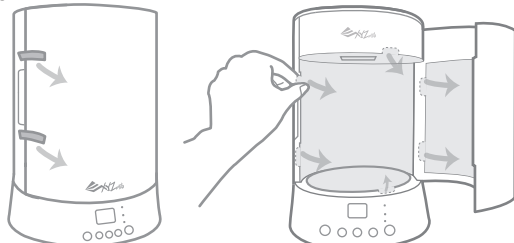# XYZprinting UV Curing Chamber User Manual

The UV Curing Chamber is a component of 3D printing solutions. The UV device outputs steady, focused and consistent UV lights to cure the printouts printed with photopolymer resins in a short period. The post curing process increases the hardness and durability of the printed products.

Unpacking

After removing all packing materials, open the cover door and peel off the transparent protection films from the reflective sheets.

*Please retain all original packaging material that came with the product. If warranty service is needed, please ship your product with the original packaging. Shipping without the original packaging material may cause product damage during the shipment and may result in additional service fees for which you shall be solely responsible.
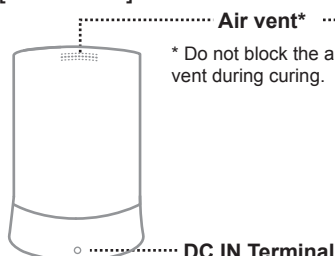
Package Contents

Power Adapter

Power Cord

UV Curing Chamber

Quick Guide (This sheet)
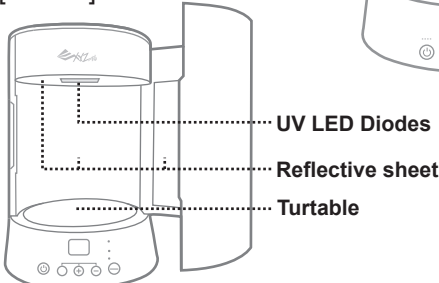
Warranty card

Components

[Back view]

Air vent*

* Do not block the air vent during curing.

DC IN Terminal

[Front view]
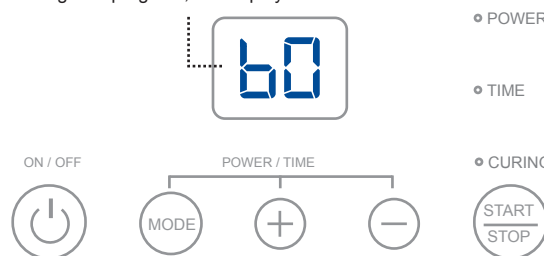
[Interior]

UV LED Diodes

Reflective sheet

Turtable

Operation panel
Display for power level, curing timer or turntable setup.
When curing is in progress, the display switches to a countdown timer.

b0

○ POWER

○ TIME

○ CURING

ON / OFF

POWER / TIME

MODE

START / STOP

Power button: click to power on the device, press and hold to power off.

Click to switch to power level, curing timer or turntable setup.

Increases / decreases power level, curing timer, or enables / disables the turntable.

Starts curing. Curing is stopped after this button is pressed during curing.

Safety / Operation Notices

▪ The glass cover over the UV LED diodes gets warm after curing. Please avoid touching the glass cover.
▪ Objects feel warm right after being cured. The heat from the UV unit does not affect the quality of the objects.
▪ The product is used to cured the objects printed with photopolymer resin. Please do not cure other items.
▪ Use only the power cord and the power adapter that come with this product. Use of another cord or power adapter may result in the malfunction of the product or cause injury to the user.
▪ The product is designed with safety in mind. Curing stops automatically when the cover door is opened. Please do not disassamble the product, or the safety protection may be impaired. This may cause injury to eyes caused by UV exposure. This will also void warranty.
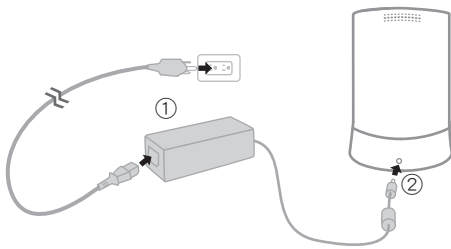▪ The device is intended to be used in office, not for home use.

LED Indicator

The LED lights indicate the status of the curing chamber. To switch setup item, press [MODE] button.

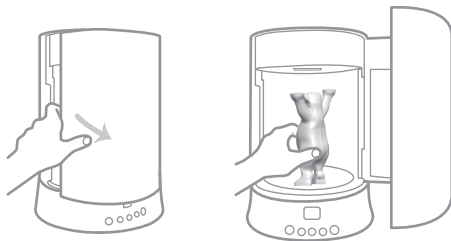|	
● POWER	Lit when switched to curing power level setup. To adjust power intensity, press [+] or [-]. Intensity 01 Intensity 02 Intensity 03
● TIME	Lit when switched to curing timer setup. Curing timer with range from 1 to 60 minutes. Adjust by 1 minute intervals, click [+] or [-]. Adjust by 5 minute intervals, press and hold [+] or [-].
● POWER + ● TIME	Both LED lit when in turntable setup mode. To setup the turntable, press [+] or [-]. Setting 00 - Turntable disabled (The setting allows you to cure in silence. If the object is too large to fit in the turntable, you may also disable the turntable.) Setting 01 - Turntable enabled (The setting provides better curing efficiency.)
● CURING	Lit when curing is in progress. The LED blinks when curing is paused (as happens when the cover door is opened).

How to UV Cure

- Connect the curing chamber to the power source.

①Insert the power cord into the power adapter and plug the other end into the power outlet.
②Connect the power adapter to the curing chamber's DC IN terminal at the back.

- Open the cover door, put the UV resin-printed object on the turntable, and close the door.
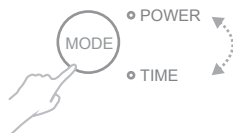

- Click on the [Power Button] to power on the device.

- Set up curing power intensity, timer and the turntable based on the features of the printed object.

①Click to switch setup mode.

②Click to adjust power level or curing time or enable/disable the turntable.

③Click to start curing.

Maintenance

- Ensure the cleanness of the relective sheets and the glass cover over the UV LED diodes.
  ▪ Use lint-free cloth dampened with alcohol to wipe any resin or alcohol off the components before it gets cured.

Product Specs

Model number	3UD10
Light source	UV LED λ 385 nm
Max. curing size	Ø180 x H200 mm
Turntable payload	1.5 kg
UV LED lamp power	16 Watt
Power supply	DC IN 24V 2.5A
Operating conditions	Temperature: 10-35℃/50-95℉
	Humidity: 40-80% RH (no condensation)

Curing Guidelines

- Ensure the cleanness of the resin-printed objects.
  ▪ Wash the printed objects thoroughly in alcohol.
  ▪ Leave the printed items until alcohol on the surface evaporates.

- To achieve highest curing efficiency:
  ▪ Put the object at the center of the turntable.
  ▪ Make sure that as much of the object as possible is facing the LED diodes at the top.
  ▪ For large object, you may tilt it on the curing stand.
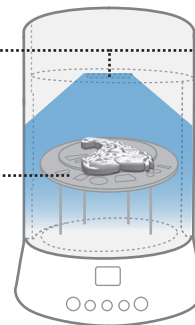 ▪ Lift small objects with the stand to close to the UV LED diodes.

Curing efficiency:

- UV LED diodes
- Curing stand*

Better   Fair

Note

*Curing stand is to be prepared by yourself.

You may use any object as the stand or download the 3D model from XYZprinting 3D gallery by going to http://us.gallery.xyzprinting.com/ and select "SLA Accessories" from the categories. Download the 3D models of the curing stand and print them out.

▪ Turn the object over periodly to get fully cured.
  Curing is paused when the cover door is opened. So you can adjust the placement of the object anytime. Simply close the cover door to resume curing.

- Recommended curing setup for XYZprinting resins:

XYZprinting Resin	Power Intensity	Cure Time
General purpose resins (Grey/Clear/White/Blue/Magenta)	03	10 minutes

*For the curing instrucions for XYZprinting functional resins, please refer to the product pages on XYZprinting website.

▪ Object printed with clear and white resin may begin yellowing after cured.
▪ Over-curing the resin prints will cause excessive yellowing.
▪ Be sure to rotate the object and start over the curing process to ensure the object is fully cured.

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