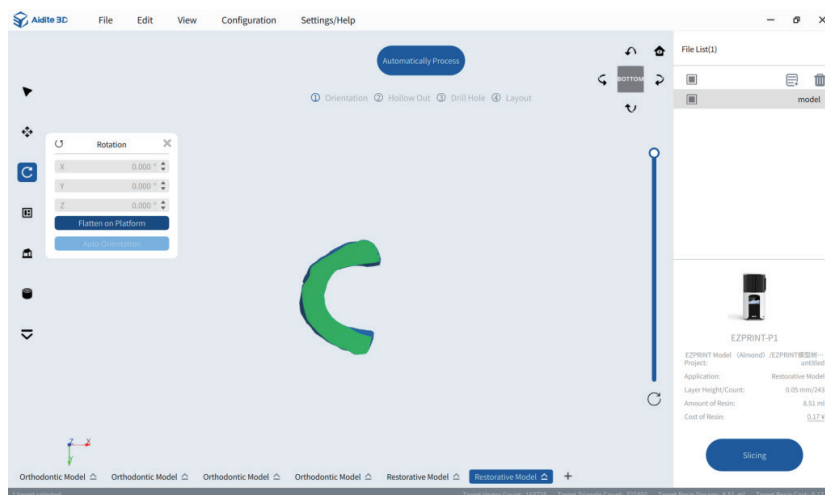


Figure 6

1.1.4. Hollowing (This Operation is Required for Solid Models)

- ① After selecting all restorations, in the function column on the left side of the slicing software, select the "Hollow Out" function card, set the corresponding hollowing parameters, and the parameters are as shown in Figure 7;
- ② Click the "Execution" tab to complete the hollowing of the model, as shown in Figure 8.

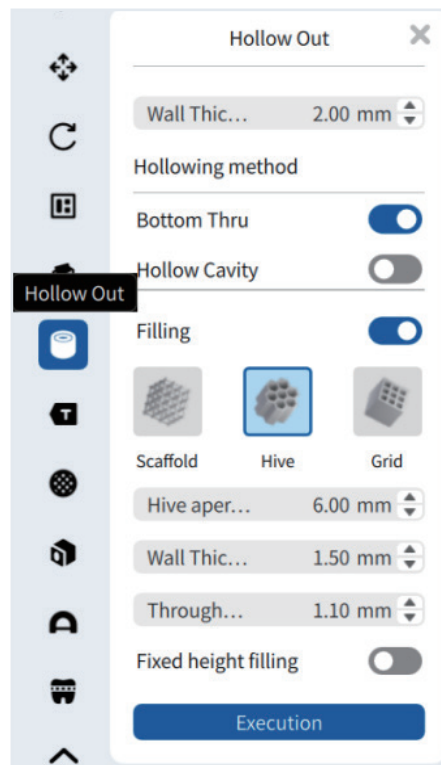


Figure 7

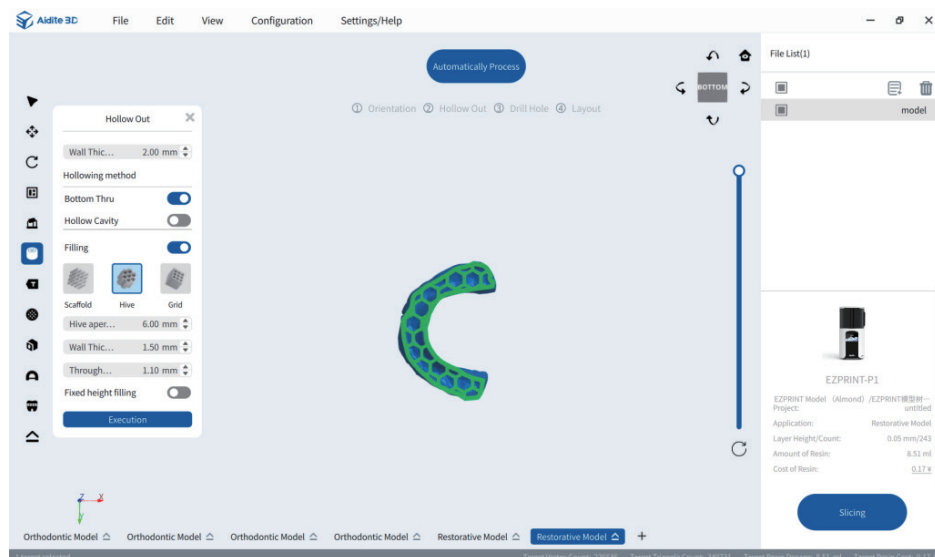


Figure 8

1.1.5. Drilling

After hollowing is completed, it is necessary to perform drilling operations on the model. This operation is to release residual resin and pressure, ensure uniform light exposure, facilitate post-processing, and ultimately ensure the molding quality, structural strength, and appearance integrity of the model.

- ① After selecting all restorations, in the function column on the left side of the slicing software, select the "Drill Hole" function card, set the hole size, quantity, and height. The parameters can refer to Figure 9 (can be defined by yourself);
- ② Click the "Auto Drill Holes" tab to complete the drilling of the model, as shown in Figure 10.

Notes: ① When setting the number of holes, select an appropriate number according to the size of the model;

② When setting the hole height, it is necessary to ensure that the hole height is less than the hole radius (i.e., half of the hole diameter).

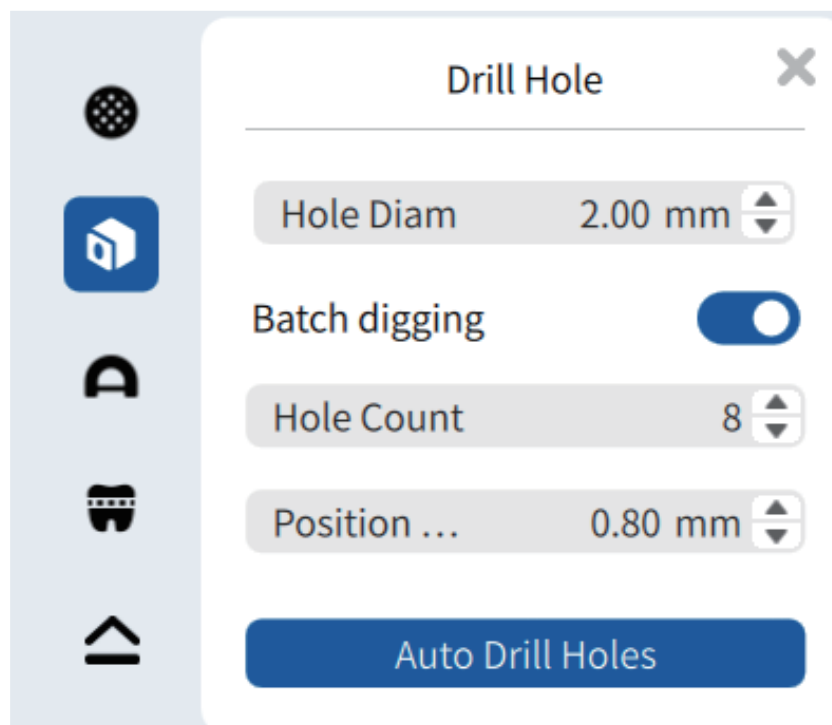


Figure 9

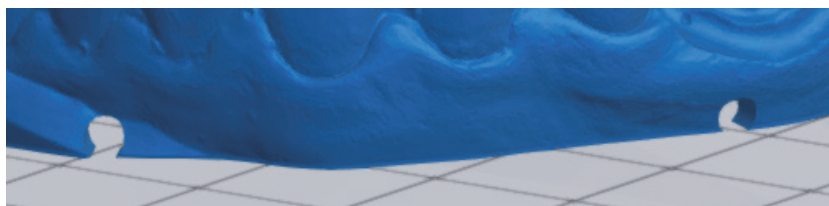


Figure 10

1.1.6. Auto Layout

The three steps 1.1.3–1.1.5 can be completed with one click by clicking "Auto Processing", which is the part in the red box in Figure 11.

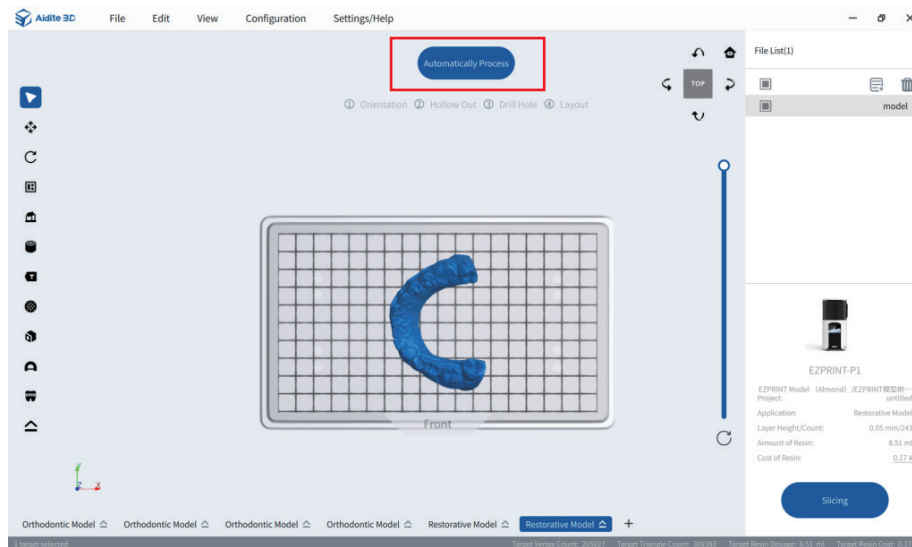


Figure 11

1.2.Slicing

After the support is added, click "Slicing" in Figure 12, and the page shown in Figure 13 will appear. Then click "Save Slice" or "Send to Printer". During the saving process, it will display that the file is being written, and after the saving is completed, it will show that the writing is successful.



Figure 12

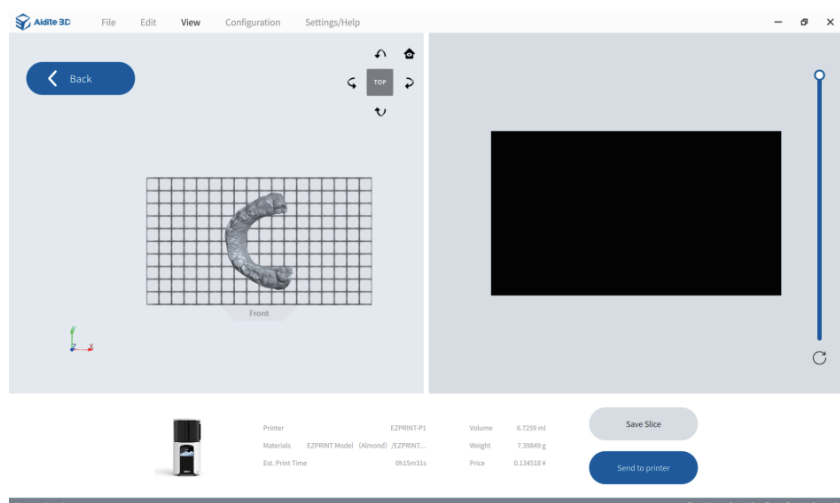


Figure 13

1.3.Printing

Send the sliced file (remotely or via USB) to the printer, click the file to be printed on the printer screen, and click Start Printing.

Notes: ① Operations must be carried out in a yellow light environment. There should be no vibrating equipment near the printer, and the desktop should be flat and not shaking.

② Before pouring the model resin liquid into the resin tank, shake it for about 1 minute, and the liquid level should be between the MIN line and the MAX line, as shown in Figure 14.

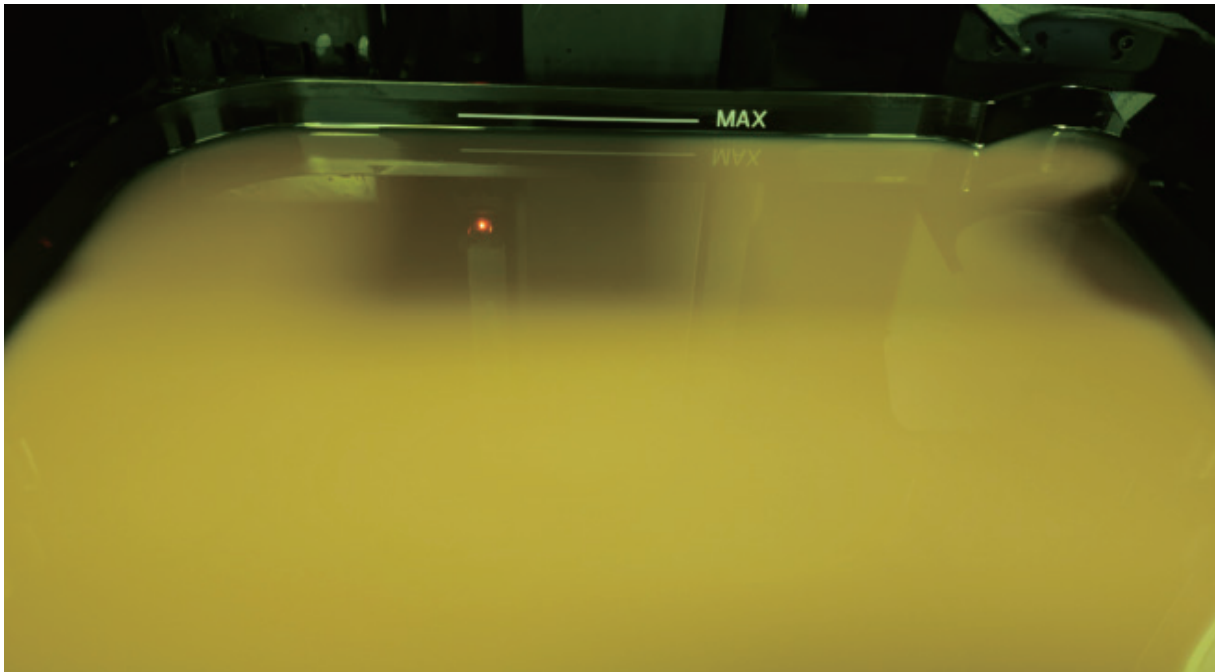


Figure 14

③ Before printing, check and confirm that the printing platform is clean, free of foreign objects, and installed reliably.

④ The lower left corner of the printer interface shows the temperature and humidity in the printer compartment. Click "Settings - Temperature Settings", turn off the temperature switch, click Save and return to the main page.

1.4.Removing Parts and Supports

After the printing job is completed, remove the build platform from the 3D printer. Use a silicone scraper to gently scrape off the uncured resin remaining on the printed model and the platform. Use a spatula to carefully remove the model from the build platform. The specific operation is to slide the spatula under the bottom of the printed part closest to the build plate and operate along the perimeter of the base until the printed part is removed.

1.5.Cleaning

Put the printed part into a beaker containing alcohol, and the height of the alcohol should be enough to cover the printed part. Note that the maximum time to stay in alcohol should not exceed 1 minute. Take out the printed part and place it in a non-heated cleaning machine for 3 minutes. The total time the printed part is in alcohol should not exceed 5 minutes. After taking out the printed part, use compressed air to blow dry the residual solvent on the surface of the printed part.

1.6.Post-Curing

Place the cleaned and dried printed part in the CL-100 post-curing light box or CL-200 post-curing light box, and select the corresponding curing program to start curing. The curing program names corresponding to each material are as follows:

Material	Curing Program Name
Almond Model Resin	Almond
Yellow Model Resin	Yellow
White Model Resin	White
Grey Model Resin	Grey
Light Grey Model Resin	Light-Grey

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